



# TECHNICAL DATA

## FL-10 PRIMER

### *Metal Primer for Flexane Urethane Compounds*

#### Description

FL-10 Primer is a one part adhesion promoter primer used on metals for ultimate adhesion of all **Flexane** urethanes.

#### Areas of application

- Priming all metals before applying any **Flexane** products
- After abrasive blasting a good primer before coating with any **Devcon**<sup>®</sup> metal-filled epoxy

#### Features

- One part primer which dries in 30 minutes

#### Chemical Resistance

Rating chemical resistance is not necessary for this product.

#### Technical Data

##### Typical Physical Properties: Cured 7 days @ 24°C

% Solids by Volume	15
Cure Time	30 minutes
Coverage (per 120ml)	0.93m <sup>2</sup> @ 125µm
Metal, dry	Adhesion (1 coat): 446 – 893 kg/m
Metal, dry	Adhesion (2 coats): 893 – 1339 kg/m
Metal, immersed in water	1-coat FL-10 followed by 1-coat FL-20

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The information contained in this Technical Bulletin is as up to date and correct as possible as at the time of issue. The data provided should be used as a guide only as the performance of the product will vary depending on differing operating conditions and application methods.

The sale of any product described in this Technical Bulletin will be in accordance with ITW Polymers & Fluids Conditions Of Sale, a copy of which is available on request. To the extent permitted by law, ITW Polymers & Fluids excludes all other warranties in relation to this product.

## Directions for use

### Surface Preparation

**Metal** – Thoroughly clean the area that is to be repaired, rebuilt or lined, by using **Devcon® Surface Cleaner**. All oil, grease and dirt must be removed before applying **Flexane** material. All surfaces must be roughened by grinding with a coarse wheel or an abrasive disc pad.

**Maximum adhesion** – Sandblast the surface using an angular abrasive to achieve minimum depth profile of 50 - 75 microns. Abrasive blast clean in accordance with **Australian Standard AS1627:4-2005** to a Class 2 ½ near white metal finish. After sandblasting, application surface should be primed immediately to prevent oxidation.

**Rubber** – Thoroughly clean the rubber area with an abrasive pad and **Devcon® Surface Cleaner**. A grinding wheel may be used to roughen the rubber surface. The rubber surface must be coarse and free from oil and dirt clogged in the “pores”. Using **Devcon® Surface Cleaner** wipe or roughen surface until the colour of the rubber substrate no longer appears on cloth. The rubber should look new or a deeper black in colour.

### Mixing

- Mixing is not applicable to this product.

### Application

Many field applications using **Devcon®’s Flexane** technology are unsuccessful because the technician fails to use the proper primers to adhere the **Flexane** to the substrate. There are 2 different priming systems to use when applying **Flexane**, **FL-10** and **FL-20**, for specific applications one or the other should be applied:

- **Metal surfaces:** Use 2 coats of **FL-10 Primer** to coat all metal substrates. This applies to stainless steel and aluminium.
- **Dry Time:** Minimum of 30 minutes before topcoating with **Flexane** and a maximum of 7 days. If exceeded solvent wipe and reapply.
- **Immersion Substrates:** Use both **FL-10** and **FL-20** to coat any metal substrate that will be immersed in any aqueous solution. First apply the **FL-10 Primer** and let dry for 30-60 minutes. Then coat with **FL-20 Primer**. Let **FL-20 Primer** dry for 15-30 minutes before applying any **Flexane** material.

### Storage and Shelf Life

Store in dry conditions between 10°C and 40°C, away from sources of heat and naked flames. Protect from frost. When stored in original sealed containers, the minimum shelf life is two (2) years.

### Packaging

**FL-10 Primer** is available in 120ml tins.

### Ordering Information:

120 ml tin

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### Health & Safety Information

The product is hazardous. A Material Safety Data Sheet is available from the ITW Polymers & Fluids Technical Department upon request or available on our website [www.itw-devcon.com.au](http://www.itw-devcon.com.au) .

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