

# 6512

## BROMOBUTYL LINING

January 2021

**Polycorp 6512** is a black 50A durometer bromobutyl rubber lining with a tie-gum layer. It was developed to provide superior resistance in phosphoric acids and caustic solutions in high temperature applications. It is FDA compliant as per 21CFR177.2600.

**APPLICATION NOTES:**

- **Skive** – Closed skive or skived butt seam with 6511 cap strip
- **Repair** – Same. Refer to section 11 of application manual.
- **Cured Durometer** – Shore A Durometer on top surface: 50 ± 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.

**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 hour at 292°F/144°C (45 psi).

**Internal Steam Method- Up to 1/4” thickness:**  
8 hours at 260°F/127°C (20 psi)  
12 hours at 240°F/116°C (10 psi).

**Atmospheric Steam Method – Up to ¼” thickness:**  
Minimum 30 hours @ 212°F/100°C

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
Seams and 6511 cap strip	0147HE2S Tack	N/A

## 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) (points)	50A ± 5	D2240
Tensile Strength (min, psi)	1100	D412
Elongation at Break (min, %)	500	D412
Specific Gravity	1.40	D297
Adhesion to Metal (min, lbf/in)	25	D429

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

## PRECAUTIONS:

- For cap strip application all seams should be made using 45° skive butt seam and covered with a cap strip (3" wide x 1/8" thick) of plain bromobutyl 6511. Cap strip is applied by swabbing mating surfaces of cap strip with CB tack cement 0147HE2S.
- For closed skive seams apply CB tack cement 0147HE2S on overlap seams.
- **Preheat cap strips for approximately 10 minutes on a 120°F /43°C heat table.** Thoroughly stitch edges of cap strip to ensure edges are completely sealed. Preheating bromobutyl lining before application will enhance the workability of this lining.