



# Forza™

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

## Marine

## M-R445

## Modified Epoxy



**ForzaBOND® M-R445** is a two-part modified epoxy adhesive with moderate cure and a wide range of applications.

### Benefits

- Semi-Flexible
- Generates no heat while curing
- No solvents or isocyanates
- 1:1 ratio, easy mixing/dispensing
- Minimal surface preparation required
- -75°F to 400°F service temp
- Retains flexible bond line, outperforms most "brittle" two part adhesives
- Light stable and UV resistant
- Paintable
- 0 VOC
- Generates no heat
- 100% solids no shrinking

### Product Application

- For cartridges: ensure flow from both sides of cartridge is possible, attach static mixer and gun out material.
- Apply mixed adhesive to one surface to be bonded then mate second surface.
- Surfaces should be clean and dry and in most cases no abrasion or solvent wipe is necessary.
- Note: The B side will stiffen at temperatures below 32°F/0°C. The material may have to be heated to return to usable viscosity.
- For bulk: Ensure flow from both drums and in both hoses. Attach static mixer and gun out adhesive as desired.
- Apply to one surface to be bonded, then mate the second surface.
- Surfaces should be clean and dry.
- Use abrasive or solvent wipe only if necessary.
- Clean up with mineral spirits/wet rag.

### Applications

**ForzaBOND® M-R445** is specifically designed to eliminate exothermic reaction issues common with composite materials. It bonds similar materials while generating no heat during curing, resulting in no gel coat "witness marks".

### Technical Data

Appearance:	Gray
Cure Time:	5 mins in mixer nozzle, allow 30 mins to handle
Elongation:	100%
Lap shear:	750 psi
Mixed Ratio:	1:1 by volume; 1:1.2 by weight
Solids:	100% reactive
Tensile Strength:	825 psi
Viscosity:	Mixed gray approximately 260,000cps
VOC:	< 1% w/w

### Sizes

400ml Cartridge	52 Gallon Drum
5 Gallon Pail	

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402.731.9300  
info@forzabuilt.com  
www.forzabuilt.com



3211 Nebraska Ave, Suite 300  
Council Bluffs, Iowa 51501