

# TECHNICAL DATA SHEET

## Klebfix FLEX superglue

**Art. no. 0893 092**

P. Qty.: 1

**Tough yet flexible black superglue with excellent thermal resistance.**

Suitable for bonding all metals including aluminium, ferrite (sintered material), plastics (EPDM, NBR, PMMA, PC, PVC, polystyrene, POM, TPE, TPO), rubber and silicone rubber, laminated panels, artificial and natural stone, HPL, enamel, glass, mirrors, porcelain, ceramics, paper and cardboard.



Chemical basis	Cyanoacrylate acidic ester
Colour	Black
Density	1.06 g/cm <sup>3</sup>
Min./max. viscosity	80-180 mPas
Stretch capacity	8 %
Max. gluing gap size	0.15 mm
Min./max. temperature resistance	-55 to +120 °C
Min./max. processing temperature	10 to 35 °C
Solvent-free	Yes
Contents	18.8 ml
Weight of content	20 g

Tensile shear strength values in compliance with DIN EN 1465		
Material	Typical bonding times	Typical tensile and shear strength values
Steel	90 - 120 seconds	>25 N/mm <sup>2</sup>
Aluminium	40 - 60 seconds	>16 N/mm <sup>2</sup>
PA	45 - 90 seconds	15-20 N/mm <sup>2</sup>
PVC	45 - 90 seconds	15-20 N/mm <sup>2</sup> *
Polycarbonate	60 - 100 seconds	4-6 N/mm <sup>2</sup> *
POM	60 - 90 seconds	1-2 N/mm <sup>2</sup>
EPDM	10 - 30 seconds	>10 N/mm <sup>2</sup> *
Neoprene	10 - 30 seconds	>10 N/mm <sup>2</sup> *
*Material breakage		

Set to the touch after	
Material	Cure time
Aluminium/aluminium	40 to 60 seconds
NBR/NBR	< 25 seconds
Neoprene/neoprene	< 30 seconds
Curing speed is accelerated by using the activator	

## Application area

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thanks to its flexibility, the cyanoacrylate structural adhesive is designed especially for applications with alternating thermal and mechanical loads. Other features include a high impact and peel resistance, even when subject to dynamic load. In addition, Klebfix FLEX has better moisture, water and steam resistance than standard cyanoacrylate adhesives.

Thanks to a short-term temperature resistance of up to +140°C, the superglue can also be used to bond electronic components on printed circuit boards, which must subsequently pass through a soldering bath. Particularly suitable for speaker construction.

		Klebfix	Klebfix Plasto	Klebfix Flex	Klebfix 4-in-1	Klebfix 4-in-1 Brush application	Klebfix GAN	Klebfix 2C
		0893 09 0893 090 0893 090 0	0893 091	0893 092	0893 423	0893 094	0893 403	0893 093 090
Metal	Aluminium	●2	-	●2	●2	●2	●2	●
	Lead	-	-	●	●	●	●	-
	Stainless steel	-	-	●	●	●	●	●
	Copper	●	-	●	●	-	-	●
	Brass	-	-	●	●	-	-	●
	Steel/iron	●	-	●	●	●	-	●
	Zinc	-	-	●	●	●	●	●
Plastics	ABS	-	●	-	●	●	●	●
	GRP	●	●1	-	-	●	●	●
	EPDM	●	-	●	-	-	●	-
	Rubber	●	-	●	●	●	●	●
	Rigid foams	-	●1	●1	-	●1	●1	●
	Neoprene	-	-	●	-	-	-	●
	PE	-	●1	-	●1	●1	●1	●1
	PMMA	-	●	●	●	●		●
	Polyamide	-	-	-	-	-	-	●
	Polycarbonate = PC	●	-	●	●	●	●	●
	Polystyrene	-	●1	●1	●	●	●	●
	PP	-	●1	-	-	-	●	●1
	PTFE	-	●1	-	-	-	-	-
	PU	-	●	-	-	-	-	●
	PVC	-	●	●	●	●	●	●
	Silicone	-	-	●1	-	-	-	-
	Styrofoam	-	●1	●1	-	-	-	●
Painted surfaces	Painted surfaces	-	-	-	-	●	●	●
Wood and wood materials	Wood (MDF, chipboard)	-	-	-	●	●	-	●
	Laminated panels (Resopal, Ultrapas)	-	-	●	●	●	●	●
	Decorative panels	-	-	-	-	-	-	●
	Cork	●	●	●	●	●	●	-

1. With primer 0893 091 5  
2. With activator 0893 301 20

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Stone and construction materials	Concrete	-	-	-	●	●	●	-
	Bituminous surfaces	-	-	-	●	-	-	-
	Aerated concrete, gypsum, gypsum plaster-board	-	-	-	●	●	●	-
	Synthetic stone (Corian, Varicor)	●	-	●	-	-	-	●
	HPL	-	-	●	●	●	●	-
	Natural stone (marble, granite)	● <sup>1</sup>	-	●	-	-	●	●
	Stone	-	-	-	-	-	●	-
	Cemented fibre-boards	-	-	-	●	●	●	-
Other	Enamel	● <sup>1</sup>	-	●	-	-	-	-
	Glass	●	-	●	●	●	●	●
	Fibre glass	-	-	-	●	●	-	●
	Mirror	● <sup>1</sup>	-	●	-	●	●	-
	Porcelain, ceramic, tiles	●	-	●	●	●	●	●
	Paper	-	-	●	●	●	●	●
	Cardboard	-	-	●	●	●	●	●
	Mesh	-	-	-	●	●	-	●
Leather	-	-	-	●	●	-	-	

1. With primer 0893 091 5  
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## Application information

The parts to be bonded must be clean, Free of grease and dry.

For elastomers (rigid but malleable plastics), only fresh blanks should be bonded, where possible, and any talc layers should be removed in advance.

Apply a thin, even layer of adhesive to just one of the surfaces to be bonded.

Apply sufficient pressure to make the connection immediately, in order to ensure complete contact.

On non-polar, difficult-to-bond materials, such as POM, TPE, TPO, PE, PP, PTFE and silicone rubber, the best bonding results are achieved using the primer for superglues (art. no.: 0893 091 0). Use the activator (art. no.: 0893 301 20) to speed up the reaction of cyanoacrylate adhesives. This can usually be used on all kinds of substrates, but please test it beforehand on a concealed section for compatibility.

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## Notice

- It is advisable to wear protective gloves and safety goggles.
- If surfaces are too dry or acidic, this will delay or prevent hardening, while higher levels of moisture and alkaline surfaces will have an accelerating effect.
- thanks to the vapour pressure of the liquid adhesive, slowly hardening excess around the point of adhesive can lead to a white deposit (blooming effect). These are adhesive vapours that are hardening. These can be removed with isopropyl alcohol or acetone for example. However, it is important to ensure that the surfaces of the parts to be cleaned are also resistant to these solvents. Blooming can be prevented / reduced by using the adhesive economically and ensuring sufficient air humidity and ventilation in the work area.



Material breakage



Material breakage

The usage instructions are recommendations based on the tests we have conducted and on our experience; carry out your own tests before each application. Due to the large number of applications and storage and processing conditions, we do not assume any liability for a specific application result. Insofar as our free customer service provides technical information or acts as an advisory service, no responsibility is assumed by this service except where the advice or information given falls within the scope of our specified, contractually agreed service or the advisor was acting deliberately. We guarantee the consistent quality of our products. We reserve the right to make technical changes and further develop products. Please observe the technical data sheet!