

WEICON Flex 310 M®

**elastic, strong, sandable, overpaintable,
free of isocyanate and solvents**

Under the brand WEICON Flex 310 M, a variety of high-quality adhesives and sealants is available. WEICON Flex 310 M are one-component products on an MS polymer basis. They are used for permanently elastic bonding and sealing of different materials to themselves or among each other.

Typical applications are in the fields of • metalworking, tank and apparatus construction • car body, vehicle, and freight container construction • ventilation and air conditioning • electrical industry • yacht and ship building – and in many areas of plastic technology.

WEICON Flex 310 M® **Classic**

(previously Flex 310 M)

For versatile use. Very good adhesion without primer on aluminium, stainless steel and many other surfaces. Immediately overpaintable (wet-in-wet). Excellent aging and UV stability. Sandable after curing.

WEICON Flex 310 M® **Crystal**

(previously Flex 290 M)



Crystal-clear after curing. Excellent adhesion on glass, PC**, PMMA** and acrylic glass. Therefore, especially suitable for elastic joints where the adhesive shall not or must not be visible.

** = only for tension-free bonding.

WEICON Flex 310 M® **Super-Tack** **NEW**

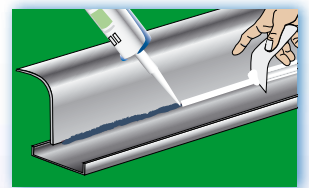
Very high initial strength. For metals, plastics and many other materials. In particular suitable for bonding on vertical surfaces, indoor and outdoor. Replaces screws, pegs, rivets, and other traditional fixings.

WEICON Flex 310 M® **HT 200**

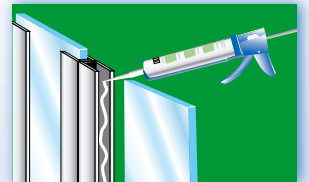
NEW

High temperature resistant. Very good adhesion on metal and most plastics. Allows bonding and sealing of parts before thermal coating (e.g. powder coating).

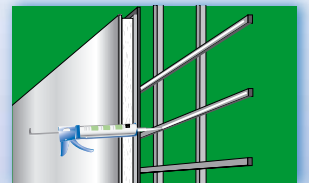
Classic



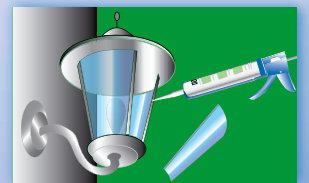
Crystal



Super-Tack



HT 200



High elasticity, excellent adhesion on different materials and a good paintability*4 – these characteristics offer a variety of applications in industry.

In addition, all types of WEICON Flex 310 M are neutral-curing, free of solvents and isocyanates as well as of substances that disturb lacquer wettings, e. g. silicone.



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Distributed by:

WEICON Flex 310 M in non-cured condition

Technical data	Classic	Crystal	Super-Tack	HT 200
Basic properties	<ul style="list-style-type: none"> • for versatile use • high elongation to break • longer skin-over-time 	<ul style="list-style-type: none"> • improved formulation • shorter tack-free time • faster curing • crystal-clear • improved UV stability • less colour change with aging 	<ul style="list-style-type: none"> • high initial strength • fast build-up of power • easy processing, even with small bonding lines • high elongation to break 	<ul style="list-style-type: none"> • high temperature resistance: 30 min. +200°C • longer skin-over/positioning time: 20 min. • very stable paste
Contents	310 ml cartridge	290 ml cartridge	290 ml cartridge	290 ml cartridge
Density g/cm ³ (DIN 53504)	1,44	1,04	1,62	1,44
Chemical basis	one-component MS Polymer			
Processing temperature	+5°C (-41°F) up to +35°C (+95°F)*1			
Cure type	by humidity			
Skin-over time*2 (min.)	25	10	10	20
Cure speed*2 in mm/first 24 hours in mm	2 – 3	2 – 3	2 – 3	3 – 4
Gap filling up to max. mm	5	5	10	10
Gap width up to max. mm	25	5	30	30
Shelf life (+5°C to +25°C)	12	12	12	12

WEICON Flex 310 M® in cured condition

Shore-A-Hardness (DIN 53505 / ASTM D 2240) +/- 5	42	38	50	60
Elongation to break % (DIN 53504 / ASTM D 412)	650	250	600	350
Tensile shear strength of the pure adhesive/sealant (DIN 53504 / ASTM D 412)	3,3 N/mm ²	2,0 N/mm ²	1,9 N/mm ²	2,7 N/mm ²
Average tensile shear strength*3 (DIN 53283 / ASTM D 1002)	2,1 N/mm ²	0,9 N/mm ²	1,5 N/mm ²	1,7 N/mm ²
Movement capacity max. %	15	20	20	20
Temperature resistance	-40°C (-40°F) to +90°C (+194°F)*2			-40°C (-40°F) up to +90°C (+194°F) briefly (30 min.) up to +200°C (+392°F)
Overpaintable*4	only wet in wet until max. 4 minutes after skin formation			
Building material category (DIN 4102)	B 2			
Possible Primer	table of primers at www.weicon.de			

*1 If used at low temperatures, cartridges or tubes should be warmed up to room temperature (20°C) for easier processing

*2 Standard climate: +23°C and 50% relative air humidity according to DIN 50014

*3 Material combination: Alu/Alu, cleaned and degreased with Cleaner S, layer thickness 1mm, tear speed 10 mm per minute.

*4 Above listed WEICON one-component adhesives and sealants are free of substances that disturb lacquer wettings, like e.g. silicone. Due to their special formulation, they can be overpainted with suitable paint coating systems (except alkyd resin varnishes). In order to check the suitability, however, tests under praxis conditions must always be carried out. This is necessary because of the different composition and the variety of paint coating systems. The cure speed of the adhesives and sealants is only slightly reduced by a paint coating.