



FL-20 Primer

Description:	A one-part moisture cure adhesion promoter primer used on concrete rubber, urethane, wood fiberglass, PVC, and cured epoxy.		
Intended Use:	Industrial Use: Priming concrete, wood, rubber, fiberglass, PVC and urethane.		
Features:	One-part, moisture cure primer, that dries in 30 minutes		
Limitations:	Suitability of product is determined by the end user for their application and process. As the humidity rises the primer will take longer to cure.		
Typical	Technical data should be considered representative or typical only and should not be used for specification purposes.		
Physical			
Properties:	Cured 7 Days @ 75°F (24°C)		Standard Tests
	Concrete	1 coat: > 50 pli (>8.8 N/mm)	
	Coverage (5 mils / 0.13 mm)	10 ft ² (0.93 m ²) per 4oz	
	Cure Time	30-120 min.	
	Cured Flexane	1 coat: > 50 pli (>8.8 N/mm)	
	Fiberglass	1 coat: > 50 pli (>8.8 N/mm)	
	Color	Orange	
	Percent Solids by Volume	3.70%	
	Polyester	1 coat: > 25 pli (>4.4 N/mm)	
	Rubber	1 coat: > 50 pli (>8.8 N/mm)	
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:	Mixing is not applicable to this product. These products are surface conditioners and primers that allow Flexane® adhere to metals, rubber and plastics. Follow instructions on the can for maximum adhesion to the surface.		
Application			
Instructions:	- Concrete: Being a very porous surface, concrete needs to be have multiple cleaning. Degrease the area with Cleaner Blend 300 and rinse multiple times. Let the floor dry thoroughly before applying FL-20. Apply two coats to the concrete for proper adhesion. - Rubber: Apply FL-20 to gum rubber, neoprene or cured poly-urethane. One coat is sufficient. - Dry Time: Minimum of 30 minutes before top coating with Flexane and a maximum of 2 hours. If exceeded, solvent wipe and re-apply. - Wood, Fiberglass: One coat on all hardwoods (maple,oak) is sufficient with 2 coats on all softwoods (pine). Fiberglass needs only one coat. - Plastics: Two coats of FL-20 primer will increase adhesion.		
Storage:	Store at room temperature, 70 °F (21 °C).		
Compliances:	None		
Chemical			
Resistance:	Rating chemical resistance is not necessary for this product.		
Precautions:	FOR INDUSTRIAL USE ONLY: Please refer to the appropriate <u>Safety Data Sheet</u> 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:**

<u>Item No.</u>	<u>Package Size</u>
15985	4 oz.

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Disclaimer:

Product Use: The information herein is based upon good faith testing that ITW PP believes are reliable, but the accuracy or completeness of such information is not guaranteed. Many factors beyond ITW PP control and uniquely within user's knowledge and control can affect the use and performance of an ITW PP product in a particular application. Given the variety of influencers on performance, the data here is not intended to substitute end user testing. It is the end users sole responsible for evaluating any ITW PP product and determining whether it is fit for a particular purpose and suitable for user's design, production, and final application.

Exclusion of Warranties: As to the herein described materials and test results, there are no warranties which extend beyond the description on the face hereof. ITW PP makes no other warranties, express or implied, including, but not limited to, any implied warranty of merchantability or fitness for a particular purpose. Since the use of the herein described involves many variables in methods of application, design, handling and/or use, the user, in accepting and using these materials, assumes all responsibility for the end result. ITW PP shall not otherwise be liable for loss of damages, whether direct, indirect, special, incidental, or consequential, regardless of the legal theory asserted, including negligence, warranty, or strict liability.