

C633BN

Enduraflex™ black, soft/semi-hard/soft Tri-Bond™ chemical cure natural rubber chemical cure for field lining and repair. FDA compliant when Chemcure II™ is utilized.

SPECIFICATIONS

Durometer of Face Material:

Shore A Scale

Atmospheric Cure:

44-65 A

Skive:

Open

Repairs:

Repair with original lining.
See Section 16 – Repair Procedures

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 (23°C) to 85°F (30°C) – 30 days

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

Caution: Natural rubber 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:	
Atmospheric	Apply 2 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.

ADHESIVE SYSTEM/CHEMCURE:	
1 st Coat on Metal	Chemlok® 289
2 nd Coat on Metal	Chemlok® 290
3 rd Coat on Metal	Chemlok® 286
On the rubber	Chemlok® 286
On the rubber	Chemcure or Chemcure II (2 coats)

* Each adhesive component requires thorough mixing before application.

TYPICAL PHYSICAL PROPERTIES		
Tensile Strength PSI	ASTM D412	1100
% Elongation at Break	ASTM D412	400
Durometer	ASTM D2240	51 A
Specific Gravity	ASTM D927	1.23
Adhesion To Metal	ASTM D429	25 lbs.

APPLICATOR NOTES

1. Adding 10% Chemcure™ by volume to the tack cement wherever tack cement is required will aid in curing the cement and underside of lining. 6 hour pot life.
2. Plying up layers of rubber lining thicker than 1/4" could result in the rubber flowing or sagging during cure. Test plate is required to determine flow characteristics.
3. 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).
4. A heated table that warms rubber to approximately 120°F (49°C) prior to application is recommended.
5. Strict adherence to adhesive specifications is required. Tack time is critical to the success of the bond.

Disclaimer: The above guidelines are based on general industry practices and not applicable to all installations. Please contact Blair Rubber company for specific application instructions. Application methods shall conform to Blair Rubber Company instructions contained in the Engineering & Applicator manual. Deviations from the specifications must be approved in writing by Blair Rubber Company. Data values are approximate and may vary based on installation techniques and atmospheric conditions. As such, data values should be used as general guidelines and are not a legally binding warranty of product characteristics. This document is copyright to and intellectual property of Blair Rubber company and may not be copied or distributed without prior consent.