



# Thortex Flexi-Tech 80 EG

## Data Sheet and Application Guide

### Product Description

Thortex Flexi-Tech 80 EG has been specifically developed as an elastomeric repair system with a high degree of flexibility for rebuilding and resurfacing rubber components.

### Product Features

- Properties comparable to factory produced rubbers.
- Designed for application by trowel or spatula at thicknesses up to 6mm.
- Provides good cold vulcanising capabilities.
- Primarily designed for use to repair conveyor belts, rollers, gaskets, hoses, off road tyres etc.

### General Application Steps

1. Remove oil, grease and loosely adhering deposits and degraded rubber.
2. Thoroughly abrade the surface, to produce a rough fibrous finish.
3. Apply Thortex Flexi-Tech 80 EG to the required thickness.
4. Allow to cure.
5. Visually inspect the coating for defects.
6. Repair all defects.

### Surface Preparation

All existing dirt, oil and grease should be removed and the surface wiped with solvent-based 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 80 EG, 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 70°F before applying Thortex Flexi-Tech 80 EG.

### Product Mixing

Thortex Flexi-Tech 80 EG is a two component material comprising Base and Activator components 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. Once mixed the material should be used within 15 minutes at 70°F.

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

### Application Procedures

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 solvent-based cleaner.

### Properties

Property	Value
Color	Black
Ratio	4:1 By volume
<b>Drying &amp; Cure times at 20°C (68°F)</b>	
Useable life	15 mins
Initial Set	1 hour
Machining	16 hours
Full Mechanical Cure	3 days
Volume Solids	100%
V.O.C (As Supplied)	Nil
Film Thickness	Up to 6mm.
Volume Capacity	736 cc (45 cu ins) per kilo
<b>Performance Data</b>	
Tensile Strength	12N/mm <sup>2</sup> (1750 psi) (ASTM D412)
Dielectric Strength	16KV/mm (ASTM D149)
Elongation	250% (ASTM D412)
Shore A Hardness	80 (ASTM D2240)
Tear Strength	50N/mm (325pli) (ASTM D624)
Maximum Operating Temperature	80°C (176°F) - Dry 50°C (122°F) - Wet
UV Resistance	No loss in properties after 1000 hours exposure (BS 3900:F3)
Peel Adhesion (Concrete & Steel)	9kg/cm (50pli) - Cohesive failure in product (ASTM D903)

## Packaging and Storage

Supplied in 1 kilo units.

Use within 2 years of date of manufacture. Store in original sealed containers at temperatures between 5°C (40°F) and 30°C (86°F).

## Handling and Safety Precautions

Read all Health Hazard, Precautionary and First Aid, Material Safety Data Sheet, and/or product label prior to handling or use.

## Ordering Information/Customer Service

For ordering technical or product information, or a copy of the Material Safety Data Sheet, please contact us:

Phone: 610-831-0222

Fax: 610-831-1910

Email: [info@thortex.com](mailto:info@thortex.com)

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Thortex America, Inc.  
12 Iron Bridge Drive • Collegeville, PA 19426  
Telephone: 610-831-0222  
Website: [www.thortex.com](http://www.thortex.com)