

# 2045

## HYPALON RUBBER LINING

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**Polycorp 2045** is a black, 60A durometer chlorosulfonated polyethylene (Hypalon) rubber lining for high temperature and strong oxidizing acids. It is excellent for chrome plating solutions. Operating temperature range is from - 20°F (-30°C) to 250°F (105°C).

### APPLICATION NOTES:

- **Skive** – Butt and Cap construction
- **Repair** – Same. Refer to section 11 of application manual.
- **Cured Durometer** – Shore A Durometer of top surface: 60 ± 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:

1 hour rise to 250°F/121°C (15psi). Hold 2 ½ hours @ 250°F/121°C (15 psi).

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

1 hour rise to 250°F/121°C (15 psi). Hold 5 hours @ 250°F/121°C (15 psi).

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

Slow rise to 212°F/100°C, hold for minimum 24 hours @ 212°F/100°C.

Coat	Polycorp Adhesive	Approved Equivalent
1 <sup>st</sup> Coat on Metal	C-100 Primer	Chemlok 205
2 <sup>nd</sup> Coat on Metal	C-200 Intermediate	Chemlok 220
3 <sup>rd</sup> Coat on Metal	021052 Tack	021052 Tack
4 <sup>th</sup> Coat on Lining	021052 Tack	021052 Tack

## 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)	60 A ± 5	D2240
Tensile Strength (min, psi)	1500	D412
Elongation at Break (min, %)	500	D412
Specific Gravity	1.404	D297
Adhesion to Metal (min, lbs)	25	D429
Operating Temperature Range for Optimum Service Life	- 20°F (-30°C) to 250°F (105°C)	N/A

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

## PRECAUTIONS:

- Calendered stock typically has nerve. Warm stock to 100°F/38°C to 120°F/49°C to preshrink the lining before cutting sheet to size.
- All seams should be made using a 45° skive butt seam and covered with a cap strip (4" wide x 3/32" thick) of plain hypalon.
- **Mating surfaces of cap strip and lining to be solvent washed only!!!**
- Preheat the sheet to 100°F/38°C to 120°F/49°C before applying.
- Rubber should be crowded rather than stretched during application.

