

1069

NATURAL RUBBER LINING

March 2015

Polycorp 1069 is a black 60A durometer natural rubber lining with excellent chemical, abrasion and tear resistance. It is a lining with excellent machining and grinding characteristics. 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 open skive construction
- **Repair** – Same or 2019 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.

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 1/2 hours @ 250°F/121°C (15 psi).

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

1 hour rise to 250°F/121°C (15 psi).
Hold 5 hours @ 250°F/121°C (15 psi).

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

Minimum 24 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



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	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)	60 A ± 5	D2240
Tensile Strength (min, psi)	3000	D412
Elongation at Break (min, %)	500	D412
Specific Gravity	1.29	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.

