

# HEGSEL® Flex 510

Low-Emission Polyurethane Coating

*You Build, We Protect!*

**Description:**

**HEGSEL Flex 510** is a low-emission, free-flow, two-component and flexible polyurethane coating suitable for smooth, energy-elastic coatings, as well as for slip resistant scattered coatings.

The coating has good flow and smoothing properties and cures with almost no shrinkage. The cured coating is hard and tough but also flexible and resistant to mechanical load.

**HEGSEL Flex 510** offers special advantages where increased flexibility is necessary due to, e.g. substrate susceptible to deformation, like mastic asphalt, flake boards, metallic and reconstruction substrate.

The resistance to chemicals like water, salt solutions, diluted acids and alkalis, mineral oil, and diesel fuel is sufficient. For organic acids, polyurethane coatings offer special advantages.

**Note:** **HEGSEL Flex 510** is available in different colours. Even though due to its chemical structure the material is not resistant to yellowing. Slight colour tone alteration is possible. Please note our general recommendation on colour / colour tones. Pale colours should be additionally sealed with colour stable **HEGSEL Flex 537**.

**Attention:** Sealers are suitable only to a limited extent for forklift-traffic. Please seek advice. Indentions cannot be excluded for concentrated point load.

**Characteristics:**

- Solvent-free
- Smooth, pigmented surfaces
- Suitable for scattering with silicium carbide/delustering agent
- Free of deleterious substances against varnish
- Elastic deformation
- Resistant to hydrolysis and Saponification
- For reconstruction work
- Ready-to-use

**Applications:**

- Low-emission coating for recreation rooms according to AgBB.
- Suitable for commercially used areas with average mechanical load, e.g., production and storage areas in many economic sectors (2 mm coating).
- Base and top coats for slip resistant scattered coatings in layers of 3 - 5 mm.
- Commercially used areas with mechanical load, minor exposure to chemicals and water.
- Smooth and slightly scattered wear layers (scattered with delustering agent or silicium carbide).
- Used on substrates susceptible to deformation like mastic asphalt, metallic, wooden, and mixed substrate.

**Application Data:**

<b>Mixing Ratio</b>	<b>Parts by Weight</b> <b>Parts by Volume</b>	A : B = 5 : 1 A : B = 100 : 25		
<b>Processing Temperature</b>	Minimum 10°C (room -and floor- temperature)			
<b>Further Coatings</b>	After 18 - 24 hours, but not longer than 48 hours at 20°C			
<b>Consumption</b>	2.2 - 3.3 kg/m <sup>2</sup>			
<b>Thickness of Layers</b>	1.5 - 2.5 mm			
<b>Addition of Quartz Sand</b>	Starting at layers of 2 mm up to 30 % depending on usage and temperature			
<b>Colours</b>	Colours available on request!			
	<b>@Temperature</b>	<b>10°C</b>	<b>20°C</b>	<b>30°C</b>
<b>Curing Time</b>	<b>Accessibility</b>	24 - 36 hrs	18 - 24 hrs	14 - 18 hrs
	<b>Mechanical Load</b>	-	2 - 3 days	-
	<b>Chemical Load</b>	-	7 days	-
<b>Processing Time</b>		45 min	25 min	15 min

**Packaging:**

Hobbock-Combi 30 kg

**Storage:**

12 months in sealed original containers under dry and cool conditions between 10 - 20 °C. Tightly re-seal opened containers and use the content as soon as possible. Protect from heat and freeze!

## 1. Build-up of Coats

### Substrate preparation – mineral substrate

- Prepare the substrate, like e.g. concrete, cement screed or other mechanically, e.g. by shot-blasting.

### Substrate preparation without in-between sanding

- Prime with the recommended HEGGEL-Base Coats: **HEGGEL Pox 410**, **HEGGEL Pox 481**, **HEGGEL Pox 415**, consumption: 0.3 - 0.4 kg/m<sup>2</sup>. For low-emission coatings use the recommended base coat **HEGGEL Pox 481**.
  - Optional: Scratch coat application with **HEGGEL Pox 410**, **HEGGEL Pox 481**, **HEGGEL Pox 415**, and **HEGGEL quartz sand-mix 2/1**, mixing ratio 1 : 0.8 parts by weight, consumption approx. 0.8 - 1.2 kg/m<sup>2</sup> of the mixture.
  - Alternatively, a scratch coat with **HEGGEL Flex 510** or **HEGGEL Flex 511** in addition of approx. 20 - 30 % quartz sand 0.1 / 0.3 mm, consumption approx. 0.8 - 1.0 kg/m<sup>2</sup> may be applied right after the base coat application without scattering.
- Important note:** Only when using the base coats **HEGGEL Pox 410** or **HEGGEL Pox 481**, **HEGGEL Flex 510** may be applied after a curing time of at least 14 up to 48 hours at the max. (at 20 °C) without any in-between sanding. When using **HEGGEL Pox 415**, **HEGGEL Flex 510** may be applied on the nonporous surface after a curing time of 4 to 24 hours at the max (at 20 °C). In-between sanding **is mandatory** when using other base coats or time cycles.
  - Apply **HEGGEL Flex 510** with a toothed trowel, consumption 2.3 - 2.6 kg/m<sup>2</sup>. Vent after 10 to 20 minutes with a spiked roller.

### Substrate preparation – mastic asphalt

- Prepare substrate mechanically by shot blasting.
- Apply a scratch coat using **HEGGEL Flex 511** or **HEGGEL Flex 510** in addition of 20 - 30 % quartz sand, grain size 0.1 / 0.3 mm, consumption approx. 0.8 - 1.0 kg/m<sup>2</sup>. Subsequent coatings may be applied when the surface is free of pores.
- Apply **HEGGEL Flex 510** with a toothed trowel, consumption 2.3 - 2.6 kg/m<sup>2</sup>. Vent after 10 - 20 minutes with a spiked roller.

### Decorative, low-emission top sealer

For decorative coatings seal with the covering sealer **HEGGEL Flex 537**. **Low-emission when used within the system**, consumption 0.150 - 0.180 kg/m<sup>2</sup>. By adding **HEGGEL anti-slip additive** the slip

resistance grade can be adjusted up to R11.

### Substrate preparation with in-between sanding

- Prime with one of the other epoxy resin base coats: consumption 0.3 - 0.4 kg/m<sup>2</sup>.
- Scatter the fresh surface with quartz sand 0.3 / 0.8 mm, consumption approx. 0.5 - 1.0 kg/m<sup>2</sup>.
- Apply a scratch coat using **HEGGEL Flex 511** or **HEGGEL Flex 510** right on top. Add approx. 20 - 30 % quartz sand 0.1 / 0.3 mm, consumption approx. 0.8 - 1.0 kg/m<sup>2</sup>. For subsequent coatings the surface has to be free of pores.
- Apply **HEGGEL Flex 510** with a toothed trowel, consumption 2.3 - 2.6 kg/m<sup>2</sup>. Vent after 10 - 20 minutes with a spiked roller.

## 2. Surface Preparation

The substrate to be coated has to be levelled, dry, free of dust, has to have adequate tensile and compressive strength, and be free from weakly-bonded components or surfaces. Materials impairing adhesion, such as grease, oil, and paint residues must be removed using suitable methods. Please refer to the product information of the recommended HEGGEL-Base Coats, like e.g., **HEGGEL Pox 410**, **HEGGEL Pox 412**, **HEGGEL Pox 481**, or **HEGGEL Pox 416**. The surface to be coated should be prepared mechanically, preferably by shot-blasting. The prepared area has to be primed accurately, saturated, and free of pores. Estimating the substrate according to the necessary sealed state may be difficult, so a scratch coat is recommended for smoothing the surface. If the substrate hasn't been sealed completely bubbles and pores may appear because of rising air. Conduct a trial if in doubt. To improve adhesion, scatter the surface with approx. 0.5 - 1.0 kg/m<sup>2</sup> quartz sand, grain size 0.3 / 0.8 mm.

**Mastic asphalt:** A scratch coat using **HEGGEL Flex 510** may be applied straight on top. Prime steel substrate using **HEGGEL Pox 412**, flake boards with **HEGGEL Pox 410** and scatter with quartz sand, grain size 0.3 / 0.8 mm.

## 3. Mixing

Combi-trading units will be supplied in the correctly measured mixing ratio. Component A has sufficient volume for the entire trading unit. Decant the hardener compound B into the resin. Blend with a slow speed mixer (200 - 400 rpm) for at least 2 - 3 minutes, for a material that is homogeneous and free of streaks. To avoid mixing errors it is recommended to empty the resin / hardener mixture into a clean container and mix briefly once again ("to report"). Stir up the single components for

partial withdrawals and weigh for the exact mixing ratio.

## 4. Processing / Handling

Process the material immediately after mixing with a coating knife or trowel by applying an even layer on the prepared surface. The product is adjusted with an optimum of air venting. To upgrade the moistening of the substrate, optimizing the flow-properties, and removing any air blows, it is recommended to roll with a spiked roller. Roll time- delayed after 10 - 15 minutes with the spiked roller. Divide working areas before starting work and always work "fresh-in-fresh" to avoid any shoulders. Do not scatter too early because of air venting, optimum point of time is after 15 - 30 minutes at 20 °C.

Floor -and air- temperature must not fall below 10 °C and humidity must not exceed 75 %. The material to be processed has to be tempered according to the room-temperature. The floor temperature may be 3°C at the max. less than the surrounding temperature to exclude a dew-point situation on the surface and on the fresh coating. If a dew-point situation occurs, curing may be disturbed and foaming may occur.

Do not process at increased insolation or on strongly heated surfaces because processing time will decrease and blisters may appear. Fresh polyurethane coatings are susceptible to humidity. Keep within the recommendations for humidity.

Coating dewy substrate, using moist sand, as well as sweat will lead to foaming of the material and have to be avoided.

Curing time applies to 20 °C. Lower temperature may increase, higher temperature may decrease the curing and processing time. Ensure of recommended processing conditions during curing. If working conditions are not complied with, deviations in the described technical properties may occur in the end product.

## 5. Cleaning

To remove fresh contamination and to clean tools use **Cleaner V30** or **V40** immediately. Hardened material can only be removed mechanically.

## 6. Safety Measures

The product is subject to the hazardous material, operational safety and transport regulations for hazardous goods. Refer to the DIN-Safety Data Sheet and the information on the labelled containers!

**GISCODE: PU 40**

## 7. Indication of VOC-Content

(EG-Regulation 2004/42)

Maximum Permissible Value 500 g/L (2010,II,j/lb): Ready-for-use product contains < 500 g/L VOC.

## Technical Data

Title	Standard	Value	Unit
Viscosity (Components A + B)	DIN EN ISO 3219 (23 °C)	3700	mPas
Solids Content	HEGCEL- Method	100	%
Density (Components A + B)	DIN EN ISO 2811-2 (20 °C)	1.45	kg/L
Weight Loss	After 28 days	0.3	Weight %
Water Absorption	DIN 53515	< 0.2	Weight %
Bending Tensile Strength	DIN EN 196/1	40	N/mm <sup>2</sup>
Tensile Strength	DIN EN ISO 527	25	N/mm <sup>2</sup>
Max. Tear Growth Resistance	DIN ISO 34-1	76	kN/m
Compressive Strength	DIN EN 196/1	45	N/mm <sup>2</sup>
Breaking Elongation	DIN EN ISO 527-3	52	%
Shore Hardness D	DIN 53505 (7 days)	65	-
Abrasion (Taber Abraser)	ASTM D4060	55	mg

**Note:** Values achieved in sampling are average values. Variation in product specification is possible.

**HEGCEL Flex 510;** Revision No: 1.10 / Last Revision Date: 11.10.2023

All information contained herein is based on the current state of our knowledge and practical experience at the time of release. Therefore, please make sure that this is the latest edition of the Technical Data Sheet. All data are only intended as a guideline for informational purposes and do not constitute a legally-binding warranty of the suitability for a certain purpose of use, due to its dependence on site conditions and possible processing, use and applications. All information contained in this technical datasheet is subject to change without notice.

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