

TECHNICAL DATA SHEET

1000

TRIFLEX 3-LAYER COMBINATIONS

October 1, 2010

Polycorp 1000 General purpose triflex tan natural rubber lining. Soft -Hard-Soft. Excellent in combined abrasion and chemical resistance. Flexible to withstand rapid changes in temperature and related expansion and contraction. A-I-E Cure. FDA compliant as per 21CFR177.2600

Application Notes:

- **Skive** – use closed skive construction
- **Repair** – same
- **Cured Durometer** - Shore A Durometer of top surface: 50 ± 10.
- The hardness on the surface may vary depending on thickness and lining method.
- **Spark Test** – Refer to section 13 of the Application Manual.
- Do not use in transport equipment
- Do not use on flange faces. Use Polycorp
- 1097 for flange faces.

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	202S Tack	Chemlok 286
4 th Coat on lining	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.

Autoclave Cure – 3/16” and ¼” thickness:
3 hours @ 260°F/127°C (20 psi)

Internal Steam Cure– 3/16”and ¼” thickness:
5 hours @ 267°F./131°C (25 psi) or 6 hours at 260°F./127°C (20 psi) or 10 hours @ 250° F. /121° C (15 psi.)

Internal Steam Method– 3/8” Thickness:
9 hours @ 267°F/131°C (25 psi.) or 12 hours @ 260 °F./127°C (20 psi.) or 24 hours. @ 250 F/ 121°C (15 psi.)

Atmospheric Steam Method– 3/16” and ¼” thickness:

Minimum 32 hours @ 212 °F/100°C.

Atmospheric Steam Method – 3/8” thickness:
Minimum 66 hours @ 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	90 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)	N/A	D412
Elongation at Break (min, %)	N/A	D412
Specific Gravity	1.027	D927
Adhesion to Metal (min, lbs)	Min. 25 lbs	D429
Maximum Continuous Operating Temperature for Optimum Service Life	68°C/ 155°F	N/A

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