



Forza™

BOND | A FORCE TO BE RECKONED WITH

Marine

M-OA755



Performance Polymer

ForzaBOND® M-OA755 is a structural, hybrid polymer, single part moisture cure adhesive.

Benefits

- High Strength
- Excellent Weather Resistance
- No solvents or isocyanates
- Retains strong bond through impact, peel, flex, and changing temperatures
- Non-yellowing when exposed to UV
- Does not form bubbles, shrink or crack upon curing
- Highly weather resistant
- Can be painted in most applications
- Low-temperature flexibility (properties retained to -75°F)

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® M-OA755 is specifically designed for permanent, flexible, and structural bonding in marine applications. It is formulated to bond a wide variety of materials, including aluminum, brass, steel, wood, plastics, and fiberglass composites without the need for fasteners.

Applications include:

- Bonding stiffeners in aluminum bass boats
- Reinforcing materials in fiberglass boats
- Bonding teak flooring and furniture
- General mounting applications exposed to weather and UV

Technical Data

Skin Time:	Less than 30 min @ 77°F/55% RH
Tack Free Time:	Less than 1 hour @ 77°F/55% RH
Tensile Strength:	475 PSI
Elongation at Break:	500-600%
Shore A Hardness:	42
Color:	White, Gray, Custom
Viscosity:	1.7M cps
Temperature Range:	-75°F - 400°F for limited amount of time
Shelf Life:	12 Months
Lap Shear Strength:	550 psi
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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