VE620BH

Description: ENDURAFLEX Black, Hypalon Lining for High Temperature and Strong Oxidizing Acids. Exhaust Steam or Pressure Cure.

Durometer of Face Material: Shore A Scale
Pressure Cure: 55 to 65
Atmospheric Cure: 55 to 65

Available Gauges: 1/8", 3/16", ¼", 3mm, 4mm, 5mm, 6mm.

Adhesive System:

Adhesives: ENDURABOND

1st coat on metal:	Primer P-100
2nd coat on metal:	Intermediate I-100
3rd coat on metal:	700 Tack
On the rubber:	P750 Primer
On the rubber:	700 Tack over P750
2" Laps:	Cyclohexanone Solvent

Skive: Open

Cure Methods and Times:

Autoclave: 3 hours @ 275ºF (135ºC)
Internal Pressure: 8 hours @ 260ºF (127ºC)
Atmospheric: 2 Step process Step 1 – 6 hours from Ambient to 160ºF (71ºC) Step 2 – 24 hours @180ºF (82ºC) or 20 hours @ 200ºF (94ºC) 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 Section14 – Curing Instructions.

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

Storage Life:

From 32° F (0° C) to 50° F (10° C)	30 days
From 55° F (13° C) to 65° F (19° C)	45 days
From 70° F (21° C) to 85° F (30° C)	15 days
Above 90° F (32° C)	5 days

Typical Physical Properties

Tensile Strength – PSI	ASTM D412	1800
% Elongation at break	ASTM D412	600
Durometer	ASTM D2240	60A
Specific Gravity	ASTM D927	1.41
Adhesion to Metal	ASTM D429	40 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.

Applicators Notes:

1. This material has a short shelf life. Works best if applied within two weeks of the delivery.
1. The temperature of the substrate must be greater than 60º F (15º C) prior to applying primer and rubber. Temperatures should not exceed 120º F (48º C).

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