

5621

NEOPRENE LINING

May 2015

Polycorp 5621 is a black 55A durometer lead cure neoprene blend lining with good abrasion, weathering, flame 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: 55 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 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 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:

2 Step process

Step 1: 6 hours from Ambient to 160°F

Step 2: 24 hours @ 180°F (82°C)

or 20 hours @ 200°F

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)	55 A ± 5	D2240
Tensile Strength (min, psi)	1500	D412
Elongation at Break (min, %)	650	D412
Specific Gravity	1.38	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
- Works best if applied within two weeks of the delivery