



# VE636BNS

**Description:** ENDURAFLEX Black, soft/hard/soft, Tri-Bond natural, synthetic blend lining for general purpose, plating and oxidizing media. Exhaust Steam or Pressure Cure.

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

**Available Gauges:** 3/16", 1/4", 3/8", 1/2", 4mm, 5mm, 6mm, & 10mm.

**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:**

<b>Autoclave:</b> 3 hours @ 275°F (135°C)
<b>Internal Pressure:</b> 8 hours @ 260°F (127°C)
<b>Atmospheric:</b> 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) 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 or C633BN. 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	2300
% Elongation at break	ASTM D412	550
Durometer	ASTM D2240	68 A
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:** 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. Available in Tacky Back which does not require an adhesive (Tack #3) to be applied to the rubber, except in the seam areas.
2. A heated table that warms rubber to 120°F is best for application.
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).