

6512

BROMOBUTYL LINING

May 2014

Polycorp 6512 is a 50A durometer bromobutyl rubber lining with a natural rubber tie gum. It provides superior temperature resistance in phosphoric acids and caustic solutions up to 260°F. Operating temperature range is from - 4°F (-20°C) to 260°F (127°C)

APPLICATION NOTES:

- **Skive** – Closed skived lap or skive-butt joints with cap strip 6511. Use skive-butt seams in pipes.
- **Repair** – Same. Refer to section 11 of application manual.
- **Cured Durometer** – Shore A Durometer of 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 hours @ 292°F/144°C (45 psi).

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

8 hours @ 260°F/127°C (20 psi).

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

Minimum 30 hours @ 212°F/100°C

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	C-202S Tack
4 th Coat on lining	C-202S Tack	C-202S 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	60 days
Stored between 71 and 90°F	30 days
Do not store above 90°F (32°C)	

Storage, handling and application methods must conform to the Polycorp Rubber Lining Application Manual.

TYPICAL PROPERTIES:

Property	Value	ASTM Test Method
Hardness (Face)	50 A ± 5	D2240
Tensile Strength (min, psi)	1100	D412
Elongation at Break (min, %)	500 %	D412
Specific Gravity	1.40	D297
Adhesion to Metal (min, lbs)	25	D429
Operating Temperature Range for Optimum Service Life	- 4°F (-20°C) to 260°F (127°C)	N/A

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

PRECAUTIONS:

- Joints can be made using either a lap or skive-butt construction. Skive-butt joint should be covered with a cap strip of 6511.
- Swab mating surfaces of cap strip and lining with toluene solvent. A solution made up of 10-15% cement in toluene can also be used on the cap strip for longer tack time and increase tack during cap strip application.
- **Preheat cap strip for at least 10 minutes on a 120°F/43°C heat table.** Preheating lining before application will enhance the workability of this lining. Thoroughly stitch edges of cap strip so edges are completely sealed.