

3049

NATURAL RUBBER BLEND LINING (MOR)

March 2015

Polycorp 3049 is a black, 55A durometer natural rubber blend lining for general purpose use when abrasion and moderate oil resistance is required. Operating temperature range is from - 40°F (-40°C) to 160°F (71°C).

APPLICATION NOTES:

- **Skive** – Open
- **Repair** – Same. Refer to section 11 of application manual.
- **Cured Durometer** – Shore A durometer of top surface: 55 ± 5.
- A heated table to warm the rubber to 110–120°F (43°C) is recommended
- Pre-shrink rubber before cutting sheet
- **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 hours at 275°F/135°C (30psi).

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

8 hours @ 260°F/127°C (22 psi).

Atmospheric Steam Method – Up to 1/2” thickness:

Slow rise to 212°F/100°C, hold for minimum 24 hours @ 212°F/100°C.

3/8” to 1”: Minimum of 30 hours @ 212°F/100°C.

| 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 |

STORAGE:

Store in a cool and 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) | 55 A ± 5 | D2240 |
| Tensile Strength (min, psi) | 2500 | D412 |
| Elongation at Break (min, %) | 450 | D412 |
| Specific Gravity | 1.20 | D297 |
| Adhesion to Metal (min, lbs) | 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.

PRECAUTIONS:

- Calendered stock typically has nerve. Warm stock to 100°F/38°C to 120°F/49°C to preshrink the lining before cutting sheet to size.
- Rubber should be crowded rather than stretched during application.
- Rubber is susceptible to weather checking. Do not expose rubber lining to sunlight, oxygen or ozone.