



January 7, 2005

C633BN

Description: ENDURAFLEX Black, soft/semi-hard/soft, TRI-BOND natural rubber chemical cure for general purpose. **FDA** compliant when **Chemcure II** is used to cure the rubber.

Durometer of Face Material: Shore A Scale.

Atmospheric Cure: 45 to 65

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

Adhesive System:

Adhesives: ENDURABOND

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

Skive: Closed

Cure Methods and Times:

Autoclave: Not Recommended.
Internal Pressure: Not Recommended
Atmospheric: Chemcure: Apply two coats on lining face. Allow to cure 7 – 14 days at room temperature. Exhaust Steam Assist – Cure may be accelerated by exhaust steam with a gradual increase to 180°F (82°C) for 8 – 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 51°F (13°C) to 65°F (19°C)	90 days
From 66°F (21°C) to 75°F (23°C)	60 days
From 75°F (23°C) to 85°F (30°C)	30 days
Do not exceed 90°F (32°C) prior to use.	Cold storage

Typical Physical Properties

Tensile Strength – PSI	ASTM D412	1100
% Elongation at break	ASTM D412	400
Durometer	ASTM D2240	58A
Specific Gravity	ASTM D927	1.23
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:

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

Applicator Notes:

1. Used to repair VE636BN and other Tri-Bond Natural Rubber Linings.
2. Plying up layers of rubber lining thicker than 1/2" could result in the rubber flowing or sagging during cure. Do a test plate to determine flow characteristics.
3. Plying up layers of rubber lining could result in the rubber not curing thoroughly, with out the addition of heat. Chemical curatives rarely penetrate through two layers. Do a test plate to determine cure suitability characteristics.
4. A heated table that warms rubber to 120°F is best for application.
5. 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).
6. 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.