



VE516BC

Description: ENDURAFLEX Black, soft chlorobutyl lining for oxidizing solutions such as bleach and high temperature applications. Rubber lining comes with “Butyl Tacky Back”. Exhaust Steam or Pressure Cure.

Durometer of Face Material: Shore A Scale

Pressure Cure: 40 to 55

Atmospheric Cure: 40 to 55

Available Gauges: 1/8”, 3/16”, ¼”; 4 mm, 5 mm, & 6mm. ¼” (5-6 mm) VE536BC is preferred.

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:	500 Tack

Skive: Open, Butt & Cap seams with VE516BC.

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 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	1400
% Elongation at break	ASTM D412	700
Durometer	ASTM D2240	43A
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.

Applicator Notes:

1. Seams can be applied with butt/cap method.
2. Manufactured with Tacky Back[®] does not require Tack 500 on the rubber.
3. For Hot Water Cure consult with Blair Rubber Company’s technical department. When using this method a qualified steel structural design engineer must be consulted due to stresses placed on vessel.
4. For vacuum vessel curing instructions contact Blair Rubber Company’s Technical Department.
5. A heated table that warms rubber between 110° F to 120° F is best for ease of application.
6. 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 2: Lining Specification

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