

TECHNICAL DATA SHEET

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2019

SOFT NATURAL RUBBER LININGS

October 1, 2010

Polycorp 2019 is a black, 50A durometer soft chemical cure natural rubber. General purpose repair stock for black soft natural rubber. Activator C-600 (FDA compliant) or Activator C-700 (non-FDA compliant) is used to cure the rubber. Ambient cure or Steam Assist cure. FDA compliant as per 21CFR177.2600.

Application Notes:

- **Skive** – use open skive construction
- **Repair** – Same
- **Cured Durometer** – Shore A Durometer of top surface: 50 ± 10 .
- **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-202S Tack	Chemlok 286
4 th Coat on lining	C-202S 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. After application, brush the rubber surface with three (3) separate coats of C600 of C700 activator. Dry 30 minutes between each coat.

Ambient: The chemical cure lining will vulcanize in about 7-14 days at ambient temperature (75°F / 24°C).

Atmospheric Steam Assist: Introduce exhaust steam sufficient to insure contact with all surfaces. Approximately 8-12 hours in exhaust steam will be required to cure lining. More time may be necessary in a large tank, or if heat losses are large.

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)	50 A \pm 10	D2240
Tensile Strength (min, psi)	1000	D412
Elongation at Break (min, %)	500	D412
Specific Gravity	1.22	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.

SPECIAL TREATMENT AFTER APPLICATION:

- After application, brush the rubber surface with three (3) separate coats of C600 or C700 activator. Dry 30 minutes between each coat.
- Cement side of lining can be freshened with a solution of 6 parts toluene to one part C-600 by weight.
- **C700 cannot be used if for FDA service.**