



A brand of ITW Polymers Adhesives North America

# FL-10 Primer

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

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

**Product features:** **One-part,moisture cure primer, which dries in 30 minutes**

**Limitations:**

**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>Coverage/4oz.</b>	<b>10 sq ft.@ 5 mils</b>
<b>Cure Time</b>	<b>30 min.</b>
<b>Metal, dry</b>	<b>Adhesion (2 coats): 50-75 pli</b>
<b>Metal, dry</b>	<b>Adhesion (1 coat): 25-50 pli</b>
<b>Metal, immersed in water</b>	<b>1-coat FL-10 followed by 1-c</b>
<b>Percent Solids by Volume</b>	<b>15%</b>

**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:** 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 2 coats of FL-10 Primer to coat all metal substrates . This applies to stainless steel and aluminum.  
- Dry Time: Minimum of 30 minutes before topcoating with Flexane and a maximum of 7 days. If exceeded solvent wipe and reapply.  
- Immersioin 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 60 minutes. Then coat with FL-20 primer. Let FL-20 dry for 30 minutes before applying any Flexane material.

**Storage:** Store at room temperature, 70 °F.

**Compliances:** None

**Chemical Resistance:** *Rating chemical resistance is not necessary for this product.*

**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:** 15980 4 oz.