

Flex 310 M[®] Classic



Suitable for universal use | ISEGA-certified

WEICON Flex 310 M Classic is strong, paintable (wet-on-wet), sandable, has an outstanding resistance to ageing and good resistance to UV rays. It is resistant to fresh and salt water and is free of silicone, isocyanate, halogens and solvents. The product as an ISEGA certificate and can be used as an adhesive in the food technology. Flex 310 M Classic is an elastic adhesive based on MS polymer and is suitable for the bonding of metals, many plastics, ceramics, wood, glass and stone. This adhesive and sealant can be used in metal construction, tank and apparatus engineering, carriage, vehicle and container construction, ventilation and air conditioning systems, in the electrical industry, yacht and boat construction, and in all applications where silicones or products containing silicones are not suitable.

Characteristics

Base	1C MS-polymer	
Texture	pasty	
Cure type	moisture-curing	
Can be painted	only "wet into the wet" within 3 h at the latest	
Stability/run-off	ASTM D 2202	1.0 mm
Building material class	DIN 4102	B 2
Minimum shelf life	at room temperature	12 mon.

Processing

Curing condition	from +5°C to +40°C and 30% to 95% rel. air humidity	
Curing speed	in the first 24 h	2 - 3 mm
Density	1,44 g/cm ³	
Max. sealing joint width	25 mm	
Gap bridging up to max.	5 mm	

Note

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Curing

Skin-over time	25 min.
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Mechanical properties after curing

Tensile strength	ISO 37	3,3 N/mm ²
Elongation at break (tensile)	DIN 53504/ASTM D412	650 %
Tear resistance	DIN 53515 / ASTM D 1002	20 kN/m
Hardness (Shore A)	DIN ISO 7619	42±5
Shear strength according to DIN EN 1465		
Medium lap shear strength (DIN EN 1465/ ASTM D 1002)		2,1 N/mm ²
Volume change	DIN 52451	-1 %

Thermal parameters

Temperature resistance	-40 °C to +90 °C, briefly up to +130 °C
Tg after curing at room temperature	~ -55 °C

Electrical parameters

Resistance	2.3 mm layer thickness	1,0 x 10 ¹⁰ Ω·m
Specific resistance		> 10 ¹⁰ Ω·cm
Tracking resistance	DIN EN 60112	CTI 800
Dielectric strength	DIN EN 60243-1 (20°C)	13,07 kV/mm

Approvals / Guidelines

ISSA Code	75.634.30/31/32
IMPA Code	815271/72/73

Surface Pre-Treatment

Surfaces must be clean and free of grease. Many surface soilings, 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.

Application

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

Ageing

The test specimens were artificially aged according to DIN ISO 21194, Annex A, to assess their long-term durability.

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After artificial ageing, Flex 310 M Classic with Primer K 200 or Activating Cleaner achieved grade 1 in the bead peel test on aluminium.

Grade 1 means: more than 95% cohesive failure and less than 5% adhesive failure in the form of the adhesive peeling off the contact surface.

After artificial ageing, Flex 310 M Classic with Primer K 200 or Activating Cleaner achieved grade 2 in the bead peel test on stainless steel (V2A).

Grade 2 means: 75 % to 95 % cohesive failure.

Storage

Store in the unopened original container at room temperature. Avoid sources of heat and direct sunlight.

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.

Accessories

- 10025241 V-Joint Nozzle, 1 PCE
- 10059792 Pressure gun Airflow 3, 1 PCE
- 10020751 Cartridge Gun Special, 1 PCE
- 10000441 Cartridge Gun, 1 PCE
- 10101992 Clip Nozzle Green Tube, 1 PCE, transparent

Available sizes

- 10057245 Flex 310 M[®] Classic, 200 ml, black
- 10057238 Flex 310 M[®] Classic, 200 ml, white
- 10057240 Flex 310 M[®] Classic, 200 ml, grey
- 10104011 Flex 310 M[®] Classic, 280 ml (Green Tube), white
- 10104007 Flex 310 M[®] Classic, 280 ml (Green Tube), grey
- 10103997 Flex 310 M[®] Classic, 280 ml (Green Tube), black
- 10104049 Flex 310 M[®] Classic, 280 Set, white
- 10104053 Flex 310 M[®] Classic, 280 Set, grey
- 10104051 Flex 310 M[®] Classic, 280 Set, black
- 10104240 Flex 310 M[®] Classic, 280 ml (plastic bag), white
- 10104244 Flex 310 M[®] Classic, 280 ml (plastic bag), black
- 10104242 Flex 310 M[®] Classic, 280 ml (plastic bag), grey

To the product detail page:



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