C613BNE

Enduraflex™ black, soft, neoprene lining, chemical cure for field lining and repair. FDA compliant when Chemcure II™ is used to cure the rubber.

SPECIFICATIONS

FACE MATERIAL DUROMETER, ATMOSPHERIC CURE:
60 to 75 A

AVAILABLE GAUGES:
1/8", 3/16", 1/4", 4mm, 5mm, 6mm

SKIVE:
Open

REPAIRS:
Repair with original lining.
See Section 16 – Repair Procedures.

TYPICAL PHYSICAL PROPERTIES

Tensile Strength PSI	ASTM D412	1100
% Elongation at Break	ASTM D412	275
Durometer	ASTM D2240	70 A
Specific Gravity	ASTM D297	1.29
Adhesion to Metal	ASTM D429	25 LBS

Notes: For the best appearance of the completed rubber lining, always apply plastic side down against the substrate.

Chemcure II™ must be used in order to meet FDA requirements.

CURE METHODS AND TIMES:

Atmospheric	Apply two coats of Chemcure™ or Chemcure II™ on lining face with approximately 60 minutes of drying time between coats. Cure approximately 14 days at room temperature.
	Exhaust Steam Assist: Gradually increasing the temperature to 160°F (71°C) for 8 to 12 hours by exhaust steam will result in an accelerated cure.
	Dry heat 20 hours at 120°F (49°C)

Note: Cure times may require adjustment to compensate for heavy metal thickness, low exterior temperatures or other unusual factors. See Section 14 – Curing Instructions.

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STORAGE LIFE FROM DATE OF SHIPMENT

32°F (0°C) to 50°F (10°C)	180 days
51°F (13°C) to 65°F (19°C)	90 days
66°F (21°C) to 75°F (23°C)	60 days
76°F (24°C) to 85°F (30°C)	30 days

Storage temperature must not exceed 85°F (30°C).

ADHESIVE SYSTEM
ENDURABOND™ 1*2*3 SYSTEM

1st coat on metal:	P-100
2nd coat on metal:	I-100
3rd coat on metal:	Tack 201
On the rubber:	Tack 201 (rubber to metal) Chemcure™ or Chemcure II™ on the face of the rubber after installation. -See applicator notes that explain Chemcure™ or Chemcure II™ use.

*Each adhesive component requires thorough mixing before application.

APPLICATOR NOTES

1. Used to repair VE610BNE, VE612BNE, AND VE713BNE.
2. Plying up layers of rubber lining thicker than ¼" could result in the rubber flowing or sagging during cure. Test plate is required to determine flow characteristics.
3. Without the addition of heat, plying up layers of rubber lining could result in the rubber not curing thoroughly. Chemical curatives rarely penetrate two layers. An addition of 10% Chemcure by volume to the tack cement is recommended between layers of rubber (see note #6).
4. 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 (49°C).
5. Chemcure™ & Chemcure II™ should not be applied if rubber temperatures are below 50°F (10°C) or above 140°F (60°C). Note: at the low end the cure time may take months.
6. Add 10% Chemcure™ by volume to the tack cement. Use this mixture wherever tack cement is required. This mixture has a pot life of approximately 6 hours.
7. A heated table that warms rubber to approximately 120°F (49°C) should be utilized prior to application.
8. Strict adherence to adhesive specifications is required. Tack time is critical to the success of the bond.
9. Apply two coats of Chemcure™ to the face of the rubber. Allow 60 minutes of drying time between applications.