VE612BNE

Enduraflex™ black, soft, neoprene lining for general purpose abrasion and chemical resistance. FDA compliant.

SPECIFICATIONS

Durometer of Face Material:
Shore A Scale

Atmospheric Cure:
50-65 A

Pressure Cure:
55-65 A

Skive:
Open

Repairs:
Repair with original lining or C613BNE
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).

CURE METHODS AND TIMES:

<table>
<thead>
<tr>
<th>Method</th>
<th>Cure Time</th>
</tr>
</thead>
<tbody>
<tr>
<td>Autoclave</td>
<td>2 hours at 275°F (135°C)</td>
</tr>
<tr>
<td>Internal Pressure</td>
<td>6 hours at 260°F (127°C)</td>
</tr>
<tr>
<td>Atmospheric</td>
<td>Step 1 Observe a gradual warm-up time until reaching 160°F (71°C)</td>
</tr>
<tr>
<td></td>
<td>Step 2 24 hours at 180°F (82°C) or 20 hours at 200°F (94°C)</td>
</tr>
</tbody>
</table>

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

1st Coat on Metal Chemlok® 205
2nd Coat on Metal Chemlok® 234B
3rd Coat on Metal Tack 201
On the rubber Tack 201

* Each adhesive component requires thorough mixing before application.

TYPICAL PHYSICAL PROPERTIES

<table>
<thead>
<tr>
<th>Property</th>
<th>Standard</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Tensile Strength</td>
<td>ASTM D412</td>
<td>2100</td>
</tr>
<tr>
<td>% Elongation at Break</td>
<td>ASTM D412</td>
<td>500</td>
</tr>
<tr>
<td>Durometer</td>
<td>ASTM D2240</td>
<td>58 A</td>
</tr>
<tr>
<td>Specific Gravity</td>
<td>ASTM D927</td>
<td>1.35</td>
</tr>
<tr>
<td>Adhesion To Metal</td>
<td>ASTM D429</td>
<td>30 lbs.</td>
</tr>
</tbody>
</table>

APPLICATOR NOTES

1. Neoprene may shrink 10% lengthwise after unrolling. Preshrink rubber before application.
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 (49°C).
3. A heated table that warms rubber to approximately 120°F (49°C) prior to application is recommended.
4. Strict adherence to adhesive specifications is required. Tack time is critical to the success of the bond.
5. Plying up layers of rubber lining thicker than 1/4” could result in rubber flow or sagging during cure.