

4048

NATURAL/NITRILE BLEND LINING (MOR)

August 2019

Polycorp 4048 is a black, 60A durometer natural /nitrile blend rubber lining for general purpose use when abrasion and moderate oil resistance (MOR) are required.

APPLICATION NOTES:

- **Skive** – Open
- **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
- Pre-shrink rubber before cutting sheet
- **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 at 260°F/127°C (20 psi).

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

Minimum of 6 hours @ 260°F/127°C (22 psi).

Atmospheric Steam Method – Up to 1/2” thickness:

Slow rise to 212°F/100°C, hold for minimum 20 hours @ 212°F/100°C.

3/8” to 1”: Minimum of 30 hours @ 212°F/100°C.

Coat	Polycorp Adhesive	Approved Equivalent
1 st Coat on Metal	C-100 Primer	Chemlok 289
2 nd Coat on Metal	C-200 Intermediate	Chemlok 290
3 rd Coat on Metal	C-202S Tack	Chemlok 286
4 th 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.

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 \pm 5	D2240
Tensile Strength (min, psi)	2500	D412
Elongation at Break (min, %)	450	D412
Specific Gravity	1.13	D297
Adhesion to Metal (min, lbs)	30	D429

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.
- Rubber should be crowded rather than stretched during application.
- Rubber is susceptible to weather checking. Do not expose rubber lining to sunlight, oxygen or ozone.