

1077 HT

CHLOROBUTYL “TRIFLEX™” COMBINATION

March 2015

Polycorp 1077 HT is black 65A durometer, chlorobutyl faced “Triflex™” which combines excellent abrasion and chemical resistance properties with low water absorption characteristics. It is flexible to withstand expansion and contraction due to rapid changes in temperature. It is an excellent lining for FGD scrubber module application and the phosphoric acid /defoamer industry. Operating temperature range is from -4°F (-20°C) to 220°F (104°C).

APPLICATION NOTES:

- **Skive** – use closed skive construction
- **Repair** – Same or chemical cure 2040. Refer to section 11 of the application manual.
- **Cured Durometer** – Shore A Durometer of top surface: 65 ± 10.
- 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 – 3/16” & 1/4” thickness:

3 hours @ 250°F/121°C (15 psi). Cool down under pressure.

Internal Steam Method – Up to 3/16” & 1/4” thickness:

6 hours @ 250°F /121°C (15 psi). Cool down under pressure.

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

Minimum 24 hours @ 212°F/100°C. Low durometer readings may result with this type of cure

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	60 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)	65A ± 10	D2240
Tensile Strength (min, psi)	N/A	D412
Elongation at Break (min,%)	N/A	D412
Specific Gravity	1.15	D297
Adhesion to Metal (min, lbs)	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:

- After pressure cure, cool down below 120°F/49°C under air pressure before releasing pressure.
- When using the atmospheric steam curing method, the hard center layer will not attain the same hardness resulting in lower hardness surface reading.