



Flexane[®] Fast Cure Rubber Repair Putty

Description:	A fast-curing, flexible urethane for repairing rubber equipment.
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:	Fast cure, Room temp.
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
Abrasion Resistance	220 mg loss per 1,000 revol.
Dielectric Strength	350 volts/mil (13.78 Kv/mm)
Hardness	98 Shore A
Maximum Elongation	500%
Maximum Operating Temperature	Dry: 180°F (82°C); Wet: 120°F (49°C)
Percent Solids by Volume	100
Tear Resistance	275 pli (48 N/mm)
Tensile Strength	2,400 psi (16.5 MPa)

Standard Tests

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

Uncured Properties @ 72°F (23°C)

Color	Black
Coverage (1/4" / 6.35mm)	94 in2/lb (1337 cm2/kg)
Cured Shrinkage	0.0014 in/in (cm/cm)
Functional Cure	3 hrs.
Light Duty Service	2 hrs
Mix Ratio	80 resin:20 curing agent /wt
Mixed Viscosity	Thixotropic paste
Pot Life	8 min. @ 75°F (24°C)
Specific Volume	23.5 in3 /lb (0.849 cm3/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°C to 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 4 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.

FOR 400 ml cartgs.

- Application**
1. Mount cartridge onto manual gun (#15043) or pneumatic gun (#15041).

Instructions:	2. Attach #15047 mix nozzle (used with both cartridges).	
	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 (21°C)	
Compliances:	None	
Chemical Resistance:	Chemical resistance is calculated with a 7-day, room temp. cure (30 days immersion) @ 75°F (24°C)	
	1,1,1-Trichloroethane	Poor
	Aluminum Sulfate 10%	Very good
	Cutting Oil	Fair
	Gasoline (Unleaded)	Poor
	Hydrochloric 10%	Very good
	Hydrochloric 36%	Very good
	Isopropyl	Poor
	Methyl Ethyl Ketone	Poor
	Phosphoric 10%	Very good
	Potassium Hydroxide 40%	Very good
	Sodium Hydroxide 50%	Very good
	Sodium Hypochlorite	Very good
	Xylene	Poor
Precautions:	FOR INDUSTRIAL USE ONLY: Please refer to the appropriate <u>Safety Data Sheet</u> 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> 15049	<u>Package Size</u> 400 ml cartg.
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