FLEXANE 60 LIQUID

PRODUCT INFORMATION

Stock No.	Package Size
15200	500g
15210	5Kg

Description

A tough pourable rubber compound for part encapsulation, rugged flexible moulds and patterns, holding fixtures and forming die pads. It can also used to form equipment linings that are abrasion resistant and noise reducing.

Recommended Applications

- Pads for press brake forming
- Lines process equipment to dampen noise
- Protects equipment surfaces from wear and corrosion
- Pouring concrete expansion joints
- Casting flexible parts and moulds

Flexibility

High

PRODUCT DATA

Typical Physical Properties

Colour	Black
Mix Ratio by Volume	1.6:1
Mix Ratio by Weight	1.67:1
% Solids by Volume	100
Pot life at 25°C (mins)	15
Specific Volume (cc/kg)	956
Cured Shrinkage (cm/cm)	0.0005
Specific Gravity	1.046
Temperature resistance	Wet 49°C Dry 82°C
Coverage	0.956m^2/Kg @ 1mm
Cured Hardness (Shore A)	65
Tensile Strength (MPa)	5.1
Tear Resistance (N/mm)	19
Elongation (%)	300
Dielectric Strength (kV/mm)	14
Thickness per Coat (mm)	As Required
Functional Cure Time (Hours)	16
Recoat Time (Hours)	12-24
Mixed Viscosity (cps)	5,000

Chemical Resistance

7 days room temperature cure (30 days) - Testing carried out 30 days immersion at 21°C

Ammonia	Very Good	Methylene Chloride	Poor
Cutting Oil	Fair	Sodium Hypochlorite 5% (Bleach)	Very Good
Isopropyl Alcohol	Poor	Sodium Hydroxide 10%	Very good
Gasoline (Unleaded)	Poor	Sulphuric Acid 10%	Very Good
Hydrochloric Acid 10%	Very Good	Xylene	Poor
Methyl ethyl Ketone (MEK)	Poor		

Excellent = +/- 1% weight change
Very Good = +/- 1-10% weight change
Fair = +/- 10-20% weight change
Poor = > 20% weight change

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APPLICATION INFORMATION

Cure	Allow the Flexane to cure for 6 hours before returning equipment to light service. Once cured, the repair may be ground flush using a 24 or 36 grit open coat-sanding disc. Be careful to keep the grinder moving and do not overheat the work surface. De-mould Flexane Liquids in approximately 5-10 hours.
Surface Preparation	**Metal Surfaces:** Thoroughly clean the area that is to be repaired, rebuilt or lined by using MEK, Acetone, IPA or similar. All oil, grease and dirt must be removed before applying Flexane 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 MEK, Acetone, IPA or similar. You may take a grinding wheel and roughen the surface. The rubber surface must be coarse and free from oil and dirt clogged in the ópores ôof the rubber. Using MEK, Acetone, IPA or similar, wipe or 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 MEK, Acetone, IPA or similar and rinse the area. A power washer or steam cleaner is useful for quicker and efficient cleaning. Let the floor dry thoroughly before applying the Primer and Flexane. **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 ï 20 minutes. On porous rubber surfaces, it may be necessary to do multiple coats. **Concrete Surfaces:** Concrete being a ñporousò 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 Fiberglass products. Softwoods will need two coats because of their absorption characteristics. **Immersion Substrates:** Use 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 Flexane material
Mixing	Add curing agent to the Flexane 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 Flexane 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 ñboxò with Devconôs 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 ñair bubblesò in the curing process. • Then pour the liquid into the ñboxò. It is recommended to tilt the ñboxò slightly onto one side when pouring to let the air escape easily and produce no ñblow holesò in the finished product. • After the Flexane has been poured, it helps to ñwaveò 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. • De-mould time is 8 hours when cured at room temperature.

Lining Applications/Noise Reduction

Flexane has an outstanding quality of having ñelasticityò This is beneficial for applications requiring impact resistance such as feeder bowls in production plants, chutes in cement, coal or mining plants and cyclones. Lining applications require a good depth of coating along with the proper primer for good adhesion.

- For good adhesion follow the cleaning method for the appropriate surface. A good surface profile is required for excellent adhesion.
- Abrade the surface of the wear area with an abrasive disc pad and clean thoroughly.
- Apply a coating of FL-10 Primer and allow it to dry thoroughly and follow with a coating of FL-20 Primer. Let it dry for 30 minutes before continuing.
- Before applying the Flexane material ensure the substrate has a defined ñbutt jointò Leaving an edge will create the possibility of the aggregate ñundercuttingòthe material. Apply the Flexane to the substrate. Apply at least 1/16òof the material if possible for better wear resistance to the substrate.

Note: Applying multiple coats to the substrate will ñbuild upòthe wearing ability of the coating. A thicker final coating will also provide additional impact absorption capabilities.

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 Devcon 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 Devcon makes no representations or warranties of any kind concerning this data.

For product information visit www.bigagroup.com / www.devconeurope.com alternatively for technical assistance please call +385 52 880 882 or send an e-mail to biga@biga.hr.