

## Flex 310 M<sup>®</sup> HT 200 MS-Polymer

### High-temperature resistant

The high temperature resistance makes it possible to bond and seal components, which will be thermal-coated (powder-coated) afterwards. WEICON Flex 310 M HT 200 can be used in metal construction, tank and apparatus engineering, in ventilation and air conditioning systems, carriage, container, wagon and vehicle construction. WEICON Flex 310 M HT 200 Adhesive and Sealant is resistant even to high temperatures, has an outstanding resistance to ageing and is free of silicone, isocyanate, halogens and solvents.

#### Technical Data

|   |  |                       |
|---|--|-----------------------|
| Base                                    | 1-C. MS polymer                                      |                       |
| Colour                                  | grey   |                       |
| Paintable                               | only "wet into the wet"                              |                       |
| Cure type                               | moisture-curing                                      |                       |
| Stability/run-off                       | ASTM D 2202  | <1 mm                 |
| Density                                 | 1,41 g/cm <sup>3</sup>                               |                       |
| Curing condition                        | from +5 °C to +40°C and 30% to 95% rel. air humidity |                       |
| Processing temperature                  | +5 °C to +40 °C                                      |                       |
| Curing speed                            | in the first 24 h                                    | 2 - 3 mm              |
| Skin-over time                          | 10 min.  |                       |
| Tensile strength                        | DIN EN ISO 527 / 5A                                  | 3,2 N/mm <sup>2</sup> |
| Elongation at break (tensile)           | DIN EN ISO 527 / 5A                                  | 400 %                 |
| Shear strength according to DIN EN 1465 | Aluminium sandblasted 1,8 N/mm <sup>2</sup>          |                       |
| Tear resistance                         | DIN ISO 34   | 21 N/mm               |
| Volume change                           | DIN EN ISO 10563                                     | < 3 %                 |
| Hardness (Shore A)                      | DIN ISO 7619   | 55±5                  |
| Temperature resistance                  | -40°C to +90°C (45 min. +180°C / 30 min. +200°C)     |                       |
| Tg after curing at room temperature     | ~ -59 °C   |                       |
| Resistance                              | 3,4 x 10 <sup>11</sup> Ω·m                           |                       |
| Building material class                 | DIN 4102   | B 2                   |
| Shelf life                              | 12 mon.  |                       |
| <b>Approvals / Guidelines</b>           |  |                       |
| ISSA Code                               | 75.634.37  |                       |
| IMPA Code                               | 815278   |                       |
| Fire resistance                         | DIN EN 45545-2 R1/R7/R17 H L3                        |                       |

### Surface pre-treatment

Surfaces must be clean and free of grease. Many surface soiling, such as oil, grease, dust and dirt can be removed with WEICON Surface Cleaner. For heavily soiled metal surfaces, we recommend Cleaner Spray S; for removing old colour residues or adhesive residues, WEICON Sealant and Adhesive Remover is ideal. Most materials can be bonded to and among each other. For certain materials or special requirements, we recommend the use of a bonding agent (primer). Mechanical surface pre-treatment e.g. by grinding or sanding can also improve the adhesion considerably.

### Processing

#### Application methods

Cartridge gun for 310 ml cartridges, compressed air gun, we recommend a version with piston rod (WEICON Compressed Air Cartridge Gun), automatic dosing systems.

#### Joining the components

In order to guarantee an ideal wetting, the bonding parts need to be joined, before the adhesive skins over (skin-over time).

### Storage

When unopened and stored in normal climate (+23°C and 50 % rel. air humidity), WEICON Elastic Adhesives and Sealants have a shelf life of 12 months.

### Instructions for use

When using WEICON products, the physical, safety-related, toxicological and ecological data and regulations in our EC safety data sheets ([www.weicon.com](http://www.weicon.com)) must be observed.

### Accessories

|          |                                     |
|----------|-------------------------------------|
| 10025241 | V-Joint Nozzle, 1 PCE               |
| 10033114 | Compressed Air Cartridge Gun, 1 PCE |
| 10020751 | Cartridge Gun Special, 1 PCE        |
| 10000441 | Cartridge Gun, 1 PCE                |

### Available sizes

10031149 Flex 310 M<sup>®</sup> HT 200 MS-Polymer, 310 ml, grey

### Conversion table

|                               |                      |
|-------------------------------|----------------------|
| (°C x 1.8) + 32 = °F          | Nm x 8.851 = lb·in   |
| mm/25.4 = inch                | Nm x 0.738 = lb·ft   |
| µm/25.4 = mil                 | Nm x 141.62 = oz·in  |
| N x 0.225 = lb                | mPa·s = cP           |
| N/mm <sup>2</sup> x 145 = psi | N/cm x 0.571 = lb/in |
| MPa x 145 = psi               | kV/mm x 25.4 = V/mil |

#### 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.

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To the product detail  
page:



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