



C417WN

Description: ENDURARFLEX White soft, pure gum natural rubber, chemical cure for field lining and repair. FDA compliant when Chemcure II is used to cure the rubber.

Durometer of Face Material: Shore A Scale.

Atmospheric Cure: 20 to 35

Available Gauges: 1/8", 3/16", 1/4"; 4 mm, 5 mm, & 6mm.

Adhesive System:

Adhesives: ENDURABOND

1st coat on metal:	Primer #1
2nd coat on metal:	Intermediate #2
3rd coat on metal:	Tack #103
On the rubber:	Tack #103 Chemcure

Skive: Open

Cure Methods and Times:

Autoclave:	Not Recommended
Internal Pressure:	Not Recommended
Atmospheric: Chemcure: Apply two coats on lining face with 20 min. drying time between coats. Cure 7 to 14 days at room temperature. Cure may be accelerated by exhaust steam with a gradual increase to 180°F (82°C) for 8 to 12 hours.	

Note: Cure times may require adjustment to compensate for heavy metal thickness, low exterior temperatures or other unusual factors. See Section 14 – Curing Instructions.

Repairs: Repair with original lining. See Section 16 – Repair Procedures.

Storage Life:

From 32°F (0°C) to 50°F (10°C)	180 days
From 55°F (13°C) to 65°F (19°C)	90 days
From 70°F (21°C) to 85°F (30°C)	60 days
Above 90°F (32°C)	30 days

Typical Physical Properties

Tensile Strength – PSI	ASTM D412	1000
% Elongation at break	ASTM D412	900
Durometer	ASTM D2240	31A
Specific Gravity	ASTM D927	1.02
Adhesion to Metal	ASTM D429	20 Lbs.

Application methods shall conform to BLAIR Rubber Company instructions contained in the Engineering & Applicator manual. Deviations from the specifications must be approved by BLAIR Rubber Company.

Notes:

- For the best appearance of the completed rubber lining, always apply plastic side down against the substrate.
- For **FDA** approved rubber material **Chemcure II** is the curative required.

Applicator Notes:

- Used to repair VE370WN and other white natural rubber “gum” type linings.
- This lining is susceptible to over cure. Over cure or reversion may occur when heat cure time and temperature parameters when pressure curing are exceeded.
- Plying up layers of rubber lining thicker than 1/4” could result in the rubber flowing or sagging during cure. Do a test plate to determine flow characteristics.
- Plying up layers of rubber lining could result in the rubber not curing throughout, without the addition of heat. Chemical curatives rarely penetrate through two layers. Do a test plate to determine cure suitability characteristics.
- The temperature of the substrate must be greater than 60° F (15° C) prior to applying primer and rubber. Temperatures should not exceed 120° F (48° C).
- Chemcure & Chemcure II should not be applied if rubber temperatures are below 50° F (10° C) or above 140° F (60° C). Note: at the low end the cure time may take months.