

# Speed-Flex® Crystal



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 <sup>2</sup>
Average tensile shear strength (DIN EN 1465/ ASTM D 12)	2,0 N/mm <sup>2</sup>
Specific resistance	0,9 x 10 <sup>12</sup> Ohm/cm
Tear strength (DIN 53515/ASTM D 1002)	19 N/mm <sup>2</sup>
Movement capacity max.	20 %
Overpaintable (liquid paint)	only „wet in wet“, within 3 hrs. at the latest
Building material category (DIN 412)	B 2
Specific forward resistance	0,9 x 10 <sup>12</sup> Ohm/cm
Temperature resistance	(-40°F) -40 to (+194°F) +90 briefly (approx. 2 h) to (+248°F) +120 °C

## crystal-clear adhesion

WEICON Speed-Flex Crystal replaces traditional fixings like screws, pegs, rivets etc. Due to the very high initial adhesion, bonding is possible even on vertical surfaces both in-house and outside.

Particularly suitable for optically demanding bondings when the adhesive bead is not to be visible. Thus e.g. transparent plastics, acrylic glass or other materials can be bonded rapidly, neatly and attractively among each other.

WEICON Speed-Flex Crystal can be used for drywall and interior work, metal construction, tank and apparatus engineering, in ventilation and air conditioning systems, in exhibition stand construction and shopfitting and in many other cases.

WEICON Speed-Flex Crystal is very strong, pasty, stable, resistant to ageing, weathering and UV rays and is free of silicone, isocyanate and halogen. ISEGA certificate for use in food technology.



## Technical Data

Base	1 C.-Polyoxypropylenere
density	1,06 g/cm <sup>3</sup>
Viscosity adhesive	pasty
Stability/Run-off (ASTM D 222)	< 1 mm
Processing temperature	(+41 °F) +5 to (+104°F) +40 °C
Cure type	By humidity
Curing condition	(+41°F) +5 to (+104°F) +40°C and 30% to 95% rel. humidity
Skin-overtime*	10 min.
Curing speed ( first 24h)	2 -3 mm
Volume change (DIN 52451)	-3 %
Gap filling up to max.	5 mm
Gap width up to max.	25 mm

### Note

The specifications and recommendations given in this technical data sheet must not be seen as guaranteed product characteristics. They are based on our laboratory tests and on practical experience. Since individual application conditions are beyond our knowledge, control and responsibility, this information is provided without any obligation. We do guarantee the continuously high quality of our products. However, own adequate laboratory and practical tests to find out if the product in question meets the requested properties are recommended. A claim cannot be derived from them. The user bears the only responsibility for non-appropriate or other than specified applications.

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

## Surface pre-treatment

The surfaces must be clean and free of grease. 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 pre-treatment, e.g. sanding or sand-blasting, can considerably improve the adhesion.

## Processing

Application methods:

Professional cartridge gun for 310 ml cartridges (WEICON Cartridge Gun "special"), compressed air gun we recommend a variation with piston rod (WEICON Cartridge Gun) , 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).

## Storage

When unopened and stored at room temperature (+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:

13608310-35 Speed-Flex® Crystal 310 ml

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**Accessories:**

13250000	Cartridge Cutter, 310 ml
13250001	Cartridge Gun Standard,
13250002	Cartridge Gun Special,
13250009	Compressed air cartridge gun,
13955031	V-Joint nozzle,

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