

FLEXI-TECH 75 R.G.

Two Component Solvent Free Polyurethane Elastomer



Thortex Flexi-Tech 75 R.G. is a 75-80 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, rubber tanks, rubber boats, ground sheets etc.

The **Thortex Flexi-Tech 75 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 75 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 75 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 R.G. Primer**.

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

The entire 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. After use the rim of the container should be cleaned and the container re-sealed, taking care not to contaminate the contents. The re-sealed container will have a limited shelf life of 3 months.

Where it is preferred not to catalyse the entire contents of the primer container, it is possible to mix smaller quantities when required by transferring a portion of the primer into a suitable container and adding a small amount of the catalyst.

The primer should now 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 75 R.G.**

MIXING

Thortex Flexi-Tech 75 R.G. is a two component material comprising a Base Component and an Activator Component which must be mixed together prior to use.

Thortex Flexi-Tech 75 R.G. is supplied in sachets, the ends of the sachets should be cut off and the entire contents of each squeezed onto a clean surface and mixed thoroughly to produce a 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 3 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

925cc (56.4 cu ins) per kilo

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

PHYSICAL CONSTANTS

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

Appearance	Base	Activator
	Coloured Paste	Clear Liquid

Drying & Cure times at

20°C (68°F)	Usable Life	3-5 minutes
	Initial Set	30 minutes
	Machining	1 hour
	Full Mechanical	24 hours

Volume Solids	100%
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V.O.C.	Nil
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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).
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FOR FURTHER INFORMATION PLEASE CONTACT

PHYSICAL PROPERTIES

Tensile Strength ASTM D412	6.31N/mm ² (915 psi)
Tear Strength ASTM D624	38.76N/mm ² (220 pli)
Elongation ASTM D412	550%
Shore A Hardness ASTM D2240	80
Dielectric Strength ASTM D149	16 volts/micron (400 volts/mil)

HEALTH AND SAFETY

As long as normal good practice is observed **Thortex Flexi-Tech 75 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 10 x 75gm 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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