

2013

CHEMICAL CURE NEOPRENE RUBBER LINING

March 2015

Polycorp 2013 is a black 60A durometer general purpose chemical cure neoprene lining with good abrasion, weathering, corrosion and flame resistance properties.

APPLICATION NOTES:

- **Skive** – use open skive construction
- **Repair** – Same
- **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
- **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.

Coat	Polycorp Adhesive	Approved Equivalent
1 st Coat on Metal	C-100 Primer	Chemlok 205
2 nd Coat on Metal	C-200 Intermediate	Chemlok 220
3 rd Coat on Metal	021052 Tack	021052 Tack
4 th Coat on lining	021052 Tack	021052 Tack

CURING:

Cure time adjustments may be required to compensate for specific conditions. See Section 10 of the Application Manual for detailed instructions. After application, brush the rubber surface with three (3) separate coats of C600 or C700 activator. Allow to dry for 30 minutes between each coat.

Ambient: The lining will cure in about 21 days at ambient temperature (75°F / 24°C). If the service temperature is above 150°F, the lining can be immediately put in service.

Atmospheric Steam Assist: Introduce exhaust steam sufficient to insure contact with all surfaces. Approximately 6-8 hours in exhaust steam will be required to cure lining. More time may be necessary in a large tank, or if heat losses are large.

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)	60 A \pm 5	D2240
Tensile Strength (min, psi)	2000	D412
Elongation at Break (min, %)	300	D412
Specific Gravity	1.42	D297
Adhesion to Metal (min, lbs)	25	D429
Operating Temperature Range for Optimum Service Life	- 13°F (-25°C) to 203°F (95°C)	N/A

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

PRECAUTIONS:

- Calendered stock typically has nerve. Warm Stock to 100°F/38°C to 120°F/49°C before applying.
- Crowd rather than stretch during application.
- After application, brush the rubber surface with three (3) separate coats of C600 cure activator. Allow to dry 30 minutes between each coat.
- Cement side of lining can be freshened with a solution of 6 parts toluene to one part C-600 by weight.