



# VE620BHWTG

**Description:** ENDURAFLEX Black, Hypalon Lining with Neoprene Tie Gum for High Temperature and Strong Oxidizing Acids. Exhaust Steam or Pressure Cure.

**Durometer of Face Material:** Shore A Scale

**Pressure Cure:** 55 to 65

**Atmospheric Cure:** 55 to 65

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

**Adhesive System:**

**Adhesives:** ENDURABOND

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

**Skive:** Closed

**Cure Methods and Times:**

<b>Autoclave:</b> 3 hours @ 275°F (135°C)
<b>Internal Pressure:</b> 8 hours @ 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 @ 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)	30 days
From 55° F (13° C) to 65° F (19° C)	45 days
From 70° F (21° C) to 85° F (30° C)	15 days
Above 90° F (32° C)	5 days

### Typical Physical Properties

Tensile Strength – PSI	ASTM D412	1800
% Elongation at break	ASTM D412	600
Durometer	ASTM D2240	60A
Specific Gravity	ASTM D927	1.41
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.

### Applicators Notes:

1. This material has a short shelf life. Works best if applied within two weeks of the delivery.
2. 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

Date: February 9, 2007 Revision No.0