

TECHNICAL DATA SHEET

1015

TRIFLEX 3-LAYER COMBINATIONS

September 21, 2011

Polycorp 1015 A 50D surface durometer triflex consisting of a semi-hard face with a hard natural rubber center layer and a soft natural rubber tie gum. Lining has excellent chemical and permeation resistance properties.

Application Notes:

- **Skive** – use closed skive construction.
- **Repair** – Same or 1038 semi-hard chemical cure.
- **Cured Durometer** – Shore D Durometer on 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.

Autoclave Method – 3/16” and 1/4” thickness:

1 hour rise to 260°F/127 °C (20 psi) hold @ 260°F for 2½ hours

Internal Steam Method - 3/16” and 1/4” thickness:

7 hours @ 260°F/127°C (20 psi).
12 hours @ 250°F/121°C (15 psi).
22 hours @ 240°F/116°C (10psi).

Atmospheric Steam Method – 1/4” thickness:

Minimum 40 hours @ 212°F/100°C
Lower durometer will result 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	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:

Property	Value	ASTM Test Method
Hardness (Face)	50D ± 10	D2240
Tensile Strength (min, psi)	N/A	D412
Elongation at Break (min, psi)	N/A	D412
Specific Gravity	1.22	D927
Adhesion to Metal (min, lbs)	25	D429
Maximum Operating Temperature for Optimum service Life	85°C/185°F	N/A

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

PRECAUTIONS:

- This is a hard rubber compound. Overcure will cause brittleness.
- Do not use in transport equipment or tanks to be installed outside.
- This lining may not be suitable for equipment that may be exposed to extremely low temperatures. If temperatures will be below 32 °F/0 °C, contact Polycorp with all the service conditions for a specific recommendation.
- Cool down to 120 °F/49 °C before releasing pressure during pressure cure.
- Do not ship lined tank below 20 °F