Elastic
One-component Adhesives and Sealants

- flexible • strong • durable
WEICON Flex 310 M® Classic

Newly developed and strong one-component adhesive/sealant (POP hybrid polymer) that cures practically without shrinkage. Almost all materials, such as metals, wood, plastics, glass, ceramic, etc., can be bonded to themselves and among each other without the necessity to use a primer.

WEICON Flex 310 M Classic is immediately overpaintable (wet-in-wet) and sandable after curing. Furthermore, the product offers excellent resistance to salt water, weathering and UV light and is free of solvents and isocyanate.

The applications for WEICON Flex 310 M Classic are many and varied. It is ideal for universal bonding as well as joint and seam sealing in:

- tank and apparatus construction
- car body, container and vehicle construction
- ventilation and air conditioning
- pipelines and fittings engineering
- insulating and protective systems
- power plants and electrical industry
- lamp production
- ship and boat building
- many fields of plastic processing

and all applications in which the bonded/sealed parts are to be painted over and therefore products containing silicone would not be suitable.

Contrary to Flex 310 M Classic, this product cures to a transparent/crystal clear material. Therefore, it can also be used for optically demanding applications.

Cure Speed of WEICON Flex 310 M Classic at +23°C and different relative air humidities

Cure Speed of WEICON Flex 310 M Classic at different temperatures and 50% relative air humidity

Optimum climate: +23°C and 50% relative air humidity
**Flex+bond**

for universal use

WEICON Flex+bond distinguishes itself by its wide range of application possibilities and the high adhesive force.

It bonds and seals nearly all materials such as:
- metals
- wood
- plastics
- glass
- ceramics
to themselves and among each other and is therefore the excellent product for a great variety of repairs and bondings as well as for the sealing of seams and joints.

Flex+bond is a one-component product, remains permanently elastic and can be sanded after curing and overpainted (wet in wet).

WEICON Flex+bond is:
- permanently elastic
- temperature resistant from -40°C up to +90°C
- resistant to weathering and UV rays
- resistant to salt water
- neutral in odour
- overpaintable (wet in wet)
- nearly shrinkage- and bubbling-free
- resistant to ageing
- free of isocyanate and solvents
- free of silicone, halogen and PVC

**Speed-Flex**

Power-Adhesive

WEICON Speed-Flex - the fast, strong and universally usable power adhesive. Replaces traditional fixings like screws, pegs, rivets, etc. Speed-Flex is pasty and stable and, thus, suitable for problem-free bonding even on vertical surfaces both in-house and outside.

Many materials, like metals, plastics (except PE, PP, PTFE), concrete, marble, natural and artificial stone, ceramic, enamel, gypsum, plates of MDF, wood, flake or gypsum plaster boards can be bonded permanently to themselves and among each other.

Especially on vertical surfaces where additional fixing is not possible or desired, Speed-Flex offers numerous application possibilities, e.g.:
- fastening of cable conduits to walls, ceilings and floors
- bonding of mopboards and corner clips
- bonding of stairs
- fixing of insulating material, e.g. insulating boards

Speed-Flex is a stable paste and levels out unevennesses (gap-filling). It is free of silicone, isocyanate and solvents, overpaintable (wet-in-wet), non-shrinking and neutral in odour when curing.
WEICON Flex 310 is a 1-component adhesive and sealant designed to serve various requirements in many fields of industry.

Features of WEICON Flex 310 are:
- permanently tough elasticity
- excellent adhesive strength

After curing WEICON Flex 310 is:
- of neutral odour, and
- can be sanded and overpainted (wet in wet) with most of the common paint and varnish systems.

The rapid cure makes the product ideal for use not only in repair and maintenance, but also in production and construction.

WEICON Flex 310 bonds nearly all materials such as
- metals
- wood
- plastics
- glass, ceramics etc.
to themselves or in combination.

WEICON Flex 310 provides long-term resistance against
- water, seawater
- many diluted acids and alkalis.
Temporarily resists fuels, oils and greases.

For non-absorbent surfaces, a pre-treatment with WEICON Primer Flex (bonding agent) is required.

WEICON Flex 310 are elastic adhesives/sealants with high adhesion force on the basis of polyurethane. The hardening process starts immediately after applying through the contact with air (air humidity).

WEICON Fast-Bond is a fast-curing one-component structural and assembly adhesive, universal in use and made on the basis of polyurethane.

It adheres to nearly all surfaces, is weathering and ageing resistant and, therefore, suitable for effective in-house or outside bonding applications with nearly all materials.

Plates of MDF or wood, flake or gypsum plaster boards, concrete, marble, natural or artificial stone, ceramic, gypsum, metals and expanding foams (e.g. polystyrene) as well as many plastics (except PE, PP, PTFE) can be bonded to themselves and among each other.

Due to these characteristics, numerous applications in craft and industry are possible:
- bonding of mopboards and corner clips
- fixing of stairs
- gluing*1 of window and door cases
- mounting of handrails
- fixing of insulating material, e.g. insulating boards
- bonding of metal thresholds
- fastening of cable conduits to walls or floors
- fixing of metal frames
- bonding of pegs inside walls

WEICON Fast-Bond is pasty and levels out unevennesses (gap-leveling). It is free of silicone and solvents, overpaintable, non-shrinking and neutral in odour when curing.

*1 Waterproof gluing according to DIN EN 204 D4
## Technical data:

### WEICON Sealants and Adhesives in non-cured condition

<table>
<thead>
<tr>
<th>Properties</th>
<th>Flex 310 M Classic</th>
<th>Flex 310 M Crystal</th>
<th>Flex+bond</th>
<th>Speed-Flex</th>
<th>Flex 310</th>
<th>Fast-Bond</th>
</tr>
</thead>
<tbody>
<tr>
<td>Basis:</td>
<td>1 K.-Polycyaprpylene</td>
<td>1 K.-Polycyaprpylene</td>
<td>1 K.-Polyurethane</td>
<td>1 K.-Polyurethane</td>
<td>1 K.-Polyurethane</td>
<td>1 K.-Polyurethane</td>
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<tr>
<td>RAL-colour*1</td>
<td>white 9003 grey 7000 black 9004</td>
<td>transparent/crystalclear</td>
<td>white 9003 grey 7000 black 9004</td>
<td>transparent/crystalclear</td>
<td>white 9003 grey 7001 black 9005</td>
<td>beige 9010</td>
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<td>Contents:</td>
<td>310 ml cartridge</td>
<td>290 ml cartridge</td>
<td>85 ml tube</td>
<td>310 ml cartridge</td>
<td>310 ml cartridge</td>
<td>310 ml cartridge</td>
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<td>Density g/cm³:</td>
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<td>1,04</td>
<td>1,67</td>
<td>1,04</td>
<td>1,60</td>
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<td>Viscosity:</td>
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<td></td>
<td></td>
<td></td>
<td></td>
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<td>&lt;1</td>
<td>1</td>
<td>&lt;1</td>
<td>&lt;1</td>
<td>1</td>
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<td>Processing temperature:</td>
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<td>(+41°F to +95°F)</td>
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<td></td>
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<td>Cure type:</td>
<td>by humidity</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Curing condition:</td>
<td>+5°C to +40°C (+41°F to +104°F) and 30% up to 95% relative humidity, cures even under water</td>
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<td></td>
<td></td>
<td></td>
<td></td>
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<tr>
<td>Skin-over time (minutes):*3</td>
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<td>10</td>
<td>10</td>
<td>10</td>
<td>10</td>
<td>45</td>
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<tr>
<td>Cure speed:*3</td>
<td>3 mm in the first 24 hours</td>
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<td></td>
<td></td>
<td></td>
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<tr>
<td>Volume change (DIN 52451 %):</td>
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<td>-3</td>
<td>-3</td>
<td>-3</td>
<td>-1</td>
<td>-6</td>
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<td>Gap filling up to max. mm:</td>
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<td>5</td>
<td>5</td>
<td>5</td>
<td>5</td>
<td>10</td>
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<tr>
<td>Gap width up to max. mm:</td>
<td>25</td>
<td>25</td>
<td>25</td>
<td>25</td>
<td>25</td>
<td>25</td>
</tr>
<tr>
<td>Shelf life (+5°C to +25°C) months:</td>
<td>12</td>
<td>12</td>
<td>12</td>
<td>12</td>
<td>9</td>
<td>12</td>
</tr>
</tbody>
</table>

### WEICON Sealants and Adhesives in cured condition

<table>
<thead>
<tr>
<th>Properties</th>
<th>Flex 310 M Classic</th>
<th>Flex 310 M Crystal</th>
<th>Flex+bond</th>
<th>Speed-Flex</th>
<th>Flex 310</th>
<th>Fast-Bond</th>
</tr>
</thead>
<tbody>
<tr>
<td>Shore-A-Hardness (DIN 53505 / ASTM D 2240):</td>
<td>42</td>
<td>40</td>
<td>40</td>
<td>40</td>
<td>58</td>
<td>45</td>
</tr>
<tr>
<td>Elongation to break (DIN 53504 / ASTM D 412 %):</td>
<td>650</td>
<td>310</td>
<td>750</td>
<td>310</td>
<td>230</td>
<td>450</td>
</tr>
<tr>
<td>Tensile strength of the pure adhesive/sealant (DIN 53504 / ASTM D 412):</td>
<td>3,3 N/mm² (479 psi)</td>
<td>2,4 N/mm² (346 psi)</td>
<td>1,8 N/mm² (261 psi)</td>
<td>2,4 N/mm² (346 psi)</td>
<td>2,2 N/mm² (319 psi)</td>
<td>2,0 N/mm² (290 psi)</td>
</tr>
<tr>
<td>Average tensile shear strength (DIN 53283 / ASTM D 1002):</td>
<td>2,1 N/mm² (304 psi)</td>
<td>1,8 N/mm² (261 psi)</td>
<td>0,7 N/mm² (102 psi)</td>
<td>1,8 N/mm² (261 psi)</td>
<td>1,5 N/mm² (212 psi)</td>
<td>1,6 N/mm² (232 psi)</td>
</tr>
<tr>
<td>Tear strength (DIN 53515 / ASTM D 624):</td>
<td>20 N/mm (114 psi)</td>
<td>17 N/mm (97 psi)</td>
<td>20 N/mm (114 psi)</td>
<td>17 N/mm (97 psi)</td>
<td>10 N/mm (57 psi)</td>
<td>9 N/mm (51 psi)</td>
</tr>
<tr>
<td>Movement capacity max. %:</td>
<td>15</td>
<td>20</td>
<td>20</td>
<td>20</td>
<td>15</td>
<td>10</td>
</tr>
<tr>
<td>Fungicide:</td>
<td>no</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Temperature resistance:</td>
<td>-40°C (-40°F) to +90°C (+194°F) shortly (approx. 2 h) up to +150°C (+302°F)</td>
<td>-40°C (-40°F) to +90°C (+194°F) shortly (approx. 2 h) up to +150°C (+302°F)</td>
<td>-40°C (-40°F) to +90°C (+194°F) shortly (approx. 2 h) up to +150°C (+302°F)</td>
<td>-40°C (-40°F) to +90°C (+194°F) shortly (approx. 2 h) up to +150°C (+302°F)</td>
<td>-40°C (-40°F) to +90°C (+194°F) shortly (approx. 2 h) up to +150°C (+302°F)</td>
<td>-30°C (-22°F) to +100°C (+212°F) WATT 91</td>
</tr>
<tr>
<td>Solids content %:</td>
<td>100</td>
<td>100</td>
<td>100</td>
<td>100</td>
<td>100</td>
<td>100</td>
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<tr>
<td>Specific forward resistance:</td>
<td>10² Ω/cm</td>
<td>10² Ω/cm</td>
<td>10² Ω/cm</td>
<td>10² Ω/cm</td>
<td>10² Ω/cm</td>
<td>10² Ω/cm</td>
</tr>
<tr>
<td>Dielectric strength:</td>
<td>22 kV/mm</td>
<td>22 kV/mm</td>
<td>22 kV/mm</td>
<td>22 kV/mm</td>
<td>22 kV/mm</td>
<td>24 kV/mm</td>
</tr>
<tr>
<td>Thermal conductivity:</td>
<td>0,6 W/mK</td>
<td>0,6 W/mK</td>
<td>0,6 W/mK</td>
<td>0,6 W/mK</td>
<td>0,6 W/mK</td>
<td>0,6 W/mK</td>
</tr>
<tr>
<td>Overpaintable:*4</td>
<td>only wet-in-wet within max. 4 minutes after skin formation</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Building material category (MAX 4102):</td>
<td>B 2</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

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*1 Nearly matches the indicated RAL colours
*2 If used at low temperatures, cartridges or tubes should be warmed up to room temperature for easier processing
*3 Standard climate: +25°C and 50% relative air humidity according to DIN 50014
*4 Material combination: Alu/Alu, cleaned and degreased with Cleaner S, layer thickness 1 mm, tear speed 10 mm per minute. Fast Bond: been/beeche, without pre-treatment, layer thickness 1 mm, tear speed 5 mm per minute.
*5 Above listed WEICON one-component adhesives and sealants are free of substances that disturb lacquer formations, 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 real conditions must always be carried out. This is necessary because of the different composition and the variety of paint coating systems.
*6 The cure speed of the adhesives and sealants is only slightly reduced by a paint coating.

Conversion table on page 8

Possible Primer: see primer chart on www.weicon.de

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Primer-Flex
Silicone

WEICON Silicones are one-component sealants/adhesives which have been developed to meet the high demands of industrial fabrication. They consist of 100% solid material which cures at room temperature practically without shrinkage.

They are particularly suitable for use in production, construction, maintenance and for quick assembly/repair work.

Silicone - Elongation at break 600 % -

The standard type is resistant to temperatures from -40⁰C to +200⁰C and is available in transparent, white, grey and black.

Silicon N - neutrally-vulcanizing -

Bonds almost all materials to themselves or among each other, insulates and adheres to substrates such as:
- aluminium
- steel and non-ferrous metals
- glass and glass fabrics
- ceramics and wood
- PVC and other plastics

The neutrally-vulcanizing Silicone N is especially suitable to bond polycarbonate and plexiglass. However, environmental stress cracking might be possible depending on the composition of the material to be bonded. Own tests are therefore recommended.

Silicon F - liquid, self-leveling -

Suitable for elastic bonding, insulation and impregnation in industrial use.
Also recommended for sealing and casting of technical components. The sealing gap should not exceed 10 mm.

Silicone F bonds almost all materials to themselves or among each other, insulates and adheres to substrates such as:
- aluminium
- anodized aluminium and steel
- glass and glass fabrics
- ceramics and wood

WEICON Silicones are highly recommended for:
- elastic bondings and sealings
- coatings
- insulation
- impregnation

The high dielectric strength make them ideal for use in electrical engineering and for insulating electrical leads. Other applications are in making:
- seals of any size
- models
- moulds and prototypes

Almost all materials can be bonded to themselves and among each other. WEICON Silicones adhere to most surfaces, e.g.:
- aluminium and steel
- glass, glass cloth and ceramics
- duroplastics/thermoplastics and nonferrous metals (only WEICON Silicone N)
- wood and many other materials

WEICON Silicones are compression-proof and chemically resistant to many aggressive media, such as:
- oil and fuel
- fresh and sea water
- industrial waste gas
- diluted acids and salts
- detergents and fruit acids

WEICON Silicones are non-ageing and adhere without embrittlement or hardening even under changing temperatures. WEICON offers different types of Silicone to cover a variety of applications.
## Technical data

### WEICON Sealants and Adhesives in non-cured condition

<table>
<thead>
<tr>
<th>Properties</th>
<th>Silicone</th>
<th>Silicone N</th>
<th>Silicone F</th>
<th>HT 300</th>
<th>Black-Seal</th>
</tr>
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<tbody>
<tr>
<td>RAL-colour*1</td>
<td>transparent</td>
<td>white 9003</td>
<td>grey 7037</td>
<td>aluminium 9006</td>
<td>transparent</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td>red 3016</td>
</tr>
<tr>
<td>Contents:</td>
<td>310 ml cartridge</td>
<td>/</td>
<td>85 ml tube</td>
<td>85 ml tube</td>
<td>200 ml spray can</td>
</tr>
<tr>
<td>Density (g/cm³):</td>
<td>1,03</td>
<td>1,05</td>
<td>1,02</td>
<td>1,03</td>
<td>1,22</td>
</tr>
<tr>
<td>Viscosity:</td>
<td>putty</td>
<td>putty</td>
<td>putty</td>
<td>11,000 mPa s</td>
<td>putty</td>
</tr>
<tr>
<td>Stability (ASTM D 2020)</td>
<td>1 mm</td>
<td>1 mm</td>
<td>liquid</td>
<td>1 mm</td>
<td>&gt;1 mm</td>
</tr>
<tr>
<td>Processing temperature:</td>
<td>+5°C to +40°C / +41°F to +104°F</td>
<td></td>
<td>+5°C to +35°C*2</td>
<td></td>
<td>+41°F to +95°F</td>
</tr>
<tr>
<td>Cure type:</td>
<td>by humidity</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Curing condition:</td>
<td>from +5°C to +40°C (+41°F to +104°F) and 30% to 95% relative humidity</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Skin-over time (minutes)*12</td>
<td>7</td>
<td>6</td>
<td>5</td>
<td>7</td>
<td>7</td>
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<tr>
<td>Cure speed:*10</td>
<td>3 mm in the first 24 hours</td>
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<td></td>
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<td></td>
</tr>
<tr>
<td>Volume change (DIN 52451) %:</td>
<td>-1</td>
<td>-1</td>
<td>-2</td>
<td>-9</td>
<td>-1</td>
</tr>
<tr>
<td>Gap filling up to max. mm:</td>
<td>5</td>
<td>5</td>
<td>5</td>
<td>2</td>
<td>5</td>
</tr>
<tr>
<td>Gap width up to max. mm:</td>
<td>25</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Shelf life (+5°C bis +25°C) months:</td>
<td>12</td>
<td>12</td>
<td>9</td>
<td>9</td>
<td>12</td>
</tr>
</tbody>
</table>

### WEICON Sealants and Adhesives in cured condition

| Shore-A hardness (DIN 53505 / ASTM D 2240): | 16 | 27 | 19 | 23 | 44 | 20 |
| Elongation to break (DIN 53504 / ASTM D 412): %: | 600 | 360 | 540 | 370 | 300 | 500 |
| Tensile strength of the pure adhesive-sealant (DIN 53504 / ASTM D 412): N/mm²: | 1,7 N/mm² (247 psi) | 1,7 N/mm² (247 psi) | 1,8 N/mm² (261 psi) | 2,9 N/mm² (421 psi) | 1,5 N/mm² (218 psi) |
| Average tensile shear strength (DIN 53593 / ASTM D 1002): N/mm²: | 0,8 N/mm² (116 psi) | 0,9 N/mm² (131 psi) | 0,8 N/mm² (116 psi) | 0,8 N/mm² (116 psi) | 1,3 N/mm² (180 psi) | 0,7 N/mm² (102 psi) |
| Tear strength (DIN 53515 / ASTM D 624): | 4,0 N/mm (52 psi) | 6,0 N/mm (84 psi) | 6,0 N/mm (84 psi) | 3,6 N/mm (51 psi) | 6,0 N/mm (84 psi) | 4,0 N/mm (52 psi) |
| Movement capacity max. %:          | 25       | 25         | /         | 16     | 20         |
| Fungicide:                        | no |
| Temperature resistance:           | -50°C (-58°F) to +180°C (+362°F) shortly (approx. 2 h) +260°C (+500°F) | -40°C (-40°F) to +180°C (+362°F) shortly (approx. 2 h) +260°C (+500°F) | -60°C (-76°F) to +180°C (+362°F) shortly (approx. 2 h) +260°C (+500°F) | -50°C (-58°F) to +230°C (+446°F) shortly (approx. 2 h) +300°C (+572°F) | -60°C (-76°F) to +230°C (+446°F) shortly (approx. 2 h) +300°C (+572°F) |
| Solids content %:                 | 100      | 100        | 90        | 100    | 90         |
| Specific forward resistance:      | 2,5 x 10⁴Ω/cm | 7 x 10⁴Ω/cm | 7 x 10⁴Ω/cm | 2,5 x 10⁵Ω/cm | 2,5 x 10⁵Ω/cm |
| Dielectric strength:              | 21 kV/mm | 16 kV/mm | 15 kV/mm | 16 kV/mm | 16 kV/mm |
| Thermal conductivity:             | 0,3 W/m*K  | 0,4 W/m*K  | 0,3 W/m*K  | 0,3 W/m*K  | 0,3 W/m*K  |
| Overpaintable:                    | not overpaintable |
| Building material category (DIN 4100): | B 2 |

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* Nearly matches the indicated RAL colours. ** If used at low temperatures, cartridges or tubes should be warmed up to room temperature for easier processing.

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### Calculation of needed quantity

<table>
<thead>
<tr>
<th>Width of joint</th>
<th>5 mm</th>
<th>6 mm</th>
<th>8 mm</th>
<th>10 mm</th>
<th>12 mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>m/m</td>
<td>25</td>
<td>30</td>
<td>30</td>
<td>10,3</td>
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<td>64</td>
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<tr>
<td>m/m</td>
<td>50</td>
<td>60</td>
<td>52</td>
<td>3,8</td>
<td></td>
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<tr>
<td>m/m</td>
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<td>72</td>
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<td>144</td>
<td>2,2</td>
<td>1,7</td>
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<td>300</td>
<td>1,0</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

Conversions:

- (°C x 1.8) +32 = °F
- kV/mm x 25.4 = V/m
- mm / 25.4 = inches
- µm / 25.4 = mil
- N x 0.225 = lb
- N/m x 5.71 = lb/in
- N/mm x 5.71 = psi
- kg x 2.2046 = lb

MPa x 145 = psi
MPa x 0.145 = kSI
mPa-s = cP
N x 0.651 = lb-ft
N-m x 0.738 = lb-ft
N-mm x 0.142 = oz-in
kg x 2.2046 = lb
HT 300
- high-temperature resistant -

This product finds its use in high-temperature applications. It withstands permanent exposure to temperatures of +230°C (briefly up to +300°C) and has been approved by the TÜV South Germany for use in exhaust systems of oil- or gas-fired heating systems with exhaust temperatures of up to +200°C.

WEICON HT 300 can therefore be used in a variety of applications: on hot cabinets or ovens, from the sealing of system parts to the fixing and sealing of inspection glasses.

Black Seal
- from the spray can -

WEICON Black Seal is a one-component special grade silicone rubber, dispensed from the practical spray can. It allows nearly unlimited applications and simplified handling without applicator gun.

WEICON Black Seal will remain flexible even at high temperatures and provides excellent adhesion on aluminium, steel, wood, glass, glass fiber cloth, ceramics and many other materials.

WEICON Black Seal also has an outstanding weathering resistance and is particularly suitable to seal
- gearbox caps, valve caps and casing covers
- oil trays and pumps
- camshaft and front covers
- water pumps
- inlet systems and thermostatic housings

It is equally suitable for use in heat-exposed flexible bonding and sealing of
- industrial furnaces and tile stoves
- flue gas boxes
- heating facilities and boilers
- exhaust gas ducts
- hot cabinets and heating furnaces
- air conditioners

Product features:
- easy processing without applicator gun
- wide range of applications
- high temperature resistance from -40°C to +280°C
  briefly (<3 hours) up to +300°C
- outstanding weathering and UV resistance
Elastic
One-component
Adhesives and Sealants

• flexible • strong • durable