



VE625BCN

Description: ENDURAFLEX Black, soft, top half chlorobutyl, center pure gum (PG-70) natural rubber for HCL acid and general purpose chemical services. Available only with Grey "Tacky – Back " Tie Gum. 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", 1/4", 4mm, 5mm, & 6mm

Adhesive Systems:

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:

Autoclave: 2 hours @ 275°F (135°C)
Internal Pressure: 6 hours @ 260°F (127°C)
Atmospheric: 2 Step process Step 1 – 6 hours from Ambient to 160°F (71°C) Step 2 – 24 hours @ 180°F (82°C) or 20 hours @ 200°F (94°C) For insulated vessels : 4 hours at 260°F (127°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 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	1000
% Elongation at break	ASTM D412	550
Durometer	ASTM D2240	57a
Specific Gravity	ASTM D927	1.39
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:

1. This lining is very easy to apply and is commonly used for HCl vapor area overlay in rail cars lined with PG-70 and locations that require ozone and oxidation resistance.

Applicator Notes:

1. This lining does not require an adhesive (Tack #3) to be applied to the rubber, except in the seam areas, because it comes with Tack Back tie gum.
2. For Hot Water Cure consult with Blair Rubber Company's technical department. When using this method a qualified steel structural design engineer must be consulted.
3. For vacuum vessel curing instructions contact Blair Rubber Company's Technical Department.
4. Always apply plastic side down against the substrate.
5. A heated table that warms rubber to 120°F is best for application.

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).