MR80

Marflex™ black, ebonite natural rubber lining with excellent machinability. Particularly suitable for lining valves/pipes.

SPECIFICATIONS

FACE MATERIAL DUROMETER, ATMOSPHERIC CURE:
N/A

PRESSURE CURE:
75 to 85 D

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

SKIVE:
Open or closed

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

TYPICAL PHYSICAL PROPERTIES

Tensile Strength PSI	ASTM D412	4200
% Elongation at Break	ASTM D412	<5%
Durometer	ASTM D2240	82 D
Specific Gravity	ASTM D927	1.13
Adhesion to Metal	ASTM D429	30 LBS

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

Caution: This lining is susceptible to deterioration by sunlight and oxygen. This is known as 'weather checking'. Do not expose rubber lining to sunlight, ozone or oxygen.

CURE METHODS AND TIMES:

Autoclave	Up to 1/4" - 4 hours at 298°F (148°C) Multiple layers – 1 hour at 240°F followed by 4 hours at 298°F (148°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:	Primer #1
2nd coat on metal:	Intermediate #2
3rd coat on metal:	Tack #3
On the rubber:	Tack #3

*Each adhesive component requires thorough mixing before application.

APPLICATOR NOTES

1. Caution: Hard rubber linings may crack when subjected to thermal or mechanical shock.
   - After cure is complete bring down temperature slowly. For example; a maximum of 50°F (10°C) per hour. When pressure curing bring temperature down under air pressure and follow the above temperature parameters.
   - Mark outside of hard rubber lined vessels with signs that would indicate prevention of mechanical shock. For example; a “do not use hammer or striking symbol”.
   - Do not transport or move hard rubber lined vessels below 20°F (-5°C).
2. Plying up layers of rubber lining thicker than 1/2” other than for a seam could result in the rubber exotherming or blister apart during cure. Do a test plate to determine thick rubber cure characteristics.
3. A heated table that warms rubber to approximately 120°F (49°C) is best for application.
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. Strict adherence to adhesive specifications is required. Tack time is critical to the success of the bond.
6. An excellent rubber lining for intricate grinding or machining work (cured).