

INNOVATION TO MAKE IT FIRST,  
QUALITY TO MAKE IT LAST.



# BLAIR

## RUBBER COMPANY

ISO 9001:2008 CERTIFIED



**BLAIR**  
RUBBER COMPANY  
5020



**Enduraflex Quality**  
**Splicing and Repair Materials**  
Conveyor, Elevator, and Transmission Belts

[www.blairrubber.com](http://www.blairrubber.com)

## Blair Rubber Belt Splice Products

Blair Rubber is the leader in vulcanized splicing materials. We have set the standard for service and quality throughout the industry.

Our materials are kept in cold storage and ready for shipment in order to meet your needs. In most cases we are able to ship the same day. Our experienced staff is available to provide assistance and answer any questions you may have.

### Standard Tie Gums Available for Textile Belt Splicing

GRADE	GAUGE	WIDTH	LENGTH	PRODUCT NUMBER
HI-T	0.020"	9"	5 Yards	30001
HI-T	0.030"	9"	5 Yards	30002
HI-T	0.045"	9"	5 Yards	30003
HI-T	0.020"	18"	10 Yards	30101
HI-T	0.030"	18"	10 Yards	30102
HI-T	0.045"	18"	10 Yards	30103
HI-T	0.060"	18"	10 Yards	30104
S	0.020"	9"	5 Yards	30201
S	0.030"	9"	5 Yards	30202
S	0.045"	9"	5 Yards	30203
S	0.020"	18"	10 Yards	30301
S	0.030"	18"	10 Yards	30302
S	0.045"	18"	10 Yards	30303
S	0.060"	18"	10 Yards	30304
H	0.020"	9"	5 Yards	30401
H	0.030"	9"	5 Yards	30402
H	0.020"	18"	10 Yards	30501
H	0.030"	18"	10 Yards	30502
B	0.020"	9"	5 Yards	30601
B	0.030"	9"	5 Yards	30602
B	0.020"	18"	10 Yards	30701
B	0.030"	18"	10 Yards	30702
BNI	0.020"	9"	5 Yards	30801
WNI	0.020"	9"	5 Yards	30901



## Standard Cover Stocks Available for Textile Belt Splicing

GRADE	GAUGE	WIDTH	LENGTH	PRODUCT NUMBER
C	1/32"	18"	2 ½ Yards	31000
C	1/32"	18"	10 Yards	31001
C	1/16"	18"	2 ½ Yards	31002
C	1/16"	18"	10 Yards	31003
C	1/8"	18"	2 ½ Yards	31004
C	1/8"	18"	10 Yards	31005
C	3/16"	18"	2 ½ Yards	31006
C	3/16"	18"	10 Yards	31007
S	1/32"	18"	2 ½ Yards	31100
S	1/32"	18"	10 Yards	31101
S	1/16"	18"	2 ½ Yards	31102
S	1/16"	18"	10 Yards	31103
S	1/8"	18"	2 ½ Yards	31104
S	1/8"	18"	10 Yards	31105
S	3/16"	18"	2 ½ Yards	31106
S	3/16"	18"	10 Yards	31107
H	1/16"	18"	2 ½ Yards	31201
H	1/8"	18"	2 ½ Yards	31202
H	3/16"	18"	2 ½ Yards	31203
EP	1/32"	18"	2 ½ Yards	31300
EP	1/16"	18"	2 ½ Yards	31301
EP	1/8"	18"	2 ½ Yards	31302
EP	3/16"	18"	2 ½ Yards	31303
B	1/32"	18"	2 ½ Yards	31350
B	1/16"	18"	2 ½ Yards	31351
B	1/8"	18"	2 ½ Yards	31352
B	3/16"	18"	2 ½ Yards	31353
BNI	1/32"	18"	2 ½ Yards	31450
BNI	1/16"	18"	2 ½ Yards	31451
BNI	1/8"	18"	2 ½ Yards	31452
BNI	3/16"	18"	2 ½ Yards	31453
WNI	1/32"	18"	2 ½ Yards	31500
WNI	1/16"	18"	2 ½ Yards	31501
WNI	1/8"	18"	2 ½ Yards	31502
WNI	3/16"	18"	2 ½ Yards	31503
GB	1/16"	18"	10 Yards	34002
GB	1/8"	18"	10 Yards	34001

## Standard Breaker Fabrics, Holland Cloth & Cements

GRADE	WIDTH	LENGTH	PRODUCT NUMBER
Multiwarp 12 - 120# Breaker	9"	2 ½ Yards	32200
Multiwarp 12 - 120# Breaker	9"	10 Yards	32201
Multiwarp 12 - 120# Breaker	54"	50 Yards	32202
011 Bare - 90# Breaker	19"	2 ½ Yards	32218
011 Bare - 90# Breaker	19"	10 Yards	32217
Multiwarp 300 - 300# Breaker	54"	1 Yard	33200
4.1 oz Leno 120# Breaker	18"	2.5 Yards	32219

## Miscellaneous Products

DESCRIPTION	WIDTH	LENGTH	SIZE	PRODUCT NUMBER
Solvent R-587-T			1 Gallon	32251
Solvent R-587-T			5 Gallons	32249
Holland Cloth Release Fabric	40"	10 Yards		32252
Holland Cloth Release Fabric	40"	50 Yards		32253

## Standard Splicing Cements

GRADE	SIZE	PRODUCT NUMBER
B636/637 2 PART	Quart	32300
B636/637 2 PART	Gallon	32301
GRADE S	Quart	32311
GRADE S	Gallon	32312
GRADE S	5 Gallons	32313
GRADE H	Quart	32320
GRADE B	Quart	32330
GRADE B	Gallon	32331
OTP Fabric Primer	Gallon	32381
NORMAC 900R Cold Bond Adhesive	Gallon	6115



## Cure Times and Temperatures for Double Platen Vulcanizers

(Single Platen Vulcanizers are not recommended)

### Cure Times.

\*Add 20 minutes for Neoprene belts.

BELT GAUGE	CURE TIME
UP TO 1/8"	30 minutes
1/8" TO 1/4"	35 minutes
1/3" TO 3/8"	35 minutes
3/8" TO 1/2"	40 minutes
1/2" TO 5/8"	50 minutes
5/8" TO 3/4"	50 minutes
3/4" TO 7/8"	55 minutes
7/8" TO 1"	60 minutes
1" TO 1 1/8"	80 minutes
1 1/8" TO 1 1/4"	80 minutes
1 1/4" TO 1 3/8"	85 minutes
1 3/8" TO 1 1/2"	90 minutes
1 1/2" TO 1 5/8"	90 minutes
1 5/8" TO 1 3/4"	95 minutes

### Cure Temperatures

Butyl, EPDM, Nitrile (B, EP, BNI)	310°F
GRADE S, GRADE C	290°F

### Curing Tips

1. Use side irons on each edge of the belt, full length of the vulcanizer to prevent the platens from bowing under pressure, and to contain the flow. The irons should extend outside of the vulcanizer and should be clamped across the width of the belt to hold the irons during the cure.
2. Do not start timing the cure until the vulcanizer reaches recommended temperature. Always start with a cold press.
3. Cool to 170°F before opening.
4. Trim at flash and trim to width after the splice is complete.
5. For multiple cures the vulcanizer should overlap each heat by 2 to 4 inches.
6. The vulcanizer should cover the full uncured splice plus a minimum overlap of 2" into the factory cured belt ends.





## Estimated Textile Belt Material Splice Requirements for One Splice Double for Two Splices

Listed below is a computation table that gives the quantities of various items required for various width belts. The tie gum and cover gauges will need to be established to match the belt being spliced.

When selecting belt cover gauges, subtract 1/16" from the actual belt cover thickness as the breaker and tie gum will make up for the difference. For example, a 1/4" x 1/8" belt will only require 3/16" and 1/16" cover material for the splice.

WIDTH	PLIES	CEMENTS	TIE GUM	COVER	BREAKER
36"	2	1 QT.	1 RL.	1 RL./ 1 RL.	1 RL.
36"	3	2 QT.	1 RL.	1 RL./ 1 RL.	1 RL.
36"	4	2 QT.	1 RL.	1 RL./ 1 RL.	1 RL.
48"	2	2 QT.	1 RL.	1 RL./ 1 RL.	1 RL.
48"	3	2 QT.	2 RL.	1 RL./ 1 RL.	2 RL.
48"	4	2 QT.	2 RL.	1 RL./ 1 RL.	2 RL.
60"	2	2 QT.	2 RL.	1 RL./ 1 RL.	2 RL.
60"	3	2 QT.	2 RL.	1 RL./ 1 RL.	2 RL.
60"	4	2 QT.	2 RL.	1 RL./ 1 RL.	2 RL.
72"	2	2 QT.	2 RL.	1 RL./ 1 RL.	2 RL.
72"	3	2 QT.	3 RL.	1 RL./ 1 RL.	2 RL.
72"	4	2 QT.	3 RL.	1 RL./ 1 RL.	2 RL.

## Recommended Splice Material Usage Table

GENERAL PURPOSE			OIL SERVICE			ELEVATED TEMPERATURE					FIRE RESISTANT		
Cover Grade	Nat. Rbr.	SBR	SBR Nit.	Nitrile	Neop	Hot SBR	Butyl	EPDM	Coke SBR	Nitrile	SBR Neop	SBR Nit.	SBR
C	✓	✓	✗	✗	✗	✗	✗	✗	✓	✗	✗	✗	✗
S	◆	◆	✓	◆	✓	✗	✗	✗	◆	◆	✓	✓	✓
H	✗	✗	✗	✗	✗	✓	✗	✗	✗	✗	✗	✗	✗
B	✗	✗	✗	✗	✗	✗	✓	◆	✗	✗	✗	✗	✗
EP	✗	✗	✗	✗	✗	✗	◆	✓	✗	✗	✗	✗	✗
BNI	✗	✗	◆	✓	✗	✗	✗	✗	✗	✓	✗	✗	✗
WNI (FDA)	✗	✗	✗	✓	✗	✗	✗	✗	✓	✗	✗	✗	✗

✓ = Recommended

◆ = Substitution

✗ = Not Recommended

SPLICE KIT	COVER STOCK	FILL IN FABRIC	CEMENT	TIE GUM
C	Nat. Rbr.	Grade C	B636/637	HI-T
S	Neoprene	Grade S	S	S
H	SBR	Grade H	H	H
B	Butyl	Grade B	B	B
EP	EPDM	Grade EP	B	B
BNI	Nitrile (Black)	Grade BNI	S	BNI
WNI	Nitrile (White)	Grade WNI	202	WNI

## Expiration Dates

**WARNING:** Care must be taken to ensure the proper grade of material is used in all splices and that only fresh materials are used within their proper recommended shelf life. Listed below is a general guide for your use provided that the material is refrigerated at 50°F (10°C).

All rubber and un-opened cements	6 months
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## Terms and Conditions of Sales

Net 30 days, F.O.B. shipping point.

Minimum Order Charge - \$100.00

All shipments will be billed at prices in effect on date of shipment.

## Disclaimer

Blair Rubber Company provides information, written and verbal, relative to belting which it has gathered from a multitude of sources. However, such information is offered as a guide only; and therefore, Blair Rubber Company does not assume liability whatsoever, in regard to the use of this information.

The user of this information must determine the suitability of this information, and if more information is needed, the user should contact the appropriate belting manufacturer.

Since the application of technical information supplied by Blair Rubber Company may be affected dramatically by many factors such as, the length of exposure to a particular substance, the concentration of any such substance, synergistic effects, exposure to more than one substance and/or a wide range of belting products and temperatures, the enclosed should only be used as a guide. Blair Rubber Company, accordingly, disclaims liability for damages of any kind, including consequential damages, resulting from reliance on the information supplied herein.

## Warranty

All first quality merchandise manufactured or sold by Blair Rubber Company is warranted to be free from defect in material and workmanship.

Our liability with respect thereto is limited, however, to your net purchase price after cash and other discounts of any such merchandise proved defective or, at our option, to the repair or replacement of such merchandise upon its return to use, transportation charges, prepaid and in either case, after a pro rated charge for any service rendered. No claim will be allowed by us on any item of merchandise purchased for further processing unless we are notified thereof within thirty (30) days after your receipt thereof and are permitted to examine it before use or processing for a particular purpose and we shall not be subject to liability for any damages resulting from the handling, use or further processing of said merchandise whether alone or in combination with other materials. In no event shall the seller be liable for any incidental, consequential or special damages.

## Return Goods Policy

No materials may be returned until authorization is received from Customer Service.

All returns on first class material will be subject to a 15% restocking charge when done for customer convenience. This will apply to current inventoried items only. Non inventoried items may not be returned for customer convenience.

## Additional Products and Service

### Enduraflex, Plioweld, & Marflex tank linings

-Over 35 available

### Chemcure, Non-Flammable

-Activator for chemical cure linings

### Custom Mixing

-To your formulations

### Endurabond Adhesives

-Primers & Tack Cements

### Custom Calendering

-To your specifications



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