

## VE621BC

Plioweld™ black, soft, chlorobutyl lining for general purpose chemical resistance. Not recommended for bleach service. FDA compliant

### SPECIFICATIONS

#### Durometer of Face Material:

Shore A Scale

#### Atmospheric Cure:

50-60 A

#### Pressure Cure:

55-65 A

#### Skive:

Closed

#### Repairs:

Repair with original lining or C623BC  
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:

Autoclave	2 hours at 275°F (135°C)
	Vacuum service: 6 hours at 275°F (135°C)
Internal Pressure	10 hours at 260°F (127°C)
	Vacuum service: 58 hours at 250°F (121°C)
Atmospheric	Step 1 – Observe a gradual warm-up time until reaching 160°F (71°C)
	Step 2 – 24 hours at 180°F (82°C) or 20 hours at 200°F (94°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

1 <sup>st</sup> Coat on Metal	Chemlok® 289
2 <sup>nd</sup> Coat on Metal	Chemlok® 290
3 <sup>rd</sup> Coat on Metal	Chemlok® 286
On the rubber	Chemlok® 286

\* Each adhesive component requires thorough mixing before application.

### TYPICAL PHYSICAL PROPERTIES

Tensile Strength PSI	ASTM D412	1000
% Elongation at Break	ASTM D412	550
Durometer	ASTM D2240	57 A
Specific Gravity	ASTM D927	1.39
Adhesion To Metal	ASTM D429	30 lbs.

### APPLICATOR NOTES

1. 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.
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.

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.