

T1004S

SOFT NATURAL RUBBER LINING

March 2015

Polycorp T1004S is a 60A durometer black natural rubber compound which combines excellent physical properties and abrasion resistance along with oxygen and weather resistance. Operating temperature range is from - 40°F (-40°C) to 159°F (70°C). It is FDA compliant as per 21CFR177.2600.

APPLICATION NOTES:

- **Skive** – use open skive construction
- **Repair** – Same or 2019 chemical cure.
- **Cured Durometer** – Shore A Durometer of top surface: 60 ± 5.
- **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-90 Primer	Chemlok 289
2 nd Coat on Metal	C-91 Intermediate	Chemlok 290
3 rd Coat on Metal	C-202S Tack	Chemlok 286
4 th Coat on lining	C-202S Tack	Chemlok 286

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:
1 hour @ 260°F/127°C (20 psi).

Autoclave Method - 1/2” thickness:
1 1/2 hours @ 260°F/127°C (20 psi).

Internal Steam Method – Up to 1/4” thickness:
3 hours @ 260°F/127°C (20 psi) or
6 hours @ 240°F/116°C (10 psi).

Atmospheric Steam Method – 212°F/100°C
For up to 1/2” thickness: Minimum 20 hours.
5/8” to 1” thickness: Minimum 24 hours

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)	60 A \pm 5	D2240
Tensile Strength (min, psi)	3000	D412
Elongation at Break (min, %)	400	D412
Specific Gravity	1.11	D297
Adhesion to Metal (min, lbs)	25	D429
Operating Temperature Range	- 40°F (-40°C) to 159°F (70°C)	N/A

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