Flexane® Fast Cure Rubber Repair Liquid

Description: A fast-curing, trowelable liquid urethane for repairing rubber equipment and filling expansion joints.

Intended Use: Repair worn or damaged rubber equipment; form protective linings in equipment subject to wear, impact, abrasion, vibration, expansion, and contraction.

Product features:
- 400 ml reusable cartridge
- Tack-free in 30 minutes
- Fast, easy, no-mess dispensing
- Thorough mixing of two components with automatic mix nozzle

Limitations:

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.

Technical Data Sheet
8/2/2019

Cured 7 days @ 75° F

<table>
<thead>
<tr>
<th>Property</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Abrasion Resistance</td>
<td>330 mg loss per 1,000 revolutions</td>
</tr>
<tr>
<td>Color</td>
<td>Grey</td>
</tr>
<tr>
<td>Coverage/lb</td>
<td>106 sq.in./lb. @ 1/4”</td>
</tr>
<tr>
<td>Cured Hardness</td>
<td>94A</td>
</tr>
<tr>
<td>Cured Shrinkage</td>
<td>0.0018 in./in.</td>
</tr>
<tr>
<td>Dielectric Strength</td>
<td>350 volts/mils</td>
</tr>
<tr>
<td>Functional Cure</td>
<td>2 hrs.</td>
</tr>
<tr>
<td>Maximum Elongation</td>
<td>450%</td>
</tr>
<tr>
<td>Maximum Operating Temperature</td>
<td>Dry: 180°F; Wet: 120°F</td>
</tr>
<tr>
<td>Mix Ratio</td>
<td>80 resin:20 curing agent /wt.</td>
</tr>
<tr>
<td>Mixed Viscosity</td>
<td>5,800 cps</td>
</tr>
<tr>
<td>Percent Solids by Volume</td>
<td>100</td>
</tr>
<tr>
<td>Pot Life</td>
<td>8 min. @ 75°F</td>
</tr>
<tr>
<td>Specific Volume</td>
<td>26.5 in.(3)/lb.</td>
</tr>
<tr>
<td>Tear Resistance</td>
<td>430 pli</td>
</tr>
<tr>
<td>Tensile Strength</td>
<td>3,300 psi</td>
</tr>
</tbody>
</table>

TESTS CONDUCTED

- Cure Shrinkage ASTM D 2566
- Dielectric Strength, volts/mil ASTM D 149
- Tear Resistance ASTM D 624
- Cured Hardness Shore D ASTM D 2240
- Tensile Strength (Urethanes) ASTM D 412
- Maximum Elongation ASTM D 412
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:
1. Mount cartridge onto manual gun (#15043).
2. Attach #15047 mix nozzle.
3. Clip mix nozzle back to desired orifice size.
4. Squeeze cartridge, allowing first THREE INCHES of material to discharge until a unified mix is exuding from nozzle (color is uniform with no striations).
5. Finish application as quickly as possible.

IMPORTANT:
Replace mix nozzle every four minutes to ensure complete mix, with no soft spots. Because of the short pot life (8 minutes), stopping between uses can result in Flexane product curing IN the mix nozzle. Further mixing will be off ratio.

Storage:
Store at room temperature, 70 °F.

Compliances:
None

Chemical Resistance:

<table>
<thead>
<tr>
<th>Chemical Resistance</th>
<th>1,1,1-Trichloroethane</th>
<th>Aluminum Sulfate 10%</th>
<th>Cutting Oil</th>
<th>Gasoline (Unleaded)</th>
<th>Hydrochloric 10%</th>
<th>Hydrochloric 36%</th>
<th>Isopropanol</th>
<th>Methyl Ethyl Ketone</th>
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</thead>
<tbody>
<tr>
<td></td>
<td>Poor</td>
<td>Very good</td>
<td>Fair</td>
<td>Poor</td>
<td>Very good</td>
<td>Very good</td>
<td>Poor</td>
<td>Poor</td>
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<tr>
<td>Phosphoric 10%</td>
<td>Very good</td>
<td></td>
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<tr>
<td>Potassium Hydroxide 40%</td>
<td>Very good</td>
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<tr>
<td>Sodium Hydroxide 50%</td>
<td>Very good</td>
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<tr>
<td>Sodium Hypochlorite</td>
<td>Very good</td>
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<tr>
<td>Xylene</td>
<td>Poor</td>
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</table>

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

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:
15050        400 ml cartridge