TECHNICAL DATA SHEET

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1064

WHITE NATURAL RUBBER

March 2015

Polycorp 1064 is a white 60A durometer natural rubber lining used in food grade services where a non-staining lining is required. It is FDA compliant as per 21CFR177.2600. Operating temperature range is from - 40°F (-40°C) to 160°F (71°C).

APPLICATION NOTES:

- Skive use closed skive construction
- Repair Same or 2041 chemical cure. Refer to section 11 of application manual
- Cured Durometer Shore A durometer of top surface: 60 ± 5.
- **Spark Test** Refer to section 13 of the Application Manual

ADHESIVE NOTES:

See Section 6 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 |
|--------------------------------|----------------------|------------------------|
| 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-204S Tack | C-204S Tack |
| 4 th Coat on lining | C-204S Tack | C-204S Tack |

CURING:

Cure time adjustments may be required to compensate for specific conditions. See Section 10 of the Application Manual for detailed instructions.

Autoclave Method – Up to 1/4" thickness: 2 hours @ 260°F/127°C (20 psi).

Internal Steam Method – Up to 1/4" thickness: 4 hours @ 260°F /127°C (20 psi); or alternate cure, 7 hours at 240°F/116°C (10 psi).

Atmospheric Steam Method – Up to 1/4" thickness: Minimum 24 hours @ 212°F/100°C.







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STORAGE:

Store in a cool and 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 | 45 days |
| Do not store above 90°F (32°C) | |

Depending on storage conditions it may be possible to use rubber linings beyond the recommended shelf life however additional testing must be completed. Please contact Polycorp for recommended test procedures. A sample of the rubber lining can also be sent back to Polycorp for verification.

Storage, handling and application methods must conform to the Polycorp Rubber Lining Application Manual.

TYPICAL PROPERTIES:

| Property | Value | ASTM Test Method |
|--|--------------------------------|------------------|
| Hardness (Face) (points) | 60A ± 5 | D2240 |
| Tensile Strength (min, psi) | 2500 | D412 |
| Elongation at Break (min, %) | 400 | D412 |
| Specific Gravity | 1.32 | D297 |
| Adhesion to Metal (min, lbf/in) | 25 | D429 |
| Operating Temperature Range for Optimum Service Life | -40°F (-40°C) to 160°F (71°C) | N/A |

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





