

WEICON TB Flex F



Flame-retardant | strong adhesion | trowelable

WEICON TB Flex F is a white, flame-retardant, trowelable 2-component adhesive. It is suitable for applications in the fire safety sector and is used to fix wear protection ceramics or steel parts to a wide variety of substrates, such as metal, concrete or similar. The adhesive system is very adhesive, hard-flexible after curing and has been modified to be impact-resistant. Even under the most extreme conditions, the adhesive does not become brittle. It shows good wear protection properties in particle erosion, has good chemical resistance and is free of solvents. TB Flex F contains additives that trigger self-extinction within a few seconds. It was examined in accordance with DIN EN ISO 340 at the DMT in Dortmund and successfully passed the test.

Characteristics

Base	epoxy
Filler	mineral
Texture	pasty
Colour	white
Shelf life	24 mon.

Processing

Processing temperature	+15 °C to +40 °C
Component temperature	> 3 °C above dew point
Relative air humidity	< 85 %
Mixing ratio by weight	100:67
Mixing ratio by volume	100:77
Viscosity of the mixture	at +25 °C 60.000 mPa·s
Density of the mixture	1,6 g/cm ³
Consumption	Layer thickness 1.0 mm 1,6 g/cm ²
Max. layer thickness	per step 20 mm

Curing

Pot life	at 20 °C, 500 g batch	30 min.
Additional layer after	(35 % strength)	5 h
Working strength after	(80 % strength)	8 h
Final strength	(100 % strength)	24 h
Shrinkage		0,31 %

Mechanical properties after curing

- Measured after curing at		24 h RT + 24 h 60 °C
Tensile strength	DIN EN ISO 527-2	32 MPa
Elongation at break (tensile)	DIN EN ISO 527-2	5,0 %
E-modulus (tensile)	DIN EN ISO 527-2	2400-2600 MPa
Compressive strength	DIN EN ISO 604	110 MPa
Bending strength	DIN EN ISO 178	52 MPa
Hardness (Shore D)	DIN ISO 7619	78 ±3
Adhesive strength	DIN EN ISO 4624	21.7 MPa
Taber Test	DIN ISO 9352 (H18, 1 kg, 1000 rotations)	0,3 g / 0,2 cm ³
Lap shear strength material thickn. 1,5mm DIN EN 1465		
Steel 1.0338 sandblasted		22 MPa
Stainless steel V2A sandblasted		26 MPa
Aluminium sandblasted		14 MPa
Galvanized steel		7 MPa

Thermal parameters

Temperature resistance		-35 °C to +120 °C
Tg after curing at room temperature	(DSC)	50 °C
Tg after tempering (at 120°C)	(DSC)	90 °C
Heat deflection resistance	DIN EN ISO 75-2	79 °C
Thermal conductivity	DIN EN ISO 22007-4	0.579 W/m·K
Heat capacity	DIN EN ISO 22007-4	1.399 J/(g·K)

Electrical parameters

Resistance	DIN EN 62631-3-1	8,85 · 10 ¹⁰ Ω·m
Magnetic		no

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) must be observed.

Surface pre-treatment

The successful application of WEICON TB Flex F depends on the thorough preparation of the surfaces. This is the most important factor for overall success. Dust, dirt, oil, grease, rust and moisture or wetness have a negative impact on the adhesion. Therefore, before processing WEICON TB Flex F, the following points must be observed: The areas to be bonded or repaired must be free of any oil, grease, dirt, rust, oxides, paint and other impurities or residues. For cleaning and degreasing, we recommend WEICON Cleaner Spray S.

Smooth and particularly heavily soiled surfaces should additionally be treated by mechanical surface pre-treatment, e.g. by grinding or preferably by blasting. In case of blasting, the surface should be brought to a degree of purity of SA 2 1/2 – "Near White Blast Cleaning" (according to ISO 8501/1-2, NACE, SSPC, SIS). In order to achieve an optimum surface

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roughness of 75 - 100 µm, angular, disposable blasting media (aluminum oxide, corundum) should be used. The surface quality is negatively influenced by the use of reusable blasting media (slag, glass, quartz), but also by ice blasting. The air for blasting must be dry and oil-free. Metal parts that have come into contact with sea water or other salt solutions should first be rinsed thoroughly with demineralised water and, if possible, left to rest overnight so that all salts can be dissolved from the metal. Before each application of WEICON TB Flex S, a test on soluble salts should be carried out according to the Bresle method (DIN EN ISO 8502-6).

Mixing

First, stir the resin. Then mix the resin and hardener together thoroughly and bubble-free for at least four minutes at 20°C (68°F). The included processing spatula or a mechanical mixer, such as a mortar stirrer, can be used for this purpose. With mechanical mixers, a low speed of max. 500 rpm should be used. The components should be stirred until a homogeneous mixture is achieved. The mixing ratio of the two components must be strictly observed, as otherwise, strongly deviating physical values will result (max. deviation +/- 2 %). Only prepare a batch as large as can be processed within the pot life. The specified pot life refers to a material batch of 500 g and 20°C (68°F) material temperature. Mixing larger quantities or higher processing temperatures will result in faster curing due to the typical reaction heat of epoxy resins.



Application

For processing, we recommend an ambient temperature of 20°C (68°F) at less than 85% relative humidity. The highest adhesive strength is achieved when the parts to be processed are heated to >35°C (>95°F) before application. For a thin pre-coat, work WEICON TB intensively into the surface in crosswise layers using the Contour Spatula Flexy, in order to achieve maximum adhesion. By means of this technique, the epoxy resin penetrates well into all cracks and roughness

depths. Afterwards, further applications can be carried out straight away, until the desired layer thickness is reached. Make sure that the epoxy resin is applied evenly and without air bubbles. To fill large gaps or holes, fibreglass, expanded metal or other mechanical fixing materials should be used. Finally, the surface can be smoothed easily with the help of a PE film and a rubber roller.

Curing

Final hardness is reached after 48 hours at 20°C (68°F) at the latest. At lower temperatures, the curing can be accelerated by evenly applying heat up to max. 40°C (104°F), e.g. with a heating pack, hot air blower or fan heater. Higher temperatures shorten the curing time. The following rule of thumb applies: Each increase by +10°C (50°F) above room temperature (20°C/68°F) will decrease the curing time by half. Temperatures below 16°C (61°F) increase the curing time, until at approx. 5°C (41°F) and below, almost no reaction will take place at all.

Storage

WEICON TB Flex F should be stored in a dry place at room temperature. Unopened containers can be stored at temperatures of +18°C to +28°C for at least 24 months after delivery date. Opened containers must be used up within 6 months.

Scope of delivery

Processing Spatula | Contour Spatula Flexy | Instructions for Use | Gloves | Resin & Hardener

Conversion table

$(^{\circ}\text{C} \times 1.8) + 32 = ^{\circ}\text{F}$	$\text{Nm} \times 8.851 = \text{lb}\cdot\text{in}$
$\text{mm}/25.4 = \text{inch}$	$\text{Nm} \times 0.738 = \text{lb}\cdot\text{ft}$
$\mu\text{m}/25.4 = \text{mil}$	$\text{Nm} \times 141.62 = \text{oz}\cdot\text{in}$
$\text{N} \times 0.225 = \text{lb}$	$\text{mPa}\cdot\text{s} = \text{cP}$
$\text{N}/\text{mm}^2 \times 145 = \text{psi}$	$\text{N}/\text{cm} \times 0.571 = \text{lb}/\text{in}$
$\text{MPa} \times 145 = \text{psi}$	$\text{kV}/\text{mm} \times 25.4 = \text{V}/\text{mil}$

Available sizes

17000002	WEICON TB Flex F, 200 g, white
17000005	WEICON TB Flex F, 0,5 kg, white
17000010	WEICON TB Flex F, 1 kg, white

To the product detail page:



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Chemical resistance of WEICON Plastic Metals after curing* (Excerpt)

Exhaust fumes	+	Potassium carbonate	+
Acetone	o	Potassium hydroxide 0-20 % (caustic potash)	+
Ethyl ether	+	Milk of lime	+
Ethyl alcohol	o	Carbolic acid	-
Ethylbenzene	-	Creosote oil	-
Alkalis (alkaline substances)	+	Cresylic acid	-
Hydrocarbons, aliphatic (petroleum derivatives)	+	Magnesium hydroxide	+
Formic acid >10 % (methanoic acid)	-	Maleic acid (cis-ethylenedicarboxylic acid)	+
Ammonia anhydrous 25%	+	Methanol (methyl alcohol) <85 %	-
Amyl acetate	+	Mineral oil	+
Amyl alcohol	+	Naphthalene	-
Hydrocarbons, aromatic (benzene, toluene, xylene)	+	Naphthene	-
Barium hydroxide	+	Sodium carbonate (soda)	+
Petrol (92-100 octane)	+	Sodium bicarbonate (sodium hydrogen carbonate)	+
Hydrobromic acid <10 %	+	Sodium chloride (table salt)	+
Butyl acetate	+	Sodium hydroxide >20 % (caustic soda)	o
Butyl alcohol	+	Caustic soda	+
Calcium hydroxide (slaked lime)	+	Heating oil, diesel	+
Chloroacetic acid	-	Oxalic acid <25 % (ethanedioic acid)	+
Chloroform (trichlormethane)	o	Perchloraethylene	o
Chlorosulphuric acid (wet and dry)	-	Kerosene	+
Chlorinated water (swimming pool concentration)	+	Oils, vegetable and animal	+
Hydrochloric acid	+	Phosphoric acid <5%	+
Chromium bath	+	Phthalic acid, phthalic anhydride	+
Chromic acid	+	Crude oil	+
Diesel fuels	+	Nitric acid <5%	o
Mineral oil and mineral oil products	+	Hydrochloric acid <10 %	+
Acetic acid diluted <5%	+	Sulphur dioxide (wet and dry)	+
Ethanol <85 % (ethyl alcohol)	+	Carbon disulphide	+
Greases, oils and waxes	+	Sulphuric acid <5%	o
Hydrofluoric acid diluted	o	White spirit	+
Tannic acid diluted <7%	+	Carbon tetrachloride (tetrachloromethane)	+
Glycerin (trihydroxipropane)	+	Tetralin (tetrahydronaphthalene)	o
Glycol	o	Toluene	-
Humic acid	+	Hydrogen peroxide <30 % (hydrogen superoxide)	+
Impregnating oils	+	Trichloraethylene	o
Potash	+	Xylene	-

+ = resistant 0 = for a limited time - = not resistant *The storage of all WEICON Plastic Metal types was carried out at +20°C chemical temperature.

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