



# LS507

**Description:** PLIOWELD Black, semi-hard, natural/synthetic blend for general purpose and oxidizing media. Exhaust Steam or Pressure Cure. Grey Tie Gum.

**Durometer of Face Material:** Shore A Scale.  
**Pressure Cure:** 85 to 100  
**Atmospheric Cure:** 80 to 100

**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:**

<b>Autoclave:</b> 2 hours @ 275°F (135°C)
<b>Internal Pressure:</b> 12 hours @ 250°F (122°C)
<b>Atmospheric:</b> Warm up: increase temperature gradually using 4 hours to reach 150° F (65°C). Maintain temperature for 6 hours, then gradually increase. Cure: 16 to 20 hours @ 185°F (85°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 C922BN chemical cure repair 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	1700
% Elongation at break	ASTM D412	150
Durometer	ASTM D2240	85A
Specific Gravity	ASTM D927	1.37
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.

**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. 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).