



# Forza™

**BOND** | A FORCE TO BE RECKONED WITH

## Marine M-R478



### Methacrylate Adhesive



ForzaBOND® M-R478 is a 2-part methacrylate adhesive designed to bond a wide range of substrates.

## Benefits

- Excellent bond strength
- Impact and weather resistant
- 1:1 ratio – easy mixing or dispensing
- Minimal surface preparation required
- Forms tough, high-strength, high-impact resistant bonds
- Resists most common industrial cleaners, fuels, lubricants, and environmental conditions
- Retains bond in strength in boiling water, salt water, salt fog, kerosene, gasoline, diesel fuel, antifreeze, hydraulic fluid, and cutting oils.

## Product Application

- When using cartridges, ensure flow from both sides of cartridge dispenser; attach static mixer and gun out material.
- After adhesive is mixed apply it to one surface to be bonded then mate the second surface.
- Surfaces should be clean and dry and in most cases no abrasion or solvent wipe is necessary.
- You have only 3-4 minutes to put parts together. Hold parts in position while curing (pressure clamping is not required).
- At room temperature handling strength is achieved at 7-10 minutes and in full cure in 2-3 hours.

## Applications

ForzaBOND® M-R478 bonds engineered thermoplastics, thermosets, composites, rubbers, and metals without the need for surface preparation, primers, or chemical wipes. Ideally suited for structural applications.

## Technical Data

Appearance:	White
Cure Properties:	5 mins in mixer nizzle, allow 30 mins to handle
Elongation:	40%
Full Cure:	2-3 hours
Handling Strength:	5-6 minutes
Sored Hardness:	70-75
Steel-Steel:	4,200 psi
Aluminum - Aluminum:	3,400 psi
Viscosity:	200,000 CPS

## Sizes

50ml Cartridge	5 Gallon
400ml Cartridge	52 Gallon Drum

CREATING INDUSTRIAL ADHESIVE, TAPE, AND SEALANT SOLUTIONS THAT OUTPERFORM

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