

## **FLEXI-TECH 60 R.G.**

### **Two Component Solvent Free Polyurethane Elastomer**



**Thortex Flexi-Tech 60 R.G.** is a 60 Durometer high performance rapid curing 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.

The **Thortex Flexi-Tech 60 R.G.** formulation 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 R.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 R.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 60 Primer**.

**Thortex Flexi-Tech 60 Primer** is supplied as a two component product comprising 100 gm of primer in a cone topped tin and a small glass bottle of catalyst.

The contents of the catalyst bottle should be added to the primer container immediately prior to use and the container should then be shaken to ensure complete mixing is achieved.

After use the container should be resealed, taking care not to contaminate the contents. This resealed **Thortex Flexi-Tech 60 R.G. Primer** will have a limited shelf life of up to 3 months.

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 10 minutes and a maximum of 1 hour at 20°C (68°F) before applying the **Thortex Flexi-Tech 60 R.G.**

### **MIXING/INSTRUCTIONS FOR USE**

**Thortex Flexi-Tech 60 R.G.** is a two component material which must be mixed together prior to use. The material is supplied either in 125gm sachets or 600gm units, which should be mixed as follows:

#### a) SACHETS

1) Remove outer wrapper using scissors to cut off corner, taking care not to damage the inner pack.

2) Extract the central dividing pin which separates the two components in the sachet.

3) Mix the two components together by hand, squeezing the pack and kneading the mixture for 1-2 minutes. To ensure complete mixing the product must then be transferred to a mixing board as follows.

4) Using scissors cut off the corner of the pack to allow the mixed product to be dispensed onto a mixing board, the product should then be mixed until completely homogenous, this will normally take a further 60 seconds.

## b)600GMUNITS

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 not unmixed material.

Once mixed the material should be used within 10 minutes, 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**

900cc (54.8 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
	Opaque Straw Paste	Coloured Paste

**Drying & Cure times at**

20°C (68°F)	Usable Life	10 minutes
	Initial Set	30 minutes
	Machining	1 hour
	Full Mechanical	24 hours

**Volume Solids** 100%

**V.O.C.** Nil

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

FOR FURTHER INFORMATION PLEASE CONTACT

**PHYSICAL PROPERTIES**

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

**HEALTH AND SAFETY**

As long as normal good practice is observed **Thortex Flexi-Tech 60 R.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 125g sachets and 0.600 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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