



Bostik

SEAL N FLEX[®] AUTO & MARINE FC

FAST CURE POLYURETHANE ADHESIVE & SEALANT

20th August 2021

YOUR SMART ADVANTAGES

- Fast tack free time and cure speed
- Excellent adhesion and sealing properties
- Good chemical resistance
- Excellent water resistance
- Paintable
- May be used in contact with both sea and fresh water
- Excellent resistance to weathering and aging
- Exceptional noise vibration and impact dampening characteristics
- Internal and external application
- Slump resistant
- Resistant to fungal attack

DESCRIPTION

Bostik Seal N Flex[®] Auto & Marine FC is a high performance, fast cure polyurethane adhesive/sealant. **Bostik Seal N Flex[®] Auto & Marine FC** exhibits exceptional adhesion capabilities and is suitable for a wide range of industrial and automotive adhesion applications for internal and external uses.

USES

- Automotive structural adhesive in bus, truck and industrial vehicle assembly.
- Marine commercial and pleasure craft
- Air-conditioning and refrigeration industrial and commercial applications.
- Metal working, joining and sealing metal panels storage vessels, heavy shipping container vessels requiring sealing or panel installation.
- General industrial and maintenance.
- For bonding sheet metal, aluminum, stainless steel, ABS, GRP, Injection molding PU and PVC as well as timber.
- Mining applications where sealing of cavities (joints) and adhering panels.

CERTIFICATIONS

- AS 1527
- AS 4020
- ASTM D412
- ASTM C719
- ASTM C793

PRODUCT CHARACTERISTICS

Viscosity	Non-sag, smooth thixotropic paste
Cure method	Moisture curing
Application temperature	+5°C to +35°C
Stain and colour change	None

Product codes

300ml cartridge/ 20 per carton

Grey	30619339
White	30619347
Black	30619336

TYPICAL PERFORMANCE DATA (approx.)

Service temperature	-40°C to +80°C continuous
Tool working time	30 minutes
Skin time @ 25°C/50%RH	45 minutes
Full cure @ 25°C/50%RH	7 days
Specific gravity	1.23 g/ml
Shore A hardness	45-50
Elongation at 100% Modulus	> 450%
Tensile strength at break	> 2.5 N/mm ²
Chemical resistance	Resistant to dilute acids and alkalis, some solvents, intermittent contact with diesel and petroleum.

BOSTIK SEAL 'N' FLEX® AUTO & MARINE FC

DIRECTIONS FOR USE

Read and understand the Safety Data Sheet before using this product. SDS can be acquired by visiting www.bostik.com.au.

SURFACE PREPARATION

Clean all surfaces by removing foreign matter and contaminants such as oil, dust, grease, frost, water, surface dirt, old sealants and any protective coating.

Porous substrates should be cleaned by grinding saw cutting or blast cleaning (sand or water). Dust, loose particles, etc should be blown out of joints with oil free compressed air or vacuum cleaned.

Non porous and plastic surfaces should be cleaned by solvent or mechanical means. Cleaning solvents should not be allowed to air dry or evaporate without being wiped with a clean, dry cloth.

PRIMING

Porous substrates:

- Absorbent or porous substrates will allow a bead of water to easily soak into and wet out the surface of the substrate.
- For maximum performance on porous surfaces and, in all periodically immersed and submerged applications, use **Bostik N49 Primer**.
- Porous substrates not subject to immersion or ponded water, e.g. vertical expansion joints in concrete or masonry structures, do not require priming if clean, dry and uncontaminated.

Non-porous substrates:

- **Bostik N40 Primer** is recommended for non-porous plastic and metal substrates.
- Prime all plastics and metallic non-porous substrates with **Bostik N40 Primer** using the two-cloth method described below.
- e.g. UPVC outlets and pipe work: brass, copper fittings, stainless steel trays and flashings.

Two cloth method – N40 Primer application

- Dampen a clean and dry cloth with Bostik N40 Primer and spread evenly over the non-porous substrate using a cleaning/rubbing action.
- With a second clean and dry cloth, immediately wipe all primer residues off with a buffing action.
- Allow the substrate to dry for a minimum of 5 minutes before installing **Bostik Seal N Flex Auto & Marine FC**.
- Do not leave the primer longer than 4 hours before applying sealant/adhesive.
- Clean and re-prime if the primed surface is contaminated before **Bostik Seal N Flex Auto & Marine FC** is applied

APPLICATION

Bostik Seal N Flex Auto & Marine FC should be dispensed from the cartridge by means of a caulking gun.

Cartridge application:

1. Pierce the membrane at the top of the top of the cartridge and screw on the nozzle
2. Cut the nozzle to give the required angle and bead size

3. Place the cartridge in a caulking gun and squeeze the trigger

Apply a bead of **Bostik Seal N Flex Auto & Marine FC** to one surface to be bonded. Bring the opposite surface into contact with the wet adhesive and compress to give a glue line thickness of 1 to 2mm. Clamp together until cured, at least 8 hours at 20° to 25°C.

COVERAGE

The estimated lineal metre yield per pack size is recommended in the following table. The coverage is approximate and is dependent on substrate conditions.

	Lineal Meters		
	3mm bead	6mm bead	20mm bead
300ml Cartridge	43	10	2.3

PAINTABILITY

- **Bostik Seal N Flex Auto & Marine FC** can be painted after fully curing by most conventional coating systems including epoxy resins and acrylic coatings. Coatings containing high solvent contents such as gloss enamels or high oil-based undercoats may cause the surface of **Bostik Seal N Flex Auto & Marine FC** to react resulting in a tacky soft surface.
- A field test is recommended to ensure compatibility.
- To obtain best appearance and performance the paint must approximate the elongation capabilities of **Bostik Seal N Flex Auto & Marine FC**. Thin or watered down coatings will surface craze very quickly upon movement.
- For sections less than 3mm thickness **Bostik Seal N Flex Auto & Marine FC** may be painted over in 24 hours.
- For sections greater than 3mm thickness **Bostik Seal N Flex Auto & Marine FC** may be painted 48 hours after application.
- High build coatings with some elastomeric ability such as quality acrylic emulsions have the capability to absorb low movement without significant distortion of the paint film.
- For additional information contact a Bostik representative.

CLEANING

Clean off uncured material, hands and equipment immediately after use using **Bostik Handy Wipe towels**. Cured material can be removed by mechanical means only.

STORAGE AND SHELF LIFE

Store in cool (between 5°C to 20°C) dry, well-ventilated area out of direct sunlight. Shelf life is 12 months from production date in original unopened packaging and correct storage conditions.

VOC INFORMATION

78 g/L

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LIMITATIONS

- May be used for joints subjected to constant immersion in water, provided **Bostik Seal N Flex Auto & Marine FC** has achieved full cure (7 days at 20°C) prior to immersion.
- Do not apply **Bostik Seal N Flex Auto & Marine FC** to any material containing bitumen. **Do not** allow bitumen to contact **Bostik Seal N Flex Auto & Marine FC**.
- May be painted over after full cure however, **Bostik Seal N Flex Auto & Marine FC** is not recommended for use under solvent-based coatings such as gloss enamels. A field test is recommended to ensure compatibility.
- Should not be applied with wet tooling techniques. Using solvents, water, detergent or soap solutions is not recommended.
- Should not be applied to surfaces with special protective or cosmetic coatings such as mirrors, reflective glass surfaces coated with Teflon without prior consultation with a Bostik representative..
- Avoid contact with water prior to initial cure. **Bostik Seal N Flex Auto & Marine FC** can be affected by water before or during cure.
- Do not apply, store or cure **Bostik Seal N Flex Auto & Marine FC** in areas where unusually high humidity or free water are present during the application or initial cure.
- Should not be used in highly chlorinated areas such as swimming pools, spas etc without prior consultation with a Bostik representative.
- Do not apply at temperatures below 5°C and temperatures above 35°C
- Ensure cartridge temperature and contents are between 10°C and 30°C prior to applications. This will eliminate curing problems.
- Do not use alcohol based cleaners to prepare surfaces or to clean up uncured adhesive. Alcohols will inhibit the adhesives cure.
- Take care when using **Bostik Seal N Flex Auto & Marine FC** on 'colour bonded' or powder coated steel or aluminium. Always conduct tests to ensure adequate adhesion on the particular grade of metal to be used.
- As all substrates and conditions are different, it is strongly recommended that the applicator or end user conducts their own tests and ensure the product meets their own end use requirements.

BOSTIK HOTLINE

Smart help 1800 267 845



This datasheet is for the general help of users. It is provided in good faith. The data is current and accurate to the best of our knowledge. Differing materials, substrates, environments, site conditions, and product storage, handling and application may affect results. Users should carry out tests to decide the product's suitability for purpose. This data sheet and the properties of the product may change without notice. Users, suppliers and retailers should check that the data sheets they have are the latest. To the maximum extent permitted by law, Bostik disclaims all warranties in relation to manufacture and use of the product. Bostik is not liable for representations made by users, suppliers or retailers about the product. Bostik is not liable for any loss or damage resulting from incorrect, careless, or negligent use or storage of the product, including use of out of date product. Any liability arising from use of the product is limited to the replacement or purchase price of the product. Bostik does not exclude rights and remedies that cannot be excluded by legislation, for example under the Australian Consumer Law (ACL). Sale of the product by Bostik is subject to the Bostik Australia Proprietary Limited Conditions and Terms of Sale. For more information on Bostik, products, and conditions of use and sale visit www.bostik.com/au