

2019

SOFT NATURAL RUBBER LININGS

March 2015

Polycorp 2019 is a black, 50A durometer soft chemical cure natural rubber. General purpose repair stock for black soft natural rubber. Use activator C-600 for FDA application and activator C-700 for non-FDA applications to cure the rubber. It is FDA compliant as per 21CFR177.2600. Operating temperature range is from - 40°F (-40°C) to 160°F (71°C).

APPLICATION NOTES:

- **Skive** – use open skive construction
- **Repair** – Same. Refer to section 11 of application manual.
- **Cured Durometer** – Shore A Durometer of top surface: 50 ± 10.
- **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. After application, brush the rubber surface with three (3) separate coats of C600 of C700 activator. Allow to dry for 30 minutes between each coat.

Ambient: The lining will cure in about 21 days at ambient temperature (75°F / 24°C). If the service temperature is above 150°F, the lining can be immediately put in service.

Atmospheric Steam Assist: Introduce exhaust steam sufficient to insure contact with all surfaces. Approximately 6-8 hours in exhaust steam will be required to cure lining. More time may be necessary in a large tank, or if heat losses are large.

STORAGE:

Store in a cool, 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	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)	50 A ± 10	D2240
Tensile Strength (min, psi)	1000	D412
Elongation at Break (min, %)	500	D412
Specific Gravity	1.22	D297
Adhesion to Metal (min, lbs)	25	D429
Operating Temperature Range for Optimum Service Life	- 40°F (-40°C) to 160°F (71°C)	N/A

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

SPECIAL TREATMENT AFTER APPLICATION:

- After application, brush the rubber surface with three (3) separate coats of C600 or C700 activator. Allow to dry for 30 minutes between each coat.
- **C700 cannot be used for FDA service.**