

TECHNICAL DATA SHEET

2045

HYPALON RUBBER LINING

October 1, 2009

Polycorp 2045 is a black, 60A durometer Hypalon rubber lining for high temperature and strong oxidizing Acids. Excellent for chrome plating solutions. A-I-E Cure.

Application Notes:

- **Skive** – Butt and Cap construction
- **Repair** – Same
- **Cured Durometer** – Shore A Durometer of top surface: 60 ± 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-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 specific conditions. See Section 11 of the Application Manual for detailed instructions.

Autoclave Method – Up to 1/4” thickness:

1 hour rise to 250°F/121°C (15psi). Hold 2 ½ hours @ 250°F/121°C (15 psi).

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

1 hour rise to 250°F/121°C (15 psi). Hold 5 hours @ 250°F/121°C (15 psi).

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

Slow rise to 212°F/100°C, hold for minimum 24 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 (21°C)	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)	60 A \pm 5	D2240
Tensile Strength (min, psi)	1500	D412
Elongation at Break (min, %)	500	D412
Specific Gravity	1.404	D927
Adhesion to Metal (min, lbs)	25	D429
Maximum Operating Temperature for Optimum Service Life	135°C/275°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 100°F/38°C to 120°F/49°C to preshrink the lining before cutting sheet to size.
- All seams should be made using a 45° skive butt seam and covered with a cap strip (4" wide x 3/32" thick) of plain hypalon.
- **Mating surfaces of cap strip and lining to be solvent washed only!!!**
- Preheat the sheet to 100°F/38°C to 120°F/49°C before applying.
- Rubber should be crowded rather than stretched during application.