

# Flex 310 M® HT 200 MS-Polymer



## high temperature resistant

The high temperature resistance makes it possible to bond and seal components needing to be subsequently thermal-coated (powder-coated).

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 highly temperature resistant, has outstanding ageing resistance, and is free of silicone, isocyanate, halogens or solvents.

## Technical Data

Composition	1 C.-MS Polymer
density	1,41 g/cm <sup>3</sup>
Viscosity adhesive	pasty
Stability/Run-off (ASTM D 222)	< 1 mm
Processing temperatur	+5 to +35 °C
Cure type	By humidity
Curing condition	+5 to +40°C and 30% to 95% rel. humidity
Skin-overtime*	10 min.
Cure speed (first 24h)	3 -4 mm
Shelf life (+5°C to +25°C / +41°F to +77°F)	12 months
Shore A hardness (DIN 5355 / ASTM D 224) ± 5	55
Elongation at break (DIN 53504/ASTM D 2240) ± 5	400 %
Tensile strength of pure adhesive and sealant	3,2 N/mm <sup>2</sup>
Tear strength (DIN 53515/ASTM D 1002)	21 N/mm <sup>2</sup>

### 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.

Overpaintable (liquid paint)	only after total cure
Building material category (DIN 412)	B 2
Specific forward resistance	3,4 x 10 <sup>11</sup> Ohm/cm
Layer thickness	2,0 mm
Temperature resistance	-40 to +90 (45 min. +180 / 30 min. +200) °C
ISSA-Code	75.634.37
IMPA-Code	81 52 77/78

\*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

### Application methods

Professional cartridge gun for 310 ml cartridges, compressed air gun (we recommend a variation with piston rod), automatic dosing systems.

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.

## 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:

13655310 Flex 310 M® HT 200 MS-Polymer 310 ml grey

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**Accessories:**

11202400	Sealant and Adhesive Remover, 400 ml
11207400	Surface Cleaner, 400 ml
11850200	Hand Protective Foam, 200 ml
13250000	Cartridge Cutter,
13250001	Cartridge Gun,
13250002	Cartridge Gun Special,
13250009	Compressed Air Cartridge Gun,
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,
13955031	V-Joint Nozzle,

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