

HI-COMPRESSION TAPES
ADHESIVES • SEALANTS
SPECIAL INDUSTRIAL PAINTS
CUSTOM MECHANICAL EQUIPMENT

SALES • SERVICE ENGINEERING
CONSULTING ENGINEERING
NEW PRODUCT DESIGN



TECHNICAL DATA

MANUS-BOND FLEX-WELD

EPOXY ADHESIVE

1. PRODUCT DESCRIPTION:

Flex-Weld is an all-purpose, non-sag epoxy that provides excellent tensile, peel and shear strength. Exhibits superior adhesion and flexibility to a wide variety of substrates including: ceramics, concrete, wood, FRP and many metals without a primer. Flex-Weld has a user-friendly 1:1 by volume mix ratio with a long room temperature work life or can be heat cured for faster assembly.

2. TECHNICAL DATA:

	<u>PART A</u>	<u>PART B</u>	<u>BLEND</u>
Specific Gravity	1.22	1.69	1.46
Color	White	Dark Gray	Gray
Viscosity (cps)	350,000	370,000	
Work Life:			
• 50°F			5 hours
• 72°F			2 hours
• 100°F			1 hour
Boeing Flow (inches)			0.05
Elongation (percent)			93
Tensile Strength (psi)			625
Lap Shear (psi)			650
Hardness Shore A			90
Service Temperature			- 30°F to 200°F

Bond Strength at 72°F

Hours	Lap Shear (psi)	Adhesion
1-2	Work Life	N/A
3	144	100%CF
4	195	100%CF
5	240	100%CF
6	267	100%CF
7	297	100%CF
24	375	100%CF
48	425	100%CF
72	441	100%CF

3. PACKAGING:

400ml 2-component cartridge pack; 5 or 55 gallon containers.

4. SURFACE PREPARATION:

Apply to clean, dry surfaces free of contaminants that can adversely affect adhesion. Remove all old sealant before applying Flex-Weld. Testing a small area for compatibility is recommended.

5. PAINTING:

Cured product may be painted with most industrial and consumer paints. Testing prior to painting is recommended.

6. STORAGE LIFE:

6 months in unopened containers at temperatures not exceeding 80°F.

7. PRECAUTIONS:

Use with adequate ventilation. Inhalation of vapor during application and cure may cause slight eye or throat irritation. In case of contact with eyes, lips, or mouth, flush thoroughly with water. If irritation persists, consult a physician. Avoid repeated, prolonged contact with skin. See MSDS for additional information. **KEEP OUT OF REACH OF CHILDREN.**

8. TECHNICAL SERVICE:

Manus technical representatives are always available to provide assistance. Please contact our Technical Service Department with your questions or requests for specific applications.

9. LIMITED WARRANTY:

Any goods proved defective will be replaced or the purchase price refunded. The limited warranty described herein is in lieu of any other warranty, expressed or implied, including any implied warranty of merchantability or fitness for a particular use. The user shall determine suitability of the product for its intended use. Liability for any incidental or consequential damage or loss is excluded. The user assumes all risks of the product's use, handling and storage.

Distributed by



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