



# 2027

## RED NATURAL RUBBER LINING

March 2015

**Polycorp 2027** is a red, 35A durometer natural rubber lining for superior abrasion and impingement resistance for the mining industry. It provides excellent service in pipe application. 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: 35 ± 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.

**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).

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

2 hours @ 260°F/127°C (20 psi) or  
4 hours at 240°F/116°C (10 psi).

**Exhaust (Atmospheric) Steam Method – Up to 1/4” thickness:**

Minimum 20 hours @ 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-202S Tack	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	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 )	35 A $\pm$ 5	D2240
Tensile Strength (min, psi)	2000	D412
Elongation at Break (min, %)	500	D412
Specific Gravity	0.96	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.