



VE644BC

Description: ENDURAFLEX Black, soft/semi-hard synthetic/chlorobutyl Tri-Bond for various acid service and open top storage tanks. FDA. With Tacky Back. Exhaust Steam or Pressure Cure.

Durometer of Face Material: Shore A Scale
Pressure Cure: 55 to 75
Atmospheric Cure: 55 to 75

Available Gauges: 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: 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) 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:

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.

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.

Notes: Always apply plastic side down against the substrate.

Applicator notes:

1. A heated table that warms rubber to 120°F is best for application.
2. 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).