



# 1020HT

## HIGH TEMPERATURE TRIFLEX™

November 2017

**Polycorp 1020HT** is a tan high temperature “Triflex™” with excellent chemical resistance properties in high temperature services. It was specially developed for phosphoric acid service. Operating temperature range is from 50°F (10°C) to 220°F (104°C).

### APPLICATION NOTES:

- **Skive** – use closed skive construction
- **Repair** – same. Refer to section 11 of application manual
- **Cured Durometer**– Durometer of top surface: 50A ± 5 and centre layer: 90A ± 5
- **Precautions** – Cool down to 120°F/49°C before releasing pressure during pressure cure.
- **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 – 3/16” & 1/4” thickness:

- 3 hours @ 260°F/127°C (22 psi)
- 2 hours @ 290°F/143°C (42 psi)

#### Internal Steam Method – 3/16” & 1/4”thickness:

- 7 hours @ 260°F/127°C (20 psi)

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

Minimum 32 hours @ 212°F/100°C.  
Lower durometer readings will result with this type of cure.

Coat	Polycorp Adhesive	Approved Equivalent
1 <sup>st</sup> Coat on Metal	C-90Primer	Chemlok 289
2 <sup>nd</sup> Coat on Metal	C-91Intermediate	Chemlok 290
3 <sup>rd</sup> Coat on Metal	C-202STack	Chemlok 286
4 <sup>th</sup> Coat on lining	C-202S Tack	Chemlok 286



## 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.

For recommendations on storage, handling and application methods refer to Polycorp Rubber Lining Application Manual.

## TYPICAL PROPERTIES:

Property	Value	ASTM Test Method
Hardness (Face) (points)	50 A ± 5	D2240
Hardness (Centre) (points)	90 A ± 5	D2240
Tensile Strength (min, psi)	N/A	D412
Elongation at Break (min, %)	N/A	D412
Specific Gravity	1.04	D297
Adhesion to Metal (min, lbf/in)	25	D429
Operating Temperature Range for Optimum Service Life	50°F (10°C) to 220°F (104°C)	N/A

### Notes:

- To verify the cure state of the hard centre layer removal of the top layer by grinding will be required before the hardness of the centre layer can be checked.
- Tack cement required on skived edges during lining application to ensure proper bonding of seams.