

## TECHNICAL DATA SHEET

# 4631

## BLENDED CHLOROBUTYL LINING

October 1, 2010

**Polycorp 4631** is a black, 55A durometer blended natural/chlorobutyl lining for reducing” chunking” on the ceiling of HCL tank cars. A-I Cure. FDA compliant as per 21CFR177.2600.

### Application Notes:

- **Skive** – use open skive construction
- **Repair** – Same or chemical cure 2040.
- **Cured Durometer** – Shore A Durometer of top surface: 55 ± 5.
- A heated table to warm the rubber to 110–120°F (43°C) is recommended
- **Spark Test** – Refer to section 13 of the Application Manual

### Adhesive Notes:

See Section 9 of the Polycorp Rubber Lining Application Manual for specific cementing / adhesion notes.

For proper adhesion, temperatures must be over 60°F (15°C) and must not exceed 120°F (49°C). Use adhesives in well ventilated area and always consult the material safety data sheet for specific precautions. If cement is used on lining please ensure complete drying.

<u>Coat</u>	<u>Polycorp Adhesive</u>	<u>Approved Equivalent</u>
1 <sup>st</sup> Coat on Natural Rubber Lining	C-210S Tack Cement	Chemlok 286
2 <sup>nd</sup> Coat on 4631 Lining	C-210S Tack Cement	Chemlok 286

For distributors of Chemlok adhesives, see Section 9 of the Application Manual

### Curing:

Cure time adjustments may be required to compensate for specific conditions. See Section 11 of the Application Manual for detailed instructions.

### Internal Steam Method – 3/16” thickness:

Add 1 ½ hours of cure onto regular cure cycle.

### Storage:

Store in a cool, dry area.

### Shelf Life:

Stored below 50°F (10°C)	180 days
Stored between 51 and 70°F	60 days
Stored between 71 and 90°F	30 days
Do not store above 90°F (32°C)	

Storage, handling and application methods must conform to the Polycorp Rubber Lining Application Manual

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### Typical Properties:

<u>Property</u>	<u>Value</u>	<u>ASTM Test Method</u>
Hardness (Face)	55 A $\pm$ 5	D2240
Tensile Strength (min, psi)	1400	D412
Elongation at Break (min, %)	500	D412
Specific Gravity	1.30	D927
Adhesion to Metal (min, lbs)	25	D429
Maximum Operating Temperature for Optimum Service Life	71°C/ 160°F	N/A

All physical property values developed and measured using a press-cured sample sheet prepared in accordance with ASTM D3182.