

3M™ Scotchkote™ Urethane Elastomer 80BG 536

(Formerly known as Flexi-Tech 80 BG)

Data Sheet and Application Guide

Product Description

Scotchkote Urethane Elastomer 80BG 536 has been specifically developed as an elastomeric system with a high degree of flexibility for resurfacing rubber components.

Product Features

- Properties comparable to factory produced rubbers.
- Designed for application by brush at thicknesses up to 500 microns (20 mil).
- Primarily designed for use to resurface impellers, chutes, and hoppers.

Surface Preparation

Heavy contamination due to oil or grease must be removed using a suitable degreasing agent. If your local air quality regulations allows its use, we recommend using 3M Scotchkote Universal Cleaner 020.

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 Scotchkote Urethane Elastomer 80BG 536, these surfaces should be treated with 3M™ Scotchkote™ Release Agent 035.

Priming

All areas to be repaired or resurfaced should be first primed with 3M™ Scotchkote™ Urethane Elastomer Primer 075. 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 20°C (68°F) before applying Scotchkote Urethane Elastomer 80BG 536.

Product Mixing

Scotchkote Urethane Elastomer 80BG 536 is a two component material which must be mixed together prior to use.

The contents of the base container should be transferred to the mixing container provided. The contents of the activator should be added to the base with continuous stirring to produce a streak free viscous liquid. Where less than full unit mixes are required it is essential that the product be mixed accurately weighing out the quantities of base and activator.

Thorough mixing is extremely important, and once the material appears mixed, a further period of mixing should be carried out to ensure there is no unmixed material. The mixed material should be used within 20 minutes of mixing at 20°C (68°F).

Application Procedures

For resurfacing the mixed material should be applied evenly to the primed surface with a clean brush. When a second coat is required this should be applied as soon as possible, after the initial set and within 24 hours of the first coat being applied. All equipment must be cleaned immediately after use with a suitable degreasing agent. If your local air quality regulations allows its use, we recommend using 3M Scotchkote Universal Cleaner 020.

Properties

Property	Value
Color	Black
Ratio	1:1.7 By volume 7:8 By weight
Drying & Cure times at 20°C (68°F)	
Useable life	15 mins
Initial Set	1 hour
Machining	16 hours
Full Mechanical	3 Days
Volume Solids	100%
V.O.C (As Supplied)	0 g/L
Film Thickness	Up to 500 micron (20 mil)
Volume Capacity	933 cc (57 cu ins) per kilo
Tensile Strength	11.7 Mpa (1700 psi)
Dielectric Strength	16 KV/mm (406 V/mil)
Elongation	600%
Shore A Hardness	80



Packaging and Storage

Supplied in 0.5 and 2.0 kilo packs

Use within 12 months of purchase. 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, call:

Phone: 800/722-6721 or 651/575-5842

Fax: 877/601-1305

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