1020 HT

TRIFLEX 3-LAYER COMBINATIONS

October 1, 2009

Polycorp 1020 HT Tan 50A durometer high temperature Triflex, excellent chemical resistance properties in high temperature services up to 220 F. Developed for phosphoric acid service. A-I-E Cure.

Application Notes:

- **Skive** – use closed skive construction
- **Repair** – same
- **Cured Durometer** – Shore A Durometer of top surface: 50 ± 10.
- **Precautions** – Cool down to 120°F/49°C before releasing pressure during pressure cure.
- **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.

Coat	Polycorp Adhesive	Approved Equivalent
1st Coat on Metal	C-90 Primer	Chemlok 289
2nd Coat on Metal	C-91 Intermediate	Chemlok 290
3rd Coat on Metal	C-202S Tack	Chemlok 286
4th 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.

Autoclave Method – 3/16" & 1/4" thickness:
3 hours @ 260°F/127°C (20 psi)

Internal Steam Method – 3/16" & 1/4" thickness:7 hours @ 260°F/127°C (20 psi)

Atmospheric Steam Method – Up to 1/4" thickness: 32 hours @ 212°F/100°C. Lower durometer readings with this type of cure

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

TECHNICAL DATA SHEET

Typical Properties:

Property	Value	ASTM Test Method
Hardness (Face)	50 A ± 10	D2240
Tensile Strength (min, psi)	N/A	D412
Elongation at Break (min, %)	N/A	D412
Specific Gravity	1.04	D927
Adhesion to Metal (min, lbs)	25	D429
Maximum Operating Temperature for Optimum Service Life	104° C/ 220°F	N/A

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