

TECHNICAL DATA SHEET

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1054

BLENDED CHLOROBUTYL LINING

October 1, 2010

Polycorp 1054 is a white 40 A durometer blended chlorobutyl lining with natural rubber tie gum. General chemical resistance in temperature applications up to 200 °F/93°C. A-I-E Cure. FDA compliant as per 21CFR177.2600

Application Notes:

- **Skive** – use closed skive construction
- **Repair** – Same or chemical cure 1058 with C-600 activator.
- **Cured Durometer** - Shore A Durometer of top surface: 40 ± 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.

<u>Coat</u>	<u>Polycorp Adhesive</u>	<u>Approved Equivalent</u>
1 st Coat on Metal	C-90 Primer	Chemlok 289
2 nd Coat on Metal	C-91 Intermediate	Chemlok 290
3 rd Coat on Metal	C-204S Tack	Chemlok 286
4 th Coat on lining	C-204S Tack	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.

Autoclave Method – Up to 1/4” thickness:

Slow rise to 250°F/121°C (15 psi). Hold 3 hours at 250°F/121°C (15 psi).

Internal Steam Method- Up to 1/4” thickness:

Slow rise to 250°F/121°C (15 psi). Hold 6 hours at 250°F/121°C (15 psi).

Atmospheric Steam Method – Minimum 24

hours at 212°F/100°C.

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)	40 A \pm 5	D2240
Tensile Strength (min, psi)	1000	D412
Elongation at Break (min, %)	400	D412
Specific Gravity	1.38	D927
Adhesion to Metal (min, lbs)	25	D429
Maximum Operating Temperature for Optimum Service Life	93°C / 200°F	N/A

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