LS585

Description: PLIOWELD White chlorobutyl lining for phosphoric acid. Exhaust Steam or Pressure Cure.

Durometer of Face Material: Shore A Scale.
Pressure Cure: 40 to 55
Atmospheric Cure: 40 to 55

Available Gauges: 1/8", 3/16", ¼"; 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 #103
On the rubber:	Tack #103

Skive: Closed

Cure Methods and Times:

Autoclave: 1/8" to ¼" 1 hour @ 275ºF (135ºC) 3/8" to ½" 2 hours @ 275ºF (135ºC)
Internal Pressure: 8 hours @ 260ºF (127ºC) For insulated vessels : 4 hours at 260ºF (127ºC)
Atmospheric: 2 Step process Step 1 – 6 hours from Ambient to 160ºF (71ºC) Step 2 – 24 hours @180ºF (82ºC) or 20 hours @ 200ºF (94ºC) 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 Section14 – Curing Instructions.

Repairs: Repair with original lining or C629WC. 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	1225
% Elongation at break	ASTM D412	850
Durometer	ASTM D2240	52A
Specific Gravity	ASTM D927	1.31
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 rubber lining, always apply plastic side down against the substrate.

1. This lining is also available in the following versions: Without tie gum – uses the same adhesive system. With Tacky Back® - does not require Tack 103 on the rubber.

Applicator Notes:

1. For vacuum vessel curing instructions contact Blair Rubber Company's Technical Department.
2. Always apply plastic side down against the substrate.
3. A heated table that warms rubber to 120º F is best for application.
4. The temperature of the substrate must be greater than 60º F (15º C) prior to applying primer and rubber. Temperatures should not exceed 120º F (48º C).

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