

TECHNICAL DATA SHEET

5621

NEOPRENE LINING

October 1, 2009

Polycorp 5621 is a black 55A durometer lead cure neoprene lining with good abrasion, weathering, flame and corrosion resistance properties. Good machining properties. A-I-E Cure.

Application Notes:

- **Skive** – Use open skive construction
- **Repair** – With original lining
- **Cured Durometer** – Shore A Durometer of top surface: 55 A ± 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.

The temperature of the steel must be greater than 60°F (15°C) prior to applying primer and rubber. Temperatures 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-100 Primer	Chemlok 205
2 nd Coat on Metal	C-200 Intermediate	Chemlok 220
3 rd Coat on Metal	021052 Tack	021052 Tack
4 th Coat on lining	021052 Tack	021052 Tack

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

Curing:

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

Autoclave Method – Up to 1/4” thickness:

2 hours @ 275°F/135°C (30 psi).

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

6 hours @ 260°F/127°C (20 psi).

Atmospheric Steam Method – Up to 1/4” thickness:

2 Step process

Step 1 – 6 hours from Ambient to 160°F

Step 2 –24 hours @ 180°F (82°C)

or 20 hours @ 200°F

Atmospheric curing not recommended for vacuum service.

Storage:

Store in a cool, dry area.

Shelf Life:

Stored below 50°F (10°C)	120 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

TECHNICAL DATA SHEET

5621 Page 2 of 2

Typical Properties:

<u>Property</u>	<u>Value</u>	<u>ASTM Test Method</u>
Hardness (Face)	55 A \pm 5	D2240
Tensile Strength (min, psi)	1500	D412
Elongation at Break (min, %)	650	D412
Specific Gravity	1.38	D927
Adhesion to Metal (min, lbs)	25	D429
Maximum Operating Temperature for Optimum Service Life	95°C/203°F	N/A

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

PRECAUTIONS:

- Calendered stock typically has nerve. Warm stock to 120°F/49°C for ease of application.
- Pre-shrink rubber before applying.
- Ensure uniform heat distribution throughout the vessel during cure
- Lining may shrink 10% lengthwise after unrolling. Pre-shrink rubber before applying
- Works best if applied within two weeks of the delivery