



VE415TN

Description: ENDURAFLEX Tan, soft, heat resistant natural rubber for high temperature and moderate abrasion service. Exhaust Steam or Pressure Cure. This lining material is the same as the top layer of VE333TN.

Durometer of Face Material: Shore A Scale
Pressure Cure: 60 to 80
Atmospheric Cure: 60 to 80

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: Open

Cure Methods and Times:

Autoclave: 1/8" to 3/16" 40 min @ 275°F (135°C)
Internal Pressure: 8 hours @ 260°F (127°C)
Atmospheric: 3 Step Cure – 34 hours total – Gradual increase temperature as follows: <u>All three steps must be used.</u> Step 1 - 6 hour period - Ambient to 140°F (60°C) Step 2 – 4 hour period @ 140°F to 160°F (71°C) Step 3 – 24 hour period – 180° to 200°F (93°C) 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 or C413TN. See Section 17 – 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

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.

Section 2

Typical Physical Properties

Tensile Strength – PSI	ASTM D412	2000
% Elongation at break	ASTM D412	750
Durometer	ASTM D2240	43A
Specific Gravity	ASTM D927	1.06
Adhesion to Metal	ASTM D429	30 Lbs.

Notes: For the best appearance of the completed rubber lining, always apply plastic side down against the substrate.

Caution: Soft natural 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. This lining is susceptible to over cure when pressure curing. Over cure or reversion may occur when heat cure time and temperature parameters are exceeded.
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. 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).