



C924BNG

Description: ENDURAFLEX Black, semi-hard natural rubber, chemical cure, graphite reinforced for wet chlorine service field repair.

Durometer of Face Material: Shore A Scale.

Atmospheric Cure: 55 to 85

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

Adhesive System:

Adhesives: ENDURABOND 1*2*3 SYSTEM

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

Skive: Closed

Cure Methods and Times:

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| Autoclave: Not Recommended |
| Internal Pressure: Not Recommended |
| Atmospheric: Chemcure: Apply two coats on lining face. Allow to cure 7 to 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 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:

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|---|--------------|
| 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 | NA |
| % Elongation at break | ASTM D412 | NA |
| Durometer | ASTM D2240 | NA |
| Specific Gravity | ASTM D927 | 1.19 |
| Adhesion to Metal | ASTM D429 | 30 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.

Applicator Notes:

- Used to repair VE925BNG and other graphite reinforced natural rubber linings.
- 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.
- 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.
- 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.