

1039

EPDM RUBBER LINING

September 2018

Polycorp 1039 Acidseal EP is a black 60A durometer EPDM lining with soft natural rubber tie gum. It is an excellent lining for weather resistance (sun, ozone, oxygen) and also an excellent lining for sodium hypochlorite (bleach) service. It is FDA compliant as per 21CFR177.2600. Operating temperature range is from -4°F (-20°C) to 220°F (104°C).

APPLICATION NOTES:

- **Skive** – seams skived butt with cap strip 2008. Swab mating surfaces of cap strip and lining with solvent
- **Repair** – Same. Refer to Section 11 of application manual.
- **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

ADHESIVE 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:

- 2 hours @ 260°F/127°C (20 psi).
- 1 hour @ 292°F/144°C (45 psi).

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

- 7 hours @ 260°F/127°C (20 psi);
- 13 hours @ 240°F/116°C (10 psi).

Atmospheric Steam Method –

Minimum 30 hours @ 212°F/100°C.

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
Cap Strip / Lining	Solvent Wipe	

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)	1500	D412
Elongation at Break (min, %)	500	D412
Specific Gravity	1.13	D297
Adhesion to Metal (min, lbf/in)	25	D429
Operating Temperature Range for Optimum Service Life	-4°F (-20°C) to 220°F (104°C)	N/A

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

PRECAUTIONS:

- Seams should be 45° skive-butt joint and covered with a cap strip (4"wide x 1/8"thick) of plain Acidseal EP lining 2008.
- Cap strip is applied by swabbing mating surfaces of cap strip and lining with toluene. Do not use cement on cap strips.
- **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.