

# 1054

## WHITE BLENDED CHLOROBUTYL LINING

March 2020

**Polycorp 1054** is a white 45A durometer blended chlorobutyl lining with natural rubber tie gum. Depending on the concentration of the chemical it can provide temperature resistance up to 200°F/93°C for certain applications. It is the lining of choice for phosphoric acid tank cars. It is FDA compliant as per 21CFR177.2600.

### APPLICATION NOTES:

- **Skive** – use closed skive construction
- **Repair** – Same or chemical cure 1058 with C-600 activator. Refer to section 11 of application manual.
- **Cured Durometer** - Shore A durometer of top surface: 45 ± 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:** Slow rise to 250°F/121°C (15 psi). Hold 3 hours at 250°F/121°C (15 psi).

**Internal Steam Method- Up to 1/4” thickness:** Slow rise to 250°F/121°C (15 psi). Hold 6 hours at 250°F/121°C (15 psi).

**Atmospheric Steam Method –** Minimum 24 hours at 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-204S Tack	Chemlok 286
4 <sup>th</sup> Coat on lining	C-204S 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.

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

## TYPICAL PROPERTIES:

Property	Value	ASTM Test Method
Hardness (Face) (points)	45A	D2240
Tensile Strength (min, psi)	1000	D412
Elongation at Break (min, %)	400	D412
Specific Gravity	1.38	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:

- Preheating chlorobutyl lining before application will enhance the workability of this lining. **Do not expose tie-gum layer.**