

6511

BROMOBUTYL CAP STRIP

March 2021

Polycorp 6511 is a black 50A durometer bromobutyl rubber lining. It was developed to provide superior resistance in phosphoric acids and caustic solutions in high temperature applications. It is used as cap strip for Polycorp 6512 lining. It is FDA compliant as per 21CFR177.2600.

APPLICATION NOTES:

- **Skive** – Open skive construction.
- **Repair** – Same. Refer to section 11 of application manual.
- **Cured Durometer** – Shore Durometer of top surface: 50A ± 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:
2 hours @ 292°F/144°C (45 psi).

Internal Steam Method – Up to 1/4” thickness:
8 hours @ 260°F/127°C (20 psi).

Atmospheric Steam Method – Up to 1/4” thickness:
Minimum 30 hours @ 212°F/100°C

Coat	Polycorp Adhesive	Approved Equivalent
1 st Coat on Metal	N/A	N/A
2 nd Coat on Metal	N/A	N/A
3 rd Coat on Metal	N/A	N/A
4 th Coat on lining	N/A	N/A
Cap strip	0147HE2S Tack	N/A

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)	50 A ± 5	D2240
Tensile Strength (min, psi)	1100	D412
Elongation at Break (min, %)	500 %	D412
Specific Gravity	1.40	D297
Adhesion to Metal (min, lbs)	25	D429

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

PRECAUTIONS:

- Use 2" wide cap strip over skive-butt joint.
- Swab mating surfaces of cap strip and lining with toluene solvent or CB tack cement 0147HE2S for longer open tack time during cap strip application.
- **Preheat cap strip for at least 10 minutes on a 120°F/43°C heat table.** Thoroughly stitch edges of cap strip so edges are completely sealed.