TECHNICAL DATA

MANUS-BOND
FLEX-WELD 15

MODIFIED EPOXY ADHESIVE

1. **PRODUCT DESCRIPTION:** Flex-Weld 15 is an all-purpose, modified epoxy that provides excellent tensile, peel and shear strength. Exhibits superior adhesion and flexibility to a wide variety of substrates including: ceramics, concrete, wood, composites, FRP and most metals-without the use of a primer. Flex-Weld has a user-friendly and forgiving1:1 by volume mix ratio. Light stable and highly UV resistant. Flex-Weld outperforms most "brittle" 2-component systems by retaining high peel strength and flexibility through a wide temperature range.

2. TECHNICAL DATA:

	PART A	PART B	BLEND
Specific Gravity	1.19	1.44	1.315
Color	White	Black	Gray
Viscosity (cps) *Brookfield Helipath T-E @ 5 rpms, 72˚F	80,000	160,000	140,000
Work Time @72ºF			15 min.
Open Time @72ºF			25 min.
Ultimate Peel Strength *Per ASTM D1781-93 Standard Test Method for Climbing Drum Peel for Adhesives			50 pli
Tensile Strength			825 psi
Lap Shear			750 psi
Elongation			100%
High Temperature Resistance			Up to 350˚F for short periods
Low Temperature Flexibility			Properties retained to - 75˚F
Shore A			82

*Above values are typical values for the material, but not intended for use in specifications. Field conditions may yield different results.

3. **PACKAGING:**
   55 gallon Drums, 5 gallon pails, gallon cans, 400 ml dual cartridges

4. **SURFACE PREPARATION:**
   Apply to clean, dry surfaces free of contaminants that can adversely affect adhesion. Remove all old sealant before applying product. Some substrate materials may not be compatible with this product. Testing substrate compatibility with this product before full application is recommended.

5. **PAINTING:**
   Cured product may be painted with most industrial & consumer paints. Testing prior to painting is recommended.

6. **STORAGE LIFE:**
   6 Months. For maximum shelf life, store unopened product between 65ºF – 80ºF.
   Part B is cold storage sensitive. Do not store below 65ºF for more than 1 week.

7. **PRECAUTIONS:**
   Some applications may not be compatible with this product. Testing suitability for intended application before proceeding with full application is recommended. 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 FROM 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 prove 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.

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