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TECHNICAL DATASHEET

FLEXI-TECH 60 E.G.

Two Component Solvent Free Polyurethane Elastomer



Thortex Flexi-Tech 60 E.G. is a 60 Durometer high performance paste grade elastomer which has been specifically developed for the repair of rubber components by trowel or putty knife and is suitable for use on impellers, chutes, hoppers, valves, rollers, gaskets, hoses, conveyor belts, off road tyres etc.

Thortex Flexi-Tech 60 E.G. is based on a complex blend of polyols and polyesters in combination with amine catalysts and activators to produce a cold vulcanising product with outstanding mechanical strength.

The properties of **Thortex Flexi-Tech 60 E.G.** have been designed to match factory produced rubbers.

Before proceeding, please read the following information carefully to ensure that the correct application procedure is fully understood.

SURFACE PREPARATION

All existing dirt, oil and grease should be removed and the surface wiped with **Thortex Universal Cleaner**.

Any areas of frayed or fragmented rubber should be cut away to provide a sound repair area.

Smooth surfaces, including metals, should be mechanically etched to produce a good profile, with abrasive blasting being preferred for metal substrates. Rubber surfaces are best roughened using a stiff wire brush / comb.

Edges of repair areas of belts, hoses, tyres etc. should be undercut.

All loose dust and particles should be blown clear of the prepared surface.

On certain repairs such as gaskets and castings where one surface is not required to bond to the **Thortex Flexi-Tech 60 E.G.**, these surfaces should be treated with **Thortex Release Agent**.

PRIMING

All areas to be repaired or resurfaced should be first primed with **Thortex Flexi-Tech Primer**.

The primer should be applied with a soft bristled brush to give an even, but low coating thickness, taking care to avoid ponding of the primer.

The primer should be allowed a minimum of 60 minutes and a maximum of 8 hours at 20°C before applying **Thortex Flexi-Tech 60 E.G.**

Where a faster drying primer is required **Thortex Flexi-Tech 60 R.G. Primer** can be used. Please refer to **Thortex Flexi-Tech 60 R.G. Tech Sheet**.

MIXING

Thortex Flexi-Tech 60 E.G. is a two component material which must be mixed together prior to use.

Two volumes of base and one volume of activator should be measured onto a clean surface and the two components mixed thoroughly to produce a smooth streak free material.

Thorough mixing is extremely important and once the material appears mixed, a further period of mixing should be carried out to ensure there is no unmixed material.

The mixed material should be used within 30 minutes of mixing at 20°C (68°F).

APPLICATION

The mixed material should be pressed firmly onto the prepared area working the product into cracks or defects on the surface. Where necessary, reinforcement tape should be bedded into the material and overlapped to provide multi-layer reinforcement.

All equipment must be cleaned IMMEDIATELY after use with **Thortex Universal Cleaner**.

Volume Capacity

910cc (55.5 cu ins) per kilo

Detailed working recommendations are available from the Technical Centre on request.

PHYSICAL CONSTANTS

Mixing Ratio	Base	Activator	
	2	1	By volume
	2	1	By weight

Appearance	Base	Activator
	Base	Opaque Paste
	Activator	Coloured Paste

Drying & Cure times at 20°C (68°F)	Usable Life	25 minutes
	Initial Set	3 hours
	Machining	16 hours
	Full Mechanical	3 days

Volume Solids 100%

V.O.C. Nil

Shelf Life Use within 12 months of purchase. Store in original sealed containers at temperatures 5°C (40°F) and 30°C (86°F).

PHYSICAL PROPERTIES

Tensile Strength ASTMD412	70 kg/cm ² (1000 psi)
Tear Strength ASTMD624	36 kg/cm (200 pli)
Elongation ASTMD412	800%
Shore A Hardness ASTMD2240	60
Peel Adhesion (Concrete & Steel) ASTMD903	9 kg/cm (50 pli) - cohesive failure in Flexi-Tech
Dielectric Strength ASTMD149	16 volts/micron (400 volts/mil)

HEALTH AND SAFETY

As long as normal good practice is observed **Thortex Flexi-Tech 60 E.G.** can be safely used.

Protective gloves should be worn.

A fully detailed **Material Safety Data Sheet** is either included with the material or is available on request.

PACKAGING

Supplied in 0.600 kg and 3 kg packs.

The information provided in this Product Data Sheet is intended as a general guide only and should not be used for specification purposes. The information is given in good faith but we assume no responsibility for the use made of the product or this information because this is outside the control of the company. Users should determine the suitability of the product for their own particular purposes by their own tests.



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Thortex Division of E. Wood Ltd.

Standard Way, Northallerton, N. Yorks. U.K. DL6 2XA

Tel: +44(0)1609 780170 Fax: +44(0)1609 780438 & 777905

E Mail: thortex@ewood.co.uk

FOR FURTHER INFORMATION PLEASE CONTACT