

1024

CHLOROBUTYL FOR BLEACH SOLUTION

March 2015

Polycorp 1024 is a black 50A durometer chlorobutyl rubber lining with natural rubber tie gum with excellent chemical resistance at elevated temperature. Specially developed to handle strong bleach solution. Operating temperature range is from - 4°F (-20°C) to 260°F (127°C).

APPLICATION NOTES:

- **Skive** – use skive-butt joint covered with 1024 cap strip without tie gum (4” wide)
- **Repair** – Same. Refer to section 11 of application manual.
- **Cured Durometer** – Shore A durometer of top surface: 50 ± 5. See note about atmospheric cure
- 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 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.

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:
4 hours @ 292°F/144°C (45 psi).

Internal Steam Method– Up to 1/4” thickness:
10 hours @ 260°F/126°C (22 psi)

Atmospheric Steam Method –
Minimum of 42 hours @ 212°F/100°C
Note: Using this type of cure may result in lower durometer readings.

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-202S Tack	Chemlok 286
4 th Coat on lining	C-202S Tack	Chemlok 286

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)	50A ± 5	D2240
Tensile Strength (min, psi)	1000	D412
Elongation at Break (min, %)	280	D412
Specific Gravity	1.30	D297
Adhesion to Metal (min, lbf/in)	25	D429
Operating Temperature Range for Optimum Service Life	-4°F (-20°C) to 260°F (127°C)	N/A

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

PRECAUTIONS:

- Skive-butt joint should be covered with a cap strip (4 "wide) of 1024 without tie gum.
- Cap strip is applied by swabbing mating surfaces of cap strip and lining with toluene. A solution made up of 10-15% cement in toluene can also be used on the cap strip for longer tack time and increase tack during cap strip application.
- **Preheat cap strip for at least 10 minutes on a 120°F/43°C heat table.** Thoroughly stitch edges of cap strip so edges are completely sealed.