



VE822BBS

Description: ENDURAFLEX Black, semi-hard butyl synthetic lining for general chemical service. With gray tie gum. Exhaust Steam or Pressure Cure.

Durometer of Face Material: Shore A Scale

Pressure Cure: 85 to 95

Atmospheric Cure: 80 to 90

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: Closed

Cure Methods and Times:

Autoclave: 3 hours @ 275°F (135°C) Reference section 8, Preface for clarification
Internal Pressure: 8 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 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	1600
% Elongation at break	ASTM D412	150
Durometer	ASTM D2240	82A
Specific Gravity	ASTM D927	1.10
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: For the best appearance of the completed rubber lining, 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. For vacuum vessel curing instructions, contact Blair Rubber Company's Technical Department.
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).