



VE610BNE

Description: ENDURAFLEX Black, soft, neoprene lining for general purpose use. Competitive grade. Exhaust Steam or Pressure Cure.

Durometer of Face Material: Shore A Scale

Pressure Cure: 55 to 65

Atmospheric Cure: 50 to 65

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

Adhesive Systems:

Adhesives: ENDURABOND 1*2*3 SYSTEM

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

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 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	1700
% Elongation at break	ASTM D412	750
Durometer	ASTM D2240	55A
Specific Gravity	ASTM D927	1.39
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. 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.
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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