



VE929BN

Description: ENDURAFLEX Black, flexible ebonite natural rubber, specially compounded for high heat resistance in continuous service. FDA. With Grey Tie Gum. Exhaust Steam or Pressure Cure.

Durometer of Face Material: Shore A Scale

Pressure Cure: 90 to 100

Atmospheric Cure: 85 to 95

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: Typical 2 hours @ 260° (127° C) Reference Section 8, Preface for Clarification
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 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	2400
% Elongation at break	ASTM D412	100
Durometer	ASTM D2240	95A
Specific Gravity	ASTM D927	1.18
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.

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:

- Caution: Hard rubber linings may crack when subjected to thermal or mechanical shock.
 - After cure is complete bring down temperature slowly. For example; a maximum of 50°F (10°) per hour. When pressure curing bring temperature down under air pressure and follow the above temperature parameters.
 - Mark outside of hard rubber lined vessels with signs that would indicate prevention of mechanical shock. For example; a “do not use hammer or striking symbol”.
 - Do not transport or move hard rubber lined vessels below 20°F (-5°C).
- A heated table that warms rubber to 120°F is best for application. Do not pile rubber up hot or a fire could result. Ensure even scrap is allowed to cool before disposal.
- Plying up layers of rubber lining thicker than 1/2” other than for a 2” seam could result in the rubber exotherming or blister apart during cure. Do a test plate to determine thick rubber cure characteristics.
- 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).