



68670

SOFT NATURAL RUBBER LININGS

March 2015

Polycorp 68670 (EPSEAL) is a black, 40A durometer natural rubber with excellent chemical, abrasion and tear resistance properties. Used for steel mill, pickle lines and chemical storage services. Operating temperature range is from - 40°F (-40°C) to 159°F (70°C).

APPLICATION NOTES:

- **Skive** – use open skive construction
- **Repair** – Same or 2019 chemical cure.
- **Cured Durometer** – Shore A Durometer of top surface: 40 ± 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).

1/4” to 3/8” thick: 1 ½ hours @ 260°F (20 psi)

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

3 hours @ 260°F/127°C (20 psi) or

6 hours at 240°F/116°C (10 psi).

Exhaust (Atmospheric) Steam Method – 212°F/100°C

Up to 1/4” thickness: Minimum 20 hours.

3/8” to 1/2” thickness: Minimum 24 hours

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-210S Tack	C-210S Tack
4 th Coat on metal or lining	C-210S Tack	C-210S 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)	40 A \pm 5	D2240
Tensile Strength (min, psi)	2500	D412
Elongation at Break (min, %)	500	D412
Specific Gravity	1.03	D297
Adhesion to Metal (min, lbs)	25	D429
Operating Temperature Range for Optimum Service Life	- 40°F(-40°C) to 159°F (70°C)	N/A

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