



# VE350CPETN

**Description:** ENDURAFLEX – Black, Improved resistance to Hydrochloric Acid with Organic Chlorides.  
 CPE Cap material must also be ordered when ordering this rubber lining. Exhaust Steam or Pressure Cure.

**Durometer of Face Material:** Shore A Scale  
**Pressure Cure:** 65 to 75  
**Atmospheric Cure:** 65 to 75

**Available Gauges:** 1/8", 3/16", 1/4"; 4 mm, 5mm, & 6mm.

**Adhesive Systems, use one or the other:**  
**Adhesives:** ENDURABOND SYSTEM for

1st coat on metal:	Primer #1
2nd coat on metal:	Intermediate #2
3rd coat on metal:	Tack #3
On the rubber:	Tack #3
On cap seams	CPE Tack Part A & B

**ENDURABOND 2001 SYSTEM**

1st coat on metal:	Primer 2001
2nd coat on metal:	Tack #3
On the rubber:	Tack #3
On cap seams	CPE Tack Part A & B

**Skive:** BUTT/CAP. See CPE CAP Specification.

**Cure Methods and Times:**

<b>Autoclave:</b> 2 Hours @ 275° F (71° C)
<b>Internal Pressure:</b> 6 Hours at 260° F (127° C)
<b>Atmospheric:</b> 2 Step process Step 1 – 6 hours from ambient to 160° F (71° C) Step 2 – 24 hours at 180° F (82° C) or 20 hours at 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	N/A
% Elongation at break	ASTM D412	N/A
Durometer	ASTM D2240	65 A
Specific Gravity	ASTM D927	1.30
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.

Rubber is against the plastic leaving the CPE on top of the tan natural rubber.

**Applicator Notes:**

- The lining must be preheated on a hot table to 100°F to 120°F to soften the lining and assure a good bond of the butt skive joint. The skive of the butt joint should have a very slight overlap that will produce a slight hump to assure complete adhesion of the joint. This also aids in the application of the CPE cap strip overlap easier.
- If there is any evidence of poor bonding of the joint, use a heat gun to reheat the area and stitch again.
- Over heating of the cap makes it very plastic and easily damaged if excessive stitcher pressure is used.**
- Avoid the spillage of Tack #3 on the CPE cap seam area, as this will decrease the bond of the butt and cap joint.**
- 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).