Technical Data Sheet
Version 5. 12/2024

FL-10 Primer

Description: A one-part adhesion promoter primer used on metals for ultimate adhesion of all Flexane urethanes.

Intended Use: Industrial Use: After shotblasting a good primer before coating with any Devcon epoxy.
Priming all metals before applying any Flexane products.

Features: **One-part, moisture cure primer, that dries in 5-15 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 Physical Properties:

Technical data should be considered representative or typical only and should not be used for specification purposes.

Cured 7 Days @ 75°F (24°C)		Standard Tests
Coverage (5 mils / 0.13 mm)	10 ft^2 (0.93 m2) per 4oz	NA
Cure Time	5-30 min.	
Metal immersed in water	1-coat FL10 and 1-coat FL20	
Metal, dry	Adhesion (2 coats): 50-75 pli (8.8-13.1 N/mm)	
Metal, dry	Adhesion (1 coat): 25-50 pli (4.4-8.8 N/mm)	
Color	Blue	
Percent Solids by Volume	15%	

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 coating 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: Metal Surfaces- Use 1-2 coats of FL-10 Primer [as documented in the physical property section], to coat all metal substrates. This applies to stainless steel and aluminum.

Dry Time: Minimum of 5 minutes before top coating with Devcon urethanes and epoxies. If you prime and do not topcoat after 5 minutes, then you have a maximum of 7 days before you will have to solvent wipe and reapply FL-10.

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 between 5-15 minutes. Then coat with FL-20 primer. Let FL-20 dry for 5-10 minutes before applying any Flexane material.

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 **S**afety **D**ata **S**heet 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:

Item No.	Package Size
15980	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.

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