



VE107WNI

Description: ENDURAFLEX White, soft, nitrile lining. FDA Compliant.

Durometer of Face Material: Shore A Scale
Pressure Cure: 50 to 60
Atmospheric Cure: 50 to 60

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

Adhesive Systems, use one or the other:
Adhesives: ENDURABOND System for Synthetics

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|--------------------|--------------------|
| 1st coat on metal: | Primer P-100 |
| 2nd coat on metal: | Intermediate I-100 |
| 3rd coat on metal: | 202 Tack |
| On the rubber: | 202 Tack |

ENDURABOND 2001 SYSTEM

| | |
|--------------------|-------------|
| 1st coat on metal: | Primer 2001 |
| 2nd coat on metal: | 202 Tack |
| On the rubber: | 202 Tack |

Skive: Open

Cure Methods and Times:

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| Autoclave: 1.5 hours @ 290°F (143°C) |
| Internal Pressure: 8 hours @ 260°F (127°C) (Required for tank cars and trailers) |
| Atmospheric: 3 Step process Step 1 – 6 hours from Ambient to 140°F (60°C) Step 2 – 4 hours from 140°F to 160°F (71°F) Step 3 – 24 hours from 160°F to 200°F (93°F) Atmospheric curing not recommended for vacuum service. |

Note: Cure times may require adjustment to compensate for heavy metal thickness, low exterior temperatures or other unusual factors. See Section 15 – Curing Instructions.

Repairs: Repair with original lining. See Section 17 – 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 85°F (30°C) | 60 days |
| 90°F | 30 days |
| Do not exceed 90°F (32°C) prior to use. | -- |

Typical Physical Properties

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|------------------------|------------|---------|
| Tensile Strength – PSI | ASTM D412 | 1300 |
| % Elongation at break | ASTM D412 | 500 |
| Durometer | ASTM D2240 | 55A |
| Specific Gravity | ASTM D927 | 1.30 |
| Adhesion to Metal | ASTM D429 | 25 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.

Caution: Soft nitrile rubber is susceptible to deterioration by sunlight and oxygen called weather checking. **Do not** expose rubber lining to sunlight, ozone or oxygen.

Applicator Notes:

1. A heated table that warms rubber to 120°F is best for application.
2. Lining may shrink 10% lengthwise after unrolling. Preshrink rubber before applying or during the cure the lining will lift away, requiring repair.
3. 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).
4. This rubber lining cannot be overly stretched. It must be gently folded to cover the area to be lined and then firmly rolled down. **Do not attempt to push or force the lining down into corners.** Stretching the rubber will cause the lining and seams to lift during cure. Use “V-beads” in corners and sharp angles to prevent any stretching.
5. Strict adherence to adhesive specifications is required. Tack time is also critical to the success of the bond. **Application of multiple coats of adhesive will be detrimental to the bond.**