Version 3. 04/2023

Edge & Seal T-35

Description: Tough, rubber-like urethane compound for making a broad range of repairs, and for tooling and molding applications.

Intended Use: Industrial Use: Repair and rebuild conveyor belts; seal electrical cables; seal woven fabric belting from wear and abrasion; fill expansion/control joints; pot and encapsulate parts.

Features:

Excellent humidity resistance
High tensile and tear strength
Easy-to-use 400 ml cartridge
Fast-curing; self-leveling
Oil-resistant

Limitations: Suitability of product is determined by the end user for their application and process.

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 (24°C)	Typical Values
Abrasion Resistance	250 mg loss per 1,000 revol.
Cured Shrinkage	0.0014 in/in (cm/cm)
Dielectric Strength	350 volts/mil (13.78 Kv/mm)
Hardness	94 Shore A
Maximum Elongation	450%
Maximum Operating Temperature	Dry: 180°F (82°C); Wet: 120°F (49°C)
Percent Solids by Volume	100
Tear Resistance	430 pli (75 N/mm)
Tensile Strength	3,300 psi (23 MPa)

Uncured Properties @ 72°F (23°C)	
Color	Black
Coverage (1/4" / 6.35mm)	106 in2/lb (1508 cm2/kg)
Functional Cure	1.5 hours
Mix Ratio	80 resin:20 curing agent
Mixed Viscosity	5,000 cP
Pot Life	3 min. @ 75°F (24°C)
Specific Volume	26.5 in3/lb (0.957 cm3/g)

Standard Tests
Dielectric Strength, volts/mil ASTM D 149
Tensile Strength (Urethanes) ASTM D 412
Maximum Elongation ASTM D 412
Cure Shrinkage ASTM D 2566
Tear Resistance ASTM D 624
Cured Hardness Shore D ASTM D 2240

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 5-15 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:

---- To ensure proper cure speeds and hardness, mix Flexane at a temperature between 65°F-85°F (18°C-29°C). ----

FOR 1 LB. UNITS
1.Add hardener to resin.
2.Vigorously mix with screwdriver or spatula for two minutes, while continuously scraping material away from sides and bottom of container.
3.Transfer the mixed material to the plastic container (included in kit).
4.Wipe spatula clean, and stir again for two more minutes

FOR 400ML CARTRIDGES:
1.Attach mix nozzle to cartridge
2.Follow application instructions; no mixing is required.

FOR 10LB. UNITS:
Use a propeller-type Jiffy Mixer Model ES on an electric drill.
Mix until color is uniform and consistent (approx. 4-6 min.).

NOTE: Completely submerge propeller, otherwise large amounts of air will be added resulting in air bubbles on the finished product's surface.

Application Instructions:

1.Mount cartridge onto manual gun (#15043) or pneumatic gun (#15041).
2.Attach #15047 mix nozzle (used with both cartridges).
3.Clip mix nozzle back to desired orifice size.
4.Squeeze cartridge, allowing first THREE INCHES of material to discharge until a unified mix is exuding from nozzle (color is uniform with no striations).
5.Finish application as quickly as possible.

IMPORTANT:
Replace mix nozzle every four minutes to ensure complete mix, with no soft spots. Because of the short pot life (8 minutes), stopping between uses can result in Flexane product curing IN the mix nozzle. Further mixing will be off ratio.

Storage: Store at room temperature, 70 °F (21 °C).

Compliances: None

Chemical Resistance: Chemical resistance is calculated with a 7-day, room temp. cure (30 days immersion) @ 75°F (24°C)

1,1,1-Trichloroethane	Poor
Acetic (Glacial)	Fair
Aluminum Sulfate 10%	Very good
Cutting Oil	Fair
Hydrochloric 10%	Fair
Isopropanol	Poor
Methyl Ethyl Ketone	Poor
Phosphoric 10%	Fair

Phosphoric 50%	Fair
Potassium Hydroxide 40%	Very good
Sodium Hydroxide 50%	Very good
Sulfuric 10%	Fair
Xylene	Poor

Precautions: **FOR INDUSTRIAL USE ONLY:** Please refer to the appropriate **S**afety **D**ata **S**heet prior to using this product.

Warranty: ITW Performance Polymers 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.

Order Information:

Item No.	**Package Size**
DF039	400 ml cartridge

Contacts:

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Disclaimer:

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