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TECHNICAL DATA SHEET

REV.1 04/09/2026

GELFLEX 345 BUS

DEFINITION

One-component polyurethane adhesive/sealant curing with atmospheric moisture. Ideal for windshield and vehicle glass replacement with or without airbags, and generally for bonding and sealing glass in the automotive field (especially buses, campers, tractors, trucks), industrial, railway, and marine sectors.

DRIVE AWAY TIME: 3 h

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

PRODUCT BENEFITS

- Excellent adhesive strength.
- Neutral curing: non-corrosive on surfaces.
- Absorbs stress caused by thermal expansion and tension at joints between different materials.
- Does not swell, shrink, or sag.
- Good resistance to chemicals and weathering.
- Excellent resistance to water and salt spray.

CHARACTERISTICS

- Appearance: Thixotropic paste
- Chemical nature: Polyurethane
- Colour: black
- Specific gravity: 1,20 ± 0,05 g/cm^3
- Operating temperature: -40°C up to +90°C, with short peaks at 120°C
- Hardness Shore A: 55
- Elongation at break: ~400 %

SUBSTRATE PREPARATION

The surfaces to be treated must be perfectly clean, dry, and degreased.
Apply a suitable cleaner such as Cleaner Activator, 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. Refer to the relevant documentation for the drying times of the products used and respect them.

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.

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APPLICATION

Open using a blade by making an incision on the side opposite the silver seal, approximately 1 cm from the metal clip towards the "shoulder" of the pack.
Application temperature: from +5°C to +40°C.
Apply Gelflex 345 Bus to the black ceramic edge of the windshield. Using the appropriate nozzle, extrude a triangular bead of sealant.
Wait at least 3 hours before using the vehicle.

DRYING TIME

- Skin forming time (23°C, 50% r.h.): 40-60 minutes
- Curing rate (23°C, 50% r.h.):3,0 mm/24h
- Drive-away time (23°C, 50% u.r.): 3 h

STORAGE

Store the product in a dry place, protected from direct sunlight, at temperatures in between 5°C and 35°C.

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