

Flex 310 M® Crystal MS-Polymer



crystal-clear curing

WEICON Flex 310 M Crystal adhesive and sealant is transparent, strong, overpaintable (wet in wet), sandable, has outstanding aging stability and good resistance to UV rays. It contains no silicone, isocyanate, halogens or solvents.

WEICON Flex 310 M Crystal has an ISEGA certificate and can be used as an adhesive in food technology.

The product is crystal clear after curing and is particularly suited for elastic joints where the adhesive should or must not be visible.

Flex 310 M Crystal can be used in plastic processing, metal construction, tank and apparatus engineering, in ventilation and air conditioning systems, the electrical and lighting industry, in exhibition stand construction and shopfitting and in all applications where silicones or products containing silicones are not suitable.

* = Only tension-free bonding



Technical Data

Composition	1 C.-Polyoxypropylene
density	1,06 g/cm ³
Viscosity adhesive	pasty
Stability/Run-off (ASTM D 222)	< 1 mm
Processing temperatur	+5 to +40 °C
Cure type	By humidity

Note

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Curing condition	+5 to +40°C and 30% to 95% rel. humidity
Skin-overtime*	10 min.
Cure speed (first 24h)	2 -3 mm
Volume change (DIN 52451)	-1 %
Gap filling up to max.	5 mm
Gap width up to max.	25 mm
Shelf life (+5°C to +25°C / +41°F to +77°F)	12 months
Shore A hardness (DIN 5355 / ASTM D 224) ± 5	40
Elongation at break (DIN 53504/ASTM D 2240) ± 5	300 %
Tensile strength of pure adhesive and sealant	3,0 N/mm ²
Average tensile shear strength (DIN 53283 / ASTM D 12)	2,0 N/mm ²
Tear strength (DIN 53515/ASTM D 1002)	19 N/mm ²
Movement capacity max.	20 %
Overpaintable (liquid paint)	only „wet in wet“, within 3 hrs. at the latest after material app
Building material category (DIN 412)	B 2
Specific forward resistance	1,2 x 10 ¹² Ohm/cm
Layer thickness	2,2 mm
Temperature resistance	-40 to +90 briefly (approx. 2 h) to +120 °C

*Measured at 50% relative air humidity and +23°C

Surface pre-treatment

The surfaces must be clean and grease-free. Many surface contaminants, e.g. oil, dust and dirt, can be removed with WEICON Surface Cleaner. For heavily soiled metal surfaces, we recommend WEICON Cleaner Spray S; WEICON Sealant and Adhesive Remover is suitable for removing old paint or adhesive residues. Most materials can be bonded well to themselves and among each other. For certain materials or extreme requirements, we recommend the use of an adhesion agent (primer). Detailed information on this subject is contained in the Primer selection table. A mechanical surface pretreatment, e.g. sanding or sand-blasting, can considerably improve the adhesion.

Processing

Application methods

Professional cartridge gun for 310 ml cartridges, compressed air gun (we recommend a variation with piston rod), automatic dosing systems.

Joining the parts to be bonded

To ensure optimal wetting, the parts must be joined before the first skin has been formed on the adhesive (skin-overtime).

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Technical Datasheet

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Storage

When unopened and stored in a normal climate (+23°C and 50 % rel. humidity), WEICON elastic one-component adhesives and sealants have a shelf life of 12 months.

Safety and health

When using WEICON products, the physical, safety technical, toxicological and ecological data and regulations in our EC safety data sheets (www.weicon.com) must be observed.

Available sizes:

13308310 Flex 310 M@ Crystal MS-Polymer 310 ml transparent

Accessories:

11202400	Sealant and Adhesive Remover, 400 ml
11207400	Surface Cleaner, 400 ml
11850200	Hand Protective Foam, 200 ml
13250000	Cartridge Cutter,
13250001	Cartridge Gun,
13250002	Cartridge Gun Special,
13250009	Compressed Air Cartridge Gun,
13550125	Primer M 100, 250 ml
13550225	Primer K 200, 250 ml
13550325	Primer S 300, 250 ml
13550425	Primer P 400, 250 ml
13559500	Smoothing Agent,
13955031	V-Joint Nozzle,

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