

**Product Information:**

# Combi Flex 524

**All-round fast neutral adhesive with high strength**

**General description and application:**

Combi Flex 524 belongs to the new generation of MS-polymer sealants, which combines the best qualities from silicone- and polyurethane sealants. The sealant cures by reaction with the moisture in the air to an elastic joint.

Combi Flex 524 is absolute odourless, neutral and fast curing. It can be painted and has a remarkable resistance to climatic influence. Combi Flex 524 does not contain solvents, silicone or isocyanate.

Combi Flex 524 is used for assembling in the body work-, ship- and container industries, where hard and resistant bonding / sealing are required. Combi Flex 524 is also suitable for joints in wooden and concrete floors.

The transparent version of Combi flex 524 can be used for interior jointing. As an adhesive Combi flex 524 transparent can be used both indoor and outdoor.

Combi Flex 524 is approved for indirect contact to foodstuff.



Member of **F&O** Danish Association of Sealant Applicators & Manufactures

**Physical / chemical properties:**

**Uncured sealant:**

Type: MS-hybrid polymer, 1-component  
 Contains fungicide: No  
 Appearance: Paste, thixotropic  
 Specific gravity: approx. 1.5 kg/litre, transparent 1.08 kg/litre  
 Shelf life: 1 year in unopened packing if stored cool and dry.  
 Packaging:

Item no.	Colour	Size
54561	Transparent	290 mL cartridge
54562	White	290 mL cartridge
54563	Grey	290 mL cartridge
54565	Black	290 mL cartridge
54592	White	600 mL foilbags
54593	Grey	600 mL foilbags

**Cured sealant:**

Paintable: Yes  
 Hardness: 41-43 Shore A  
 100% Modulus: approx. 1,3 N/mm<sup>2</sup> (ISO 8339)  
 Elasticity at break: approx. 150 % (ISO 8339)  
 Maximum movement acc: Coloured: +/- 20 %  
 Resistance: Temperature: approx. -40 °C to +90 °C. Temperature for transparent: -40 °C to +80 °C.  
 Climatic ageing (UV): good  
 Good resistance to water, seawater, aliphatic solvents, oil, grease, diluted organic acids and bases. Not resistant to concentrated acids and chlorinated organic solvents.  
 Note that the transparent\* can become yellow after a period.  
 \* at thick layers the sealant can be appeared slightly blue.



DANA LIM A/S  
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 DK-4600 Køge  
 14  
 DOP: 15651-0524-1

EN 15651-1  
 F-EXT-INT CC

EN 15651-4  
 PW-EXT-INT CC



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EN 15651-1  
 F-INT  
 (Transparent)

## Directions for use:

### Joint dimensions:

Joints in which Combi Flex 524 is used should be dimensioned so that the movement of the free sealant is below +/- 20 %. Use joint back-up material in the right dimension, which is placed according to the wanted depth of the joint. The depth of the joint is usually half of the width, although small joints should be square.

When Combi Flex 524 is used in flooring joints, make sure that the width of the joint is sufficient to tolerate the movements of the floor, e.g. related to changing temperatures and humidity. As back-up, can use hard material as e.g. bond-breaker or washed and dried quartz sand.

### Preparation:

All surfaces must be clean, dry, free of grease, dust and loose particles.

Combi Flex 524 can be used without primer on surfaces like glass, aluminium, most painted surfaces, PVC and most plastics. For optimum bonding we recommend the use of Primer 960 on non-absorbent surfaces as e.g. stainless steel and acrylics or Primer 961 on porous surfaces as bricks, concrete, wood etc.

For more detailed information, please refer to adhesion table in the brochure »Sealants Proff – Product Guide«.

In practice, variations can occur in the different materials, therefore it is always recommended to carry out sufficient bonding tests before commencing - in particular larger applications.

We recommend the use of covering tape, which should be removed immediately after application of the sealant.

### Application conditions:

Can be applied at temperatures from +5 °C to +40 °C and a relative humidity at minimum 30 %.

### Application:

The tip of the cartridge is cut off with a keen knife after which the tip is cut with an inclined cut, which is a little smaller than the width of the joint. The sealant is applied by means of a hand- or pneumatic gun.

### Curing:

Skin forming within approx. 20-40 min at 23 °C and 50 % RH and for the transparent Approx. 3-5 min. at 23 °C and 50 % RH.

Coloured: 2 mm/24 hours at 23 °C and 50 % RH.

Transparent: approx. 2.5 mm/day at 23 °C and 50 % RH.

10 mm/week at 23 °C and 50 % RH.

The curing time is slowed down at lower temperatures and lower relative humidity.

### Treatment:

After curing Combi Flex 524 can be painted with most types of paint. Because of the many different products in the market, we recommend tests to be carried out. Especially when using slow curing alkyd paints or varnishes. For optimum bonding we recommend that the cured joint is cleaned with ethanol prior to painting, especially if it takes a period before painting will begin.

After curing, the sealant can be sanded, e.g. when used in flooring joints.

### Cleaning:

Tools can be cleaned - and sealant removed with e.g. heptane or white spirit.

Cured sealant can only be removed mechanically.

Hands should be washed with water and soap.

## Health and safety:

For further information on safety, refer to product safety data sheet.

The information and data contained in this Product Information sheet are based on extensive laboratory testing and our practical experiences and are meant for helping the user to find optimum working methods. As the conditions at the user are beyond our control, we make no warranties concerning the results, achieved by the products. The information's in this Product Information sheet are typical values, intended as a guideline. They should not be regarded as product specifications. Please also refer to our standard sales conditions and terms of delivery.

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