



A brand of ITW Polymers Adhesives North America

Devcon® R-Flex®

Description: Self-leveling liquid urethane that in minutes becomes a non-sag putty for repairing gouges, tears, and holes for heavy weight SBR conveyor belt

Intended Use: - Repair holes, gouges, and tears in SBR conveyor belt
- Protect Belt Clips from Scrapers with pulleys > 10" diameter

Product features: **High Adhesion to SBR belts creating "surface pull to polymer"**
Self leveling liquid that develops into a non-sag putty
SBR Belt back into service in 1 1/2 hours

Limitations:

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

% Solids by Volume	94
Abrasion Resistance	270mg loss per1,000 rev
Adhesion @ 24 hours	65 pli surface pull of rubber
Adhesion @ 7 days	108 pli surface pull of rubber
Color	Black
Coverage/lb.	110 sq. in./lb. @ 1/4"
Cure Hardness	87 Shore A
Dielectric Strength	350 volts/mils
Functional Cure	90 minutes
Maximum Elongation	421%
Maximum Operating Temperature	Dry: 180°F Wet: 120°F
Mix Ratio	88 Resin: 12 Curing Agent
Shelf Life	18 months
Specific Volume	27.4 in[3]/lb.
Tear Resistance	377 pli
Tensile Strength	1,462 pli

TESTS CONDUCTED

Flexural Strength ASTM D 790
T-Peel Strength ASTM D 1876
Tear Resistance ASTM D 624

Uncured

Product Characteristics @ 110°F/43°C	Pot Life: 1-3 min semi-liquid; 3-5 min/self level non sag gel
Product Characteristics @73°F/23°C	PotLife: 1-4 min semi-liquid; 4-10 min/self level non sag gel

Surface Preparation: Surface Prep: Abrading/Cleaning
1.Clean the belt with Devcon® Cleaner Blend 300 by applying ONLY to a rag and then cleaning the area. DO NOT POUR directly onto the belt!
2.Attach abrasive wheel [36 grit] to a 4" grinder [minimum 10,000 RPM]. Roughen belt releasing contaminants and grit.
3.Using grinder, roughen belt until dull bluish-grey color. Ensure top layer of belt is roughened, leaving a fine dusting of residue, brush off residue with a dry rag.
NOTE: Be sure not to grind down to the belt's woven carcass as this will weaken the belt.
4.Take a dry rag and wipe off any ground particles making the repair dust free.
NOTE: DO NOT apply any solvent cleaners to the belt as this will close the pores of the SBR Belt an affect adhesion..
5.Ideal application temperature is above 50°F (12.8°C).

Mixing Instructions: Surface Conditioner Mixing Instructions
1. Open bag, remove Surface Conditioner bottles: Part A and Part B.
2. Unscrew spout cap from Part B bottle and remove aluminium seal. Screw spout cap back on Part B bottle.
3. Take Part A bottle and unscrew dauber top.
4. Flip up the spout cap on Part B bottle to pour liquid into Part A bottle. Screw dauber top onto Part A bottle.
5. Shake bottle for 30 seconds to mix Surface Conditioner.
6. Remove clear cap from dauber top. Turn upside down and press dauber firmly on repair.
7. Thinly spread Surface Conditioner around entire repair area. It will evaporate quickly leaving slight change in color on the surface.
8. Wait 3 minutes to ensure surface is dry before applying Devcon R-Flex™.

R-Flex™ Mix Instructions

1. Make sure surface is roughened and Devcon® Surface Conditioner was applied and you will need to wait at least 3 minutes before applying Devcon R-Flex™.
2. Remove metal resin can [4 lb] kit, or plastic jar [1.5 lb kit] and open lid
3. Take Curing Agent out of the container [4 lb. kit a plastic jar], [1.5 lb. kit a pouch] and pour contents into the respective resin containers.
 - >For the 4 lb. Kit pour the curing agent and the contents of the resin into the large white mix bucket. Be sure to scrape sides of metal can getting all resin into the bucket.
 - >For the 1 lb. kit simply pour the curing agent pouch into the plastic container and start mixing.
4. Using wooden paddle, stir contents thoroughly for 1.5 minutes- scraping sides and bottom of the containers to activate curing mechanism.
5. Pour mixed R-Flex™ onto the roughened belt. After 3 minutes R-Flex will be able to be applied to a vertical surface without sagging [@1/4" thick] as the product is polymerizing quickly.
6. Spread with spatula to desired area. R-Flex will continue to "self-level" in seconds up to 8 minutes after you started your mixing. After that time the material will not self-level.

Metal Surfaces

1. Thoroughly clean the metal slipes to be coated/repaired. Remove any oil, grease or dirt. Roughen the metal by grinding with a coarse wheel. To prime the surface apply a coat of Devcon® FL-10 Metal Primer and allow to dry for 5-15 minutes.

Application Instructions:

1. Repairing Holes
 - For holes, use duct tape underneath belt to bridge hole. Be sure to prime repair area 6-8" back from the hole.
 - Follow surface abrading/cleaning section thoroughly.
 - After mixing Devcon® R-Flex™ and applying to repair area, make sure you fill void 6-8" around the hole to create additional strength.
2. Gouges or Tears:
 - For tears, if the tear is over 8-10" take alligator clip and lock the tear on either end of the tear to mechanically stop the belt form continuing to rip.
 - Take an abrasive wheel 4" grinder and at the tear undercut the rubber at an angle in a "V" configuration opening up the tear to expose more surface area for the repair compound to attach to. Place a strip of duct tape underneath the tear sealing off the area so no repair compound leaks through during the repair.
 - If using alligator metal clips, coat the clips with Devcon® FL-10 Primer and allow to dry for 3 minutes.
 - Follow surface abrading/cleaning section thoroughly.
 - After mixing Devcon® R-Flex™ [and applying to repair area, push the material into the "V" opening you created. The material will self-level in that area. Coat the clips with a thin layer of material.
3. Coating Hinged or Solid Plate Fasteners:
 - When coating plated clips, abrade an 8" area from the clip to the belt on both sides of the clip. If clip was skived and below surface only go back 4" .
 - Follow surface abrading/cleaning section thoroughly.
 - Coat the solid or pin clips with Devcon® FL-10 Metal Primer and allow to dry for 3 minutes..
 - Spread R-Flex™ on clips at a minimum thickness of 1/8" (this helps to bridge the elongation that occurs when belt is subjected to pressure of wiper and traveling across the head pulley).

Storage:

Store in a cool, dry place.

Compliances:

Adhesion Testing was conducted per ASTM 3167 measuring the polymers adhesion to SBR Rubber

Chemical Resistance:

Chemical resistance is calculated with a 7 day, room temp. cure (30 days immersion) @ 75°F

1,1,1-Trichloroethane	Poor	Sodium Hypochlorite	Very good
Aluminum Sulfate 10%	Very good		
Hydrochloric 10%	Very good		
Hydrochloric 36%	Very good		
Isopropanol	Poor		
Phosphoric 10%	Fair		
Potassium Hydroxide 40%	Very good		
Sodium Hydroxide 50%	Very good		

Precautions:

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

For technical assistance, please call 1-855-489-7262

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 Polymers Adhesives North America makes no representations or warranties of any kind concerning this data.

Order Information:

15550 4 lb.
15565 1.5 lb.