



A brand of ITW Polymers Adhesives North America

Flexane® Accelerator/Flex-Add™ Flexibilizer

Description: Flexane® Accelerator (#15990) is an additive for Flexane 80 and Flexane 94 products that shortens cure time. It also helps Flexane to cure in temperatures as low as 32°F (0°C).

Flex-Add™ (#15940) Flexibilizer is a softening agent used with Flexane® 80 Liquid to produce a more flexible rubber with a durometer below 80 Shore A.

Intended Use: Accelerator (#15990): To reduce cure time of any Flexane product by 50%, and for maintaining cure schedule when using Flex-Add.

Flex-Add: (Match Shore A Hardness of existing rubber roll, custom part, or repair area.)

Product features: Produces greater flexibility for easier handling.

Limitations: None

Typical Physical Properties: *Technical data should be considered representative or typical only and should not be used for specification purposes.*

Cured 7 days @ 75° F

Flex-Add Quantities	2oz.	4oz.	6oz.	8oz.
Shore A Durometer (7 days)	75	68	64	60
Shore A Ultimate Cure (30 days @ 75°F)	78	70	66	62
Volume Increase %	12	23	35	47

Surface Preparation: For METAL SURFACES, thoroughly clean area to be repaired, rebuilt, or lined with Devcon® Cleaner Blend 300. Remove any oil, grease, or dirt. Roughen surface by grinding with a coarse wheel or an abrasive disc pad. To prime this surface, apply a coat of Devcon FL-10 Primer and allow to dry tack-free for 15 minutes. If the metal surface requires maximum tear resistance or is exposed to moisture, or if submerged in water, use Devcon® FL-10 and Devcon® FL-20 Primer.

For RUBBER SURFACES, thoroughly clean area with an abrasive pad and Devcon® Cleaner Blend 300. Surface can also be roughened with a grinding wheel so that it is coarse and free from oil and dirt that may clog the "pores" of the rubber. Wipe or roughen surface with Cleaner Blend 300 until the cloth no longer picks up the color of the rubber. The rubber should appear new or deeper in color. To prime this surface, apply a coat of Devcon® FL-20 Primer and allow to dry tack-free for 15-20 minutes. Use Devcon® FL-40 Primer on "hard-to-bond" rubber surfaces as this gives ultimate peel resistance. Multiple coats may be necessary for porous rubber surfaces.

For MAXIMUM ADHESION, sandblast the surface with an angular abrasive until a minimum depth profile of 2-3 mils is met. Blast to near-white finish specification SSPC-SP5 (Steel Structure Painting Council). Prime surface immediately after sandblasting to prevent oxidation.

Mixing Instructions: FLEX-ADD (To lower Flexane durometer):
1. Complete Flexane 80 mixing instructions
2. Add appropriate amount of Flex -Add in 2 oz. Increments (see chart in Application Instructions section of this data sheet).

FLEXANE ACCELERATOR (To increase cure speed):
1. Mix according to the Flexane product's mixing instructions.
2. Add Flexane Accelerator (2 gm = ½ tsp.) to mixed product. (see chart listed under Application Instructions of this data sheet for desired cure speed).
3. Mix well for two minutes.

Application Instructions: Flex-Add Flexibilizer (#15940), allows Flexane 80 Flexane 80 Liquid to produce a durometer below 80A. This allows for custom mixing of urethanes for specific application requirements. Mix well for two minutes. The chart below displays various Flex-Add amounts used with 1 lb. Of Flexane and the resulting durometers. (See Flexane® 80 Liquid TDS for application information).

Flex-Add	2 oz.	4 oz.	6 oz.	8 oz.	10 oz.	12 oz.	14 oz.	16 oz .
Durometer	78	70	66	62	58	54	50	46

Flexane Accelerator (#15990) is used to increase Flexane's cure speed at temperatures as low as 32°F. One-half tsp. (2gms) of Accelerator reduces the cure time of 1 lb. of Flexane by 50% (see chart below). Use 2 tsp. Or less of Accelerator for each 1 lb. of Flexane. (See Flexane 80/94 TDS for further application information.)

Accelerator/1 lb. Flexane	0	2gm	4gm
Working time @ 75°F (min.)	30	20	10
Working time @ 40°F (min.)	80	40	30
100% cure in days @ 75°F	7	5	3

Storage: Store at room temperature, 70 °F.

Compliances: None

Chemical Resistance: *Rating chemical resistance is not necessary for this product.*

Precautions: Please refer to the appropriate material safety data sheet (MSDS) prior to using this product.

For technical assistance, please call 1-800-933-8266

FOR INDUSTRIAL USE ONLY

Warranty: 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.

Order Information:
15990 12 oz.
15940 8 oz.