

GELFLEX 345 SPEED

DESCRIPTION

One-component, polyurethane-based, fast-hardening adhesive/sealant that cures when exposed to atmospheric moisture.

If used with the specific 345 Speed Cleaner Activator, it adheres to the support without primer.

Ideal for replacing windscreens and windows on vehicles with or without airbags and in general for gluing and sealing glass in the automotive, industrial, railway and nautical fields.

DRIVE AWAY TIME: 1 h

(23°C, 50% u.r., vehicles with double airbag)

Compliant with FMVSS 212.

PRODUCT BENEFITS

- Ultra-fast curing and excellent green strength.
- Neutral polymerization: non-corrosive on surfaces
- Absorbs stress and tensions from thermal expansion and joining of different materials.
- Does not swell, does not shrink, does not sag.
- Good resistance to chemical and atmospheric agents
- Excellent resistance to water and salt spray

CHARACTERISTICS

- Appearance: Thixotropic paste
- Base: Polyurethane
- Colour: black
- Specific gravity: $1,25 \pm 0,05 \text{ g/cm}^3$
- Operating temperature: -40°C up to +90°C, with short peaks at 120°C
- Hardness Shore A: 57
- Elongation at break: ~700 %

SUBSTRATE PREPARATION

The surfaces to be treated must be perfectly clean, dry, and degreased. Refer to the relevant documentation for the drying times of the products used and respect them.

Application with 345 Speed Cleaner Activator:

Apply the 345 Speed Cleaner Activator on both surfaces to be joined with a felt tip applicator or a lint-free cloth. Let it dry for 10 minutes minimum before proceeding.

You can apply the sealant without additional steps on:

- black ceramic edge of the windshield, only if intact and perfectly opaque
- coated metal or e-coat, or old polyurethane sealant freshly cut (less than an hour)

In all other cases, it is mandatory to apply Black Glass Primer.

Application with standard Cleaner Activator or Glass Cleaner:

Apply a suitable cleaner such as Cleaner Activator (or alternatively Glass Cleaner), on both surfaces to be joined with lint-free cloth. Let it dry before proceeding.

When the cleaner has dried, apply Black Glass Primer on both surfaces.

The effectiveness of our products is based on practical experiences and research work carried out in our laboratories; nevertheless we accept no liability for work carried out following our instructions being clear that the final result depends in all cases on a series of unforeseeable factors.

* For any information about product codes or packs, please see our catalogue, our price list or contact us.

APPLICATION

Application temperature: from +5°C to +40°C.

Apply Gelflex 345 Speed to the black ceramic edge of the windshield. Using the appropriate nozzle, extrude a triangular bead of sealant.

Wait at least 1 hour before using the vehicle.

DRYING TIME

Skin forming time (23°C, 50% r.h.): 25-40 minutes

Curing rate (23°C, 50% r.h.): 3,5 mm/24h

Drive-away time (23°C, 50% u.r.): 1 h

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