

Flex 310 M® HT 200



耐高温

该产品耐高温，因而适用于涂胶后还需进行粉末喷涂的工况。

WEICON Flex 310 M HT 200 可用于金属加工、容器及仪器制造、通风和空调技术，以及车身、集装箱和汽车制造。

该产品能够耐高温、耐老化，且不含硅、异氰酸酯、卤素及溶剂。

技术参数

基础成分	单组份MS聚合物
密度	1,41 g/cm ³
粘度	膏状
垂流 (依据 ASTM D 2202)	< 1 mm
操作温度	+5 至 +35 °C
固化方式	湿气固化
固化条件	+5至+40温度环境及30%至95%相对空气湿度
表干时间*	10 分钟
固化速度 (首24个小时)	3 -4 mm
保存期限 (+5°C 至 +25°C)	12 个月
邵氏硬度 A (依据 DIN 53505 / ASTM D 2240) ± 5	55
断裂伸长率(依据 DIN 53504/ASTM D412)	400 %
粘合剂抗拉强度	3,2 N/mm ²
在室温下固化后的玻璃转换温度	-59 °C
电阻率	3,4 x 10 ¹¹ Ohm/cm
断裂抗性(依据 DIN 53515/ASTM D 1002)	21 N/mm ²
是否可涂漆 (湿涂)	nur nach vollständiger Durchhärtung
可燃性等级 (DIN 4102)	B 2
特定正向电阻	3,4 x 10 ¹¹ Ohm/cm
耐温性	-40至+90 (45分钟 +180 / 30分钟 +200) °C
ISSA 编码	75.634.37
IMPA 编码	815278

*50%空气湿度和+23°C环境温度下的测试结果

表面预处理

待粘接的物体表面需清洁、无油脂。大多数污垢（如油、脂、粉尘、污渍等）都能用WEICON表面清洁剂除去。针对严重污染的金属表面，我们推荐使用WEICON清洁喷剂S；针对老化的油漆或胶水残留物，我们建议使用WEICON密封胶去除喷剂。多数材料都能够很好地进行同材及异材粘接。针对少数特殊材料或极端工况，我们建议在涂胶之前先使用底漆进行预处理。详细说明请参见底漆选型表。使用机械方式对待粘接的表面进行预处理（如研磨或喷砂），能够大大提升粘接效果。

操作

使用方法

适用于310 ml胶瓶的手动胶枪，气动胶枪（我们建议使用带活塞连杆的胶枪），自动点胶系统

将待粘接部件进行粘合

为了达到最佳的浸润效果，涂胶后的待粘接部件需在胶水表面形成干膜前（表干时间）进行粘合操作。

储藏

在未开封且存放于正常环境（23°C，50%相对湿度）的情况下，WEICON单组份弹性密封胶的保质期为12个月。

安全与健康

使用WEICON产品时，需注意产品的物理性、安全性、毒性、生态性的详细参数以及我们EG材料安全数据表（www.weicon.com）的具体信息。

包装

13655310-47 Flex 310 M® HT 200 310 ml 灰色

产品配件

13250000 胶瓶切刀, 310 ml
13250001 压力胶枪,
13250002 压力胶枪特殊款,
13250009 空压胶枪,
13955031 V型喷嘴,

提示

本资料中列出的所有产品，其参数和建议是在实验室的测试结果及经验总结，不得被视为对产品特性的保证。由于每一个用的实际应用情况并不在我们的认知、控制及责任范围内，我们对这些信息并不承担任何义务。我们保证我们的产品符合并遵守我们销售条款中承诺的高品质、无瑕疵的要求。我们建议用户通过自行试验来论证其希望选用的产品是否完全符合预期。因用户未遵照指定的操作方法使用产品而造成损失的情况，用户将独自承担全部责任。

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Flex 310 M® HT 200 MS-Polymer



ISSA-Code	75.634.37
IMPA-Code	815278

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

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

Base	1 C.-MS Polymer
density	1,41 g/cm ³
Viscosity adhesive	pasty
Stability/Run-off (ASTM D 222)	< 1 mm
Processing temperature	+5 to +35 °C
Cure type	By humidity
Curing condition	+5 to +40 and 30% to 95% rel. humidity
Skin-overtime*	10 min.
Curing 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 ²
Tg after curing at room temperature	-59 °C
Specific resistance	3,4 x 10 ¹¹ Ohm/cm
Tear strength (DIN 53515/ASTM D 1002)	21 N/mm ²
Overpaintable (liquid paint)	only "wet in wet"
Building material category (DIN 412)	B 2
Specific forward resistance	3,4 x 10 ¹¹ Ohm/cm
Temperature resistance	-40 to +90 (45 min. +180 / 30 min. +200) °C

Surface pre-treatment

The surfaces must be clean and free of grease. 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 pre-treatment, 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 at room temperature (+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) must be observed.

Available sizes:

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

Accessories:

13250000 Cartridge Cutter, 310 ml
13250001 Cartridge Gun,
13250002 Cartridge Gun Special,

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.

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Technical Datasheet

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13250009 Compressed Air Cartridge Gun,
13955031 V-Joint Nozzle,

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