



ForzaTM

BOND | A FORCE TO BE RECKONED WITH

Industrial OA4



Performance Polymer



ForzaBOND® OA4 is a hybrid polymer, high strength, single part moisture cure adhesive.

Benefits

- Retains strong bond through impact, peel, flex, and changing temperatures
- Easy apply by extrusion, or trowel
- Non-yellowing when exposed to UV
- Does not form bubbles, shrink or crack
- Highly weather resistant
- Can be painted in most applications
- Low-temperature flexibility (properties retained to -75°F)
- High Strength with great green strength

Product Application

- Generally applied by extrusion, and trowel. Surfaces should be clean and free of dust, oil, and grease.
- Apply between 34° and 150°F, in damp or dry conditions. The majority of its strength is developed in the first 24 hours.
- Minimum cure time is overnight, but several days may be required for maximum performance, however cure time may be accelerated at higher temperatures (do not exceed 150°F for accelerated cure).
- Most parts do not require fixturing, although heavy parts may require temporary clamping to ensure desired positioning.

Bead Widths (inch) **Linear Yield (FT) / oz**

1/8	12.2 ft
1/4	3.05 ft
3/8	1.35 ft
1/2	9.2 in
5/8	5.88 in
3/5	4.08 in

Applications

ForzaBOND® OA4 is permanently flexible and creates a structural bond. It bonds a large variety of materials including:

- Aluminum
- Brass
- Steel
- Granite
- Wood
- Many Plastics
- General purpose bonding application on both interior and exterior applications

Technical Data

Skin Time:	Less than 30 min @ 77°F/55% RH
Tensile Strength:	475 PSI
Elongation at Break:	500-600%
Shore A Hardness:	42
Color:	White, Gray, Custom
Temperature Range:	-75°F - 400°F for limited amount of time
Shelf Life:	12 Months
Sag:	Non-Sagging
Staining:	Non-Staining

Packaging

20oz Sausage	10.1oz Cartridge
28oz Cartridge	52 Gallon Drum
	5 Gallon Pail

**Recommended Cleanup
While Wet**

Water
Alcohol

CREATING INDUSTRIAL ADHESIVE, TAPE, AND SEALANT SOLUTIONS THAT OUTPERFORM

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