



Flexane® 94 Liquid

Description: A low-viscosity, castable, non-shrinking urethane compound.

Intended Use: Reproduce low- to medium-volume or discontinued rubber parts; form flexible molds and nonscratching holding fixtures/linings; encapsulate wire and electronics subject to impact, vibration, expansion, and contraction.

Product features: **Room temperature curing urethane/no heat required**
Mixes and pours easily
5-hour demolding time

Limitations: None

Technical data should be considered representative or typical only and should not be used for specification purposes.

Typical Physical Properties:

Cured 7 days @ 75° F

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|--------------------------------------|---------------------------------------|
| Abrasion Resistance | 330 mg loss per 1,000 revolt |
| Color | Black |
| Coverage/lb | 106 sq.in./lb.@ 1/4" |
| Cured Hardness | 97A |
| Cured Shrinkage | .0014 in.in. |
| Demolding Time | 5 hrs. |
| Dielectric Strength | 350 volts/mils |
| Functional Cure | 16 hours |
| Maximum Elongation | 500% |
| Maximum Operating Temperature | Dry: 180°F; Wet: 120°F |
| Mix Ratio | 69 resin:31 curing agent / wt. |
| Mixed Viscosity | 6,000 cps |
| Percent Solids by Volume | 100 |
| Pot Life | 10 min. @ 75°F |
| Specific Volume | 26.5 in.(3) /lb. |
| Tear Resistance | 415 pli |
| Tensile Strength | 2,800 psi |

TESTS CONDUCTED

Dielectric Strength, volts/mil ASTM D 149
 Tensile Strength (Urethanes) ASTM D 412
 Maximum Elongation ASTM D 412
 Cure Shrinkage ASTM D 2566
 Tear Resistance ASTM D 624
 Cured Hardness Shore D ASTM D 2240

Surface Preparation:

For METAL SURFACES, thoroughly clean area to be repaired, rebuilt, or lined with Devcon® Cleaner Blend 300. Remove any oil, grease, or dirt. Roughen surface by grinding with a coarse wheel or an abrasive disc pad. To prime this surface, apply a coat of Devcon FL-10 Primer and allow to dry tack-free for 5-15 minutes. If the metal surface requires maximum tear resistance or is exposed to moisture, or if submerged in water, use Devcon® FL-10 and Devcon® FL-20 Primer.

For RUBBER SURFACES, thoroughly clean area with an abrasive pad and Devcon® Cleaner Blend 300. Surface can also be roughened with a grinding wheel so that it is coarse and free from oil and dirt that may clog the "pores" of the rubber. Wipe or roughen surface with Cleaner Blend 300 until the cloth no longer picks up the color of the rubber. The rubber should appear new or deeper in color. To prime this surface, apply a coat of Devcon® FL-20 Primer and allow to dry tack-free for 15-20 minutes. Use Devcon® FL-40 Primer on "hard-to-bond" rubber surfaces as this gives ultimate peel resistance. Multiple coats may be necessary for porous rubber surfaces.

For MAXIMUM ADHESION, sandblast the surface with an angular abrasive until a minimum depth profile of 2-3 mils is met. Blast to near-white finish specification SSPC-SP5 (Steel Structure Painting Council). Prime surface immediately after sandblasting to prevent oxidation.

Mixing Instructions:

---- To ensure proper cure speeds and hardness, mix Flexane at a temperature between 65°F-85°F. ----

FOR 1 LB. UNITS

1. Add hardener to resin.
2. Vigorously mix with screwdriver or spatula for two minutes, while continuously scraping material away from sides and bottom of container.
3. Transfer the mixed material to the plastic container (included in kit).
4. Wipe spatula clean, and stir again for two more minutes.

FOR 400ML CARTRIDGES:
1. Attach mix nozzle to cartridge
2. Follow application instructions; no mixing is required.

FOR 10LB. UNITS:
Use a propeller-type Jiffy Mixer Model ES on an electric drill.

Mix until color is uniform and consistent (approx 4-6 min.).

NOTE: Completely submerge propeller, otherwise large amounts of air will be added resulting in air bubbles on the finished product's surface.

Application Instructions:

---- FOR MAXIMUM ADHESION, apply a suitable Devcon primer to all substrates prior to application. ----

Metals FL-10 Primer
Rubber FL-20 Primer
Wood FL-20 Primer
Fiberglass FL-20 Primer
Concrete FL-20 Primer
Rigid Plastics FL-20 Primer (2 coats)

1. Brush a thin coat of Flexane over the substrate, then pour from one side of the mold to the other side, so as to evacuate any air as the Flexane fills the area.
2. Gently blow hot air over the finished surface to ensure a perfect mold with no blow holes or air entrapment. Use a hot air gun and gently wave over the surface to break all the air bubbles.
3. Allow to cure six (6) hours before returning equipment to light service. The repair may then be ground flush using a 24 or 36 grit sanding disc. Do not overheat the work surface. Full cure takes seven (7) days @ 70°F.

ADDITIONAL INFORMATION

Flexane Accelerator is used to increase Flexane's cure speed at temperatures as low as 32°F. One-half tsp. (2 gms) of Accelerator reduces the cure time of 1 lb. of Flexane by 50%. Use 2 tsp. or less of Accelerator for each 1 lb. of Flexane. See Flexane Accelerator TDS for further information.

Storage:

Store at room temperature, 70 °F.

Compliances:

None

Chemical Resistance:

Chemical resistance is calculated with a 7 day, room temp. cure (30 days immersion) @ 75°F

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| 1,1,1-Trichloroethane | Poor | Phosphoric 10% | Very good |
| Aluminum Sulfate 10% | Very good | Potassium Hydroxide 40% | Very good |
| Cutting Oil | Fair | Sodium Hydroxide 50% | Very good |
| Gasoline (Unleaded) | Poor | Sodium Hypochlorite | Very good |
| Hydrochloric 10% | Very good | Xylene | Poor |
| Hydrochloric 36% | Very good | | |
| Isopropanol | Poor | | |
| Methyl Ethyl Ketone | Poor | | |

Precautions:

Please refer to the appropriate safety data sheet (SDS) prior to using this product.

For technical assistance, please call 1-855-489-7262

FOR INDUSTRIAL USE ONLY

Warranty:

ITW Performance Polymers will replace any material found to be defective. Because the storage, handling and application of this material is beyond our control, we can accept no liability for the results obtained.

Disclaimer:

All information on this data sheet is based on laboratory testing and is not intended for design purposes. ITW Performance Polymers makes no representations or warranties of any kind concerning this data.

Order Information:

15250 1 lb. kit
15260 10 lb.