

# Solar-Flex®



## developed for solar industry

WEICON Solar-Flex® is strong, non-corrosive, overpaintable (wet in wet), weather-resistant and resistant to UV rays. It is free of silicone, isocyanate, halogens and solvents. WEICON Solar-Flex® is an elastic adhesive on a MS polymer basis specially developed for the solar industry.

Both the very high initial bonding power and the fast development of adhesive strength enable bonds to be achieved even on vertical surfaces. Replaces traditional fixings in the assembly of solar and photovoltaic power systems.



## Technical Data

Composition	1 C.-MS Polymer
density	1,62 g/cm <sup>3</sup>
Viscosity adhesive	paste
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)	2 -3 mm
Volume change (DIN 52451)	-2 %
Gap filling up to max.	10 mm

### Note

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Gap width up to max.	30 mm
Shelf life (+5°C to +25°C / +41°F to +77°F)	12 months
Shore A hardness (DIN 5355 / ASTM D 224) ± 5	50
Elongation at break (DIN 53504/ASTM D 2240) ± 5	600 %
Tensile strength of pure adhesive and sealant	1,9 N/mm <sup>2</sup>
Average tensile shear strength (DIN 53283 / ASTM D 12)	1,5 N/mm <sup>2</sup>
Tear strength (DIN 53515/ASTM D 1002)	13 N/mm <sup>2</sup>
Movement capacity max.	20 %
Overpaintable (liquid paint)	only „wet in wet“, within 3 hrs.
Building material category (DIN 412)	B 2
Temperature resistance	-40 to +90 °C

\*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.

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## Technical Datasheet

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### Available sizes:

13750290 Solar-Flex® 290 ml white  
13752290 Solar-Flex® 290 ml grey

### 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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