



VE514BN

Description: ENDURAFLEX Black, soft, natural rubber for abrasion and general purpose chemical service. Exhaust Steam or Pressure Cure.

Durometer of Face Material: Shore A Scale
Pressure Cure: 50 to 60
Atmospheric Cure: 50 to 60

Available Gauges: 1/8", 3/16", 1/4", & 1/2"
 3mm, 4mm, 5mm, 6mm & 10mm

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 |

ENDURABOND 2001 SYSTEM

| | |
|--------------------|-------------|
| 1st coat on metal: | Primer 2001 |
| 2nd coat on metal: | Tack #3 |
| On the rubber: | Tack #3 |

Skive: Open

Cure Methods and Times:

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|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| Autoclave: 1/8" to 1/4" 1 hour @ 275°F (135°C) 3/8" to 1/2" 2 hours @ 275°F (135°C) |
| Internal Pressure: 6 hours @ 260°F (127°C) |
| Atmospheric: 2 Step process Step 1 – 6 hours from Ambient to 160°F (71°C) Step 2 – 24 hours @ 180°F (82°C) or 20 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 15 – Curing Instructions.

Repairs: Repair with original lining or C511BN chemical cure. See Section 17 – Repair Procedures.

Storage Life:

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|-----------------------------------------|--------------|
| 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 |

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.

Typical Physical Properties

| | | |
|------------------------|------------|---------|
| Tensile Strength – PSI | ASTM D412 | 2500 |
| % Elongation at break | ASTM D412 | 700 |
| Durometer | ASTM D2240 | 50A |
| Specific Gravity | ASTM D927 | 1.09 |
| Adhesion to Metal | ASTM D429 | 30 Lbs. |

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. Plying up layers of rubber lining thicker than 1/2" could result in the rubber flowing or sagging during cure. Do a test plate to determine flow characteristics.
2. The temperature of the substrate must be greater than 60° (15° C) prior to applying primer and rubber. **Temperatures should not exceed 120° F (48° C).**



Section 2: Lining Specification

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