



Flexane® Fast Cure Rubber Repair Liquid

- Description:** A fast-curing, trowelable liquid urethane for repairing rubber equipment and filling expansion joints.
- Intended Use:** Industrial Use: Repair worn or damaged rubber equipment; form protective linings in equipment subject to wear, impact, abrasion, vibration, expansion, and contraction.
- 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:** Suitability of product is determined by the end user for their application and process.

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 (24°C)	Typical Values	Standard Tests
Abrasion Resistance	330 mg loss per 1,000 revol.	Cure Shrinkage ASTM D 2566
Cured Shrinkage	0.0018 in/in (cm/cm)	Dielectric Strength, volts/mil ASTM D 149
Dielectric Strength	350 volts/mil	Tear Resistance ASTM D 624
Hardness	94 Shore A	Cured Hardness Shore D ASTM D 2240
Maximum Elongation	450%	Tensile Strength (Urethanes) ASTM D 412
Maximum Operating Temperature	Dry: 180°F (82°C); Wet: 120°F (49°C)	Maximum Elongation ASTM D 412
Percent Solids by Volume	100	
Tear Resistance	430 pli (75 N/mm)	
Tensile Strength	3,300 psi (23 MPa)	
Uncured Properties @ 72°F (23°C)		
Color	Grey	
Coverage (1/4" / 6.35mm)	106 in ² /lb (1508 cm ² /Kg)	
Functional Cure	2 hrs.	
Mix Ratio	80 resin: 20 curing agent by weight	
Mixed Viscosity	5,800 cP	
Pot Life	8 min. @ 75°F (24°C)	
Specific Volume	26.5 in ³ /lb (0.957 cm ³ /g)	

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 (18 - 29°C). ----

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. NOTE: Flexane putties will thicken rapidly during these first two minutes of mixing, but this DOES NOT mean that the polymer is curing.
- 3.Transfer the mixed material to the plastic container (included in kit).
- 4.Wipe spatula clean, and stir again for two more minutes.
- 5.Continue to mix until a uniform, streak-free consistency is obtained.

FOR 400ML CARTRIDGES:

- 1.Attach mix nozzle to cartridge
- 2.Follow application instructions; no mixing is required.

FOR 10 LB. UNITS:

Use a propeller-type Jiffy Mixer Model ES on an electric drill.

Mix until color is uniform and consistent (approx. 4-6 min.), while continuously scraping material away from sides and bottom of container.

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) or pneumatic gun (#15041).
2. Attach #15047 mix nozzle (used with both cartridges).
3. Clip mix nozzle back to desired orifice size.
4. Squeeze cartridge, allowing first 3 inches (71 mm) 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 (21°C)

Compliances:

None

Chemical resistance is calculated with a 7-day, room temp. cure (30 days immersion) @ 75°F (24°C)

Chemical Resistance:

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		
Isopropyl	Poor		
Methyl Ethyl Ketone	Poor		

Precautions:

FOR INDUSTRIAL USE ONLY: Please refer to the appropriate Safety Data Sheet 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.

Order Information:

<u>Item No.</u>	<u>Package Size</u>
15050	400 ml cartg.

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Disclaimer:

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