

# Flex+bond®



## elastic strong adhesion

WEICON Flex+bond is strong, permanently elastic, temperature resistant from -40°C to +90°C (-40°F to +194°F), weather resistant, resistant to UV rays, overpaintable (wet in wet), sandable, and resistant to ageing and salt water. It is free of silicone, isocyanate, halogens and solvents. WEICON Flex+bond has an ISEGA certificate and can be used as an adhesive in foodstuff technology.

WEICON Flex+bond can be used to bond nearly all materials to themselves and among each other such as metal, wood, plastic, glass, and ceramics.



## Technical Data

Composition	1 C.-Polyoxypropylene
density	1,44 g/cm <sup>3</sup>
Viscosity adhesive	paste
Stability/Run-off (ASTM D 222)	1 mm
Processing temperatur	+5 to +40 °C
Cure type	By humidity
Curing condition	+5 to +40°C and 30% to 95% rel. humidity
Skin-overtime*	25 min.
Cure speed (first 24h)	2 -3 mm
Volume change (DIN 52451)	-1 %
Gap filling up to max.	5 mm

### Note

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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	42
Elongation at break (DIN 53504/ASTM D 2240) ± 5	650 %
Tensile strength of pure adhesive and sealant	3,3 N/mm <sup>2</sup>
Average tensile shear strength (DIN 53283 / ASTM D 12)	2,1 N/mm <sup>2</sup>
Tear strength (DIN 53515/ASTM D 1002)	20 N/mm <sup>2</sup>
Movement capacity max.	15 %
Overpaintable (liquid paint) only „wet in wet“, within 3 hrs. at the latest after material app	
Building material category (DIN 412)	B 2
Temperature resistance	-40 to +90 °C
IMPA-Code	81 52 87

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

## Surface pre-treatment

The surfaces must be clean and grease-free. 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 pretreatment, e.g. sanding or sand-blasting, can considerably improve the adhesion.

## Processing

### Processing tube

Squeeze out by hand, close tube again immediately after use, opened tubes should be used up as quickly as possible.

### Processing press pack

Remove original closure. Regulate discharge by smooth turning of the cap from min. to max. Press the lever and process the product. After having turned the cap into the “min.” position the valve closes automatically and the product flow is stopped.

### 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 in a normal climate (+23°C and 50 % rel. humidity), WEICON elastic one-component adhesives and sealants have a shelf life of 12 months.

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**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:**

13350085	Flex+bond@ 85 ml white
13350200	Flex+bond@ 200 ml white
13351085	Flex+bond@ 85 ml grey
13351200	Flex+bond@ 200 ml grey
13352085	Flex+bond@ 85 ml black
13352200	Flex+bond@ 200 ml black
13353085	Flex+bond@ 85 ml transparent
13353200	Flex+bond@ 200 ml transparent

**Accessories:**

11202400	Sealant and Adhesive Remover, 400 ml
11207400	Surface Cleaner, 400 ml
11850200	Hand Protective Foam, 200 ml
13550125	Primer M 100, 250 ml
13550225	Primer K 200, 250 ml
13550325	Primer S 300, 250 ml
13550425	Primer P 400, 250 ml
13559500	Smoothing Agent,

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