



FLEXI-TECH 80 E.G.

Two Component Solvent Free Paste Grade Elastomer

Thortex Flexi-Tech 80 E.G. is a 80 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, cables, hoses etc.

The **Thortex Flexi-Tech 80 E.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 80 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 must be removed and the surface given a final wipe with **Thortex Universal Cleaner**.

On certain repairs such as gaskets and castings where one surface is not required to bond to the **Thortex Flexi-Tech 80 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 (68°F) before applying the **Thortex Flexi-Tech 80 E.G.**

MIXING

Thortex Flexi-Tech 80 E.G. is a two component material which must be mixed together prior to use.

The contents of the base container should be transferred to the mixing container provided, and the activator component added whilst stirring the base. Soon after blending a soft gel is formed and this gelled material should now be transferred to a mixing board and the product further mixed to ensure the material is completely homogeneous.

Where less than full unit mixes are required it is essential that the product be mixed accurately weighing out the quantities of base and activator.

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
858cc (52.3 cu ins) per kilo

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

PHYSICAL CONSTANTS

Mixing Ratio	Base	Activator	
	3	2	By volume
	3	2	By weight

Appearance	Base	Activator
	Black Viscous Liquid	Yellow Viscous Liquid

Drying & Cure times at 20°C (68°F)	Usable Life	12 minutes
	Initial Set	4 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 between 5°C (40°F) and 30°C (86°F).

PHYSICAL PROPERTIES

Tensile Strength 197 kg/cm² (2800 psi)

ASTMD412

Elongation 400%

ASTMD412

Tear Strength 58 kg/cm (325 pli)

ASTMD624

Shore A Hardness 80

ATM D2240

Peel Adhesion (Concrete & Steel) 9kg/cm (50pli) cohesive failed in Flexi-Tech

ASTMD903

FOR FURTHER INFORMATION PLEASE CONTACT

HEALTH AND SAFETY

TX31/1106

As long as normal good practice is observed **Thortex Flexi-Tech 80 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 750 gm 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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