### TECHNICAL DATASHEET – GFR40

GFR40 IS A TWO-COMPONENT ELASTOMERIC SELF-LEVELLING RUBBER SYSTEM

#### ORDERING INFORMATION

**STOCK NO.:** 96000  
**PACKAGE SIZE:** 3kg

#### DESCRIPTION

GFR40 is a two-component elastomeric self-levelling rubber system uniquely designed to provide flame retardant in-situ gaskets.

#### RECOMMENDED APPLICATIONS

Material ideal for casting, moulding and potting applications

#### APPROVAL

NATO Approved (Stock No. 3709505)

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#### PRODUCT DATA

**TYPICAL PHYSICAL PROPERTIES**

<table>
<thead>
<tr>
<th>Property</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>COLOUR</strong></td>
<td>Battleship Grey</td>
</tr>
<tr>
<td><strong>MIX RATIO BY WEIGHT</strong></td>
<td>88.5 : 11.5</td>
</tr>
<tr>
<td><strong>MIX RATIO BY VOLUME</strong></td>
<td>5.37 : 1</td>
</tr>
<tr>
<td><strong>POT LIFE AT 25°C / MINUTES</strong></td>
<td>15-25</td>
</tr>
<tr>
<td><strong>DENSITY / G/CM³</strong></td>
<td>1.57</td>
</tr>
<tr>
<td><strong>FUNCTIONAL CURE TIME / HOURS</strong></td>
<td>24</td>
</tr>
<tr>
<td><strong>TENSILE STRENGTH / MPA</strong></td>
<td>1</td>
</tr>
<tr>
<td><strong>ELONGATION / %</strong></td>
<td>500</td>
</tr>
</tbody>
</table>
APPLICATION INFORMATION

CURE
Allow GFR40 to cure 24 hours before running moulds in operation.

SURFACE PREPARATION

METAL SURFACES: Thoroughly clean the area that is to be repaired, rebuild or lined by using Devcon Fast Cleaner 2000 Spray/Cleaner Blend 300. All oil, grease and dirt must be removed before applying GFR40 material. All surfaces must be roughened by grinding with a coarse wheel or an abrasive disc pad.

RUBBER SURFACES: Thoroughly clean the rubber area with an abrasive pad and Devcon Fast Cleaner 2000 Spray/Cleaner Blend 300. You may take a grinding wheel and roughen surface until the colour of the rubber substrate no longer appears on cloth. The rubber should look new or a deeper black in colour.

CONCRETE SURFACES: Concrete being a very porous substrate requires multiple cleaning. Degrease the area with Devcon Fast Cleaner 2000 Spray/Cleaner Blend 300 and rinse the area. A power washer or steam cleaner is useful for quicker and efficient cleaning. Let the floor dry thoroughly before applying Primer and GFR40.

PRIMING SURFACES: Metal Surfaces: On metal surfaces apply two coats of FL-10 Primer and allow to dry tack free for 15 minutes.

RUBBER SURFACES: On rubber and urethane surfaces apply a coat of FL-20 Primer and allow to dry tack free for 15 - 20 minutes. On porous rubber surfaces, it may be necessary to do multiple coats.

CONCRETE SURFACES: Concrete being a “porous” substrate may need multiple coats for proper adhesion. Let Primer dry for 30 minutes between coats.

WOOD & FIBREGLASS: Use FL-20 Primer for all wood and fibreglass products. The softwoods will need two coats because of their absorption characteristics.

IMMERSION SUBSTRATES: Use both Primers, FL-10 and FL-20 to coat any metal substrate that will be immersed in any aqueous solution. First apply the FL-10 Primer and let it dry for 60 minutes. Next coat with FL-20 Primer. Let it dry for 30 minutes before applying the GFR40 material.

MIXING
Add curing agent to the GFR40 resin container and stir vigorously for 2 minutes. Ensure that the two parts are fully mixed by scraping along the bottom and side of the container. For quantities larger than 500g use an electric drill and mixer to mix the GFR40 material. Make sure the mixer attachment is completely submerged during the mixing process. If not you will be mixing in large amounts of air and this will sometimes cause bubbles in the finished product.

APPLICATION MOULDMAKING
• First ensure good surface preparation and coat the entire “box” with Devcon’s Release Agent. Let it dry for 10 minutes. Apply a second coat, and let this dry for 10 minutes.
• Now take a small brush and apply a thin coat of mixed product over the surface. This helps to alleviate any “air bubbles” in the curing process.
• Then pour the liquid into the “box”. It is recommended to tilt the “box” slightly onto one side when pouring to let the air escape easily and produce no “blow holes” in the finished product.
• After the GFR40 has been poured, it helps to “wave” a hot air gun back and forth over the top of the mould to help release air bubbles that want to get to the surface.

SHELF LIFE & STORAGE
A shelf life of 2 years from date of manufacture can be expected when stored at room temperature (22ºC) in their original containers.

PRECAUTION
For complete safety and handling information, please refer to Material Safety Data Sheets prior to using this product.

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.

For product information visit www.devconeurope.com alternatively for technical assistance please call +353 61 771 500.