

# 2006

## CHLOROBUTYL WITHOUT TIE GUM

March 2015

**Polycorp 2006** is a 50A durometer “Pure” black chlorobutyl rubber lining. It provides excellent chemical resistance at elevated temperature. Specially developed to handle strong sodium hypochlorite solution up to 15% available chlorine. It is also suitable for 70% hydrofluoric acid service. Operating temperature range is from - 4°F (-20°C) to 220°F (104°C).

**APPLICATION NOTES:**

- **Skive** – use lap or skive-butt joint covered with 2007 cap strip (4” wide x1/8” thick)
- **Repair** – Same. Refer to section 11 of application manual.
- **Cured Durometer** – Shore A Durometer of top surface: 50 ± 5.
- 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:**

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

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

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

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

Minimum 24 hours @ 212°F/100°C.

Coat	Polycorp Adhesive	Approved Equivalent
1 <sup>st</sup> Coat on Metal	C-100 Primer	Chemlok 205
2 <sup>nd</sup> Coat on Metal	C-101 Intermediate	Chemlok 252X
3 <sup>rd</sup> Coat on Metal	Halobutyl Tack	N/A
4 <sup>th</sup> Coat on lining	Halobutyl Tack	N/A

## STORAGE:

Store in a cool, 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)	50 A ± 5	D2240
Tensile Strength (min, psi)	1200	D412
Elongation at Break (min, %)	400	D412
Specific Gravity	1.21	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
Hardness (Face)	55 A ± 5	D2240

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

## PRECAUTIONS:

- Joints can be made using either a lap or skive-butt construction. Skive-butt joint should be covered with a cap strip (4 "wide x 1/8" thick) of plain chlorobutyl 2007.
- Swab mating surfaces of cap strip and lining with toluene solvent. 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.