

## Flex 310 M® Crystal MS-Polymer

Specific forward resistance	1,2 x 10 <sup>12</sup> Ohm/cm
Temperature resistance	-40 to +90 briefly (approx. 2 h) to +120 °C

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

### 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

Base	1 C.-Polyoxypropylene
density	1,06 g/cm <sup>3</sup>
Viscosity adhesive	pasty
Stability/Run-off (ASTM D 222)	< 1 mm
Processing temperature	+5 to +40 °C
Cure type	By humidity
Curing condition	+5 to +40°C and 30% to 95% rel. humidity
Skin-overtime*	10 min.
Curing 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 <sup>2</sup>
Average tensile shear strength (DIN EN 1465/ ASTM D 12)	2,0 N/mm <sup>2</sup>
Specific resistance	1,2 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 after material app	
Building material category (DIN 412)	B 2

### 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.

### 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, 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).

### 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](http://www.weicon.com)) must be observed.

### Available sizes:

13308200	Flex 310 M® Crystal MS-Polymer 200 ml transparent
13308310	Flex 310 M® Crystal MS-Polymer 310 ml transparent

### Accessories:

13250000	Cartridge Cutter, 310 ml
13250001	Cartridge Gun,
13250002	Cartridge Gun Special,
13250009	Compressed Air Cartridge Gun,
13955031	V-Joint Nozzle,