



HB50HT

Description: MARFLEX Halobutyl – Superior Temperature Resistance to Acids and Caustic Solutions up to 260° F. With Tie Gum.

Durometer of Face Material: Shore A Scale.
Pressure Cure: 55 to 65
Atmospheric Cure: 45 to 60

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
On the seams	Tack 500

Skive: Closed

Cure Methods and Times:

Autoclave: 2 hours @ 290° F (143° C)
Internal Pressure: 8 hours @ 260°F (127°C)
Atmospheric: Up to 1/4" 48 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	1200
% Elongation at break	ASTM D412	350
Durometer	ASTM D2240	55A
Specific Gravity	ASTM D927	1.35
Adhesion to Metal	ASTM D429	25 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 and chemical resistance of the completed rubber lining, always apply plastic side down against the substrate.

Applicator notes:

Skive: Open when the above application method is used.

1. Tacky Back tie gum is also available on special order. This option eliminates the need to apply Tack #3 adhesive to the back of the rubber lining. This reduces VOC exposure to your crew and shortens application time.
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).



Section 4: Lining Specification

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