

# 4721

## CHLOROPRENE LINING

March 2015

**Polycorp 4721** is a black 60A durometer lead cure neoprene blend lining with good abrasion, weathering, and corrosion resistance properties. Operating temperature range is from - 13°F (-25°C) to 203°F (95°C).

### APPLICATION NOTES:

- **Skive** – Use open skive construction
- **Repair** – With original lining. Refer to section 11 of application manual.
- **Cured Durometer** – Shore A durometer of top surface: 60 A ± 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 <sup>st</sup> Coat on Metal	C-90 Primer	Chemlok 289
2 <sup>nd</sup> Coat on Metal	C-91 Intermediate	Chemlok 290
3 <sup>rd</sup> Coat on Metal	C-202S Tack	Chemlok 286
4 <sup>th</sup> Coat on Lining	C-202S Tack	Chemlok 286

### CURING:

Cure time adjustments may be required to compensate for metal thickness and other specific conditions. See Section 10 of the Application Manual for detailed instructions.

**Autoclave Method – Up to 1/4” thickness:**  
2 hours @ 275°F/135°C (30 psi).

**Internal Steam Method – Up to 1/4” thickness:**  
6 hours @ 260°F/127°C (20 psi).

**Atmospheric Steam Method – Up to 1/4” thickness:**  
30 hours @ 212°F (100°C)

*Atmospheric curing not recommended for vacuum service*

## 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 ± 5	D2240
Tensile Strength (min, psi)	2175	D412
Elongation at Break (min, %)	350	D412
Specific Gravity	1.41	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 120°F/49°C for ease of application.
- Lining may shrink 10% lengthwise after unrolling. Pre-shrink rubber before applying
- Ensure uniform heat distribution throughout the vessel during cure