

TECHNICAL DATA SHEET

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SEMI-HARD CHEMICAL CURE

October 1, 2009

Polycorp 1038 Black, 85 A/35D durometer chemical cure semi-hard natural rubber with soft natural rubber tie gum. Repair stock for black semi-hard natural rubber. For FDA application use C-600 activator to cure the rubber and for Non-FDA application use C-700. Ambient cure or steam assist cure.

Application Notes:

- **Skive** – use closed skive construction
- **Repair** – Same
- **Cured Durometer** - Shore A Durometer of top surface: 85 ± 10.
- **Special Treatment After Application**- After application, brush the rubber surface three (3) separate coats of C-600 activator. Dry 30 minutes between each coat.
- **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.

Ambient - The chemical cure lining will vulcanize in about three (3) weeks at 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)	85 A, 35 D \pm 10	D2240
Tensile Strength (min, psi)	1000	D412
Elongation at Break (min, %)	50	D412
Specific Gravity	1.67	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