

2040

CHEMICAL CURE CHLOROBUTYL LINING

March 2015

Polycorp 2040 is a black 60A durometer chemical cure chlorobutyl lining with tie gum. General purpose repair stock for chlorobutyl lining. It is FDA compliant when C-600 cure activator is used to cure the rubber. Use C-700 cure activator for Non-FDA application. It is FDA compliant as per 21CFR177.2600. Operating temperature range is from - 4°F (-20°C) to 185°F (85°C).

APPLICATION NOTES:

- **Skive** – use closed skive construction
- **Repair** – Same. Refer to section 11 of application manual.
- **Cured Durometer** – Shore A Durometer of top surface: 60 ± 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. After application, brush the rubber surface with three (3) separate coats of C-600 or C-700 activator. Dry 30 minutes between each coat.

Ambient – The chemical cure lining will vulcanize in about three (3) weeks at 75°F/24°C. Lower hardness readings might result with this type of cure.

Atmospheric Steam Assist – Introduce exhaust steam sufficient to insure contact with all surfaces. Approximately 4-8 hours in exhaust team will be required to cure lining. More time may be necessary in a large tank, or if heat losses are large.

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)	60 A ± 10	D2240
Tensile Strength (min, psi)	1000	D412
Elongation at Break (min, %)	450	D412
Specific Gravity	1.44	D297
Adhesion to Metal (min, lbs)	25	D429
Operating Temperature Range for Optimum Service Life	- 4°F (-20°C) to 185°F (85°C)	N/A

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

SPECIAL TREATMENT AFTER APPLICATION:

- After application, brush the rubber surface with three (3) separate coats of C-600 (FDA) or C-700 (non-FDA) cure activator. Allow to dry 30 minutes between each coat.