



VE515BNI

Description: ENDURAFLEX Black, soft, nitrile lining for general purpose when petroleum oils are present.

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"; 4 mm, 5 mm, & 6mm.

Adhesive System:

Adhesives: ENDURABOND System for Synthetics

1st coat on metal:	Primer P-100
2nd coat on metal:	Intermediate I-100
3rd coat on metal:	Tack 201
On the rubber:	Tack 201

Skive: Open

Cure Methods and Times:

Autoclave: 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. See Section 17 – 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	2200
% Elongation at break	ASTM D412	700
Durometer	ASTM D2240	55A
Specific Gravity	ASTM D927	1.24
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 of the completed rubber lining, always apply plastic side down against the substrate.

Caution: Soft nitrile 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. A heated table that warms rubber to 120°F is best for application.
2. Lining may shrink 10% lengthwise after unrolling. Preshrink rubber before applying or during the cure the lining will lift away, requiring repair.
3. 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).
4. This rubber lining cannot be overly stretched. It must be gently folded to cover the area to be lined and then firmly rolled down. **Do not attempt to push or force the lining down into corners.** Stretching the rubber will cause the lining and seams to lift during cure. Use "V-beads" in corners and sharp angles to prevent any stretching.
5. Strict adherence to adhesive specifications is required. Tack time is also critical to the success of the bond. **Application of multiple coats of adhesive will be detrimental to the bond.**



Section 2: Lining Specification

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