



A brand of ITW Polymers Adhesives North America

## Technical Data Sheet

8/18/2004

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

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

**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**

<b>Abrasion Resistance</b>	<b>250 mg loss per 1,000 revolu</b>
<b>Color</b>	<b>Black</b>
<b>Coverage/lb</b>	<b>106 sq.in./lb. @ 1/4"</b>
<b>Cured Hardness</b>	<b>94A</b>
<b>Cured Shrinkage</b>	<b>0.0014 in./in.</b>
<b>Dielectric Strength</b>	<b>350 volts/mils</b>
<b>Functional Cure</b>	<b>1.5 hours</b>
<b>Maximum Elongation</b>	<b>450%</b>
<b>Maximum Operating Temperature</b>	<b>Dry: 180°F; Wet: 120°F</b>
<b>Mix Ratio</b>	<b>80 resin:20 curing agent</b>
<b>Mixed Viscosity</b>	<b>5,000 cps</b>
<b>Percent Solids by Volume</b>	<b>100</b>
<b>Pot Life</b>	<b>3 min. @ 75°F</b>
<b>Specific Volume</b>	<b>26.5 in.(3)/lb.</b>
<b>Tear Resistance</b>	<b>430 pli</b>
<b>Tensile Strength</b>	<b>3,300 psi</b>

**TESTS CONDUCTED**

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 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. ----

**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.

**Compliances:**

None

**Chemical Resistance:**

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

1,1,1-Trichloroethane	Poor	Phosphoric 50%	Fair
Acetic (Glacial)	Fair	Potassium Hydroxide 40%	Very good
Aluminum Sulfate 10%	Very good	Sodium Hydroxide 50%	Very good
Cutting Oil	Fair	Sulfuric 10%	Fair
Hydrochloric 10%	Fair	Xylene	Poor
Isopropanol	Poor		
Methyl Ethyl Ketone	Poor		
Phosphoric 10%	Fair		

**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:**

**DF039 400 ml cartridge**