

2098

TAN NATURAL RUBBER LININGS

May 2014

Polycorp 2098 is a tan 60A durometer chemical cure natural rubber lining. It is a general purpose repair stock for tan natural rubber. It is FDA compliant as per 21CFR177.2600. 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 of top surface: 55 ± 10.
- **Spark Test** – Refer to section 13 of the Application Manual
- After application, brush the rubber surface with three (3) separate coats of cure activator C-600. Allow to dry for 30 minutes between each coat

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. After application, brush the rubber surface with three (3) separate coats of cure activator C-600. Allow to dry for 30 minutes between each coat.

Atmospheric Steam Assist: Introduce exhaust steam sufficient to insure contact with all surfaces. Approximately 6-8 hours in exhaust steam will be required to cure lining. More time may be necessary in a large tank, or if heat losses are large.

Ambient: The chemical cure lining will vulcanize in about 21 days at ambient temperature (75°F / 24°C). Lower durometer readings may result with this type of cure.

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 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	30 days
Do not store above 90°F (32°C)	

Storage, handling and application methods must conform to the Polycorp Rubber Lining Application Manual.

TYPICAL PROPERTIES:

Property	Value	ASTM Test Method
Hardness (Face)	55 A ± 10	D2240
Tensile Strength (min, psi)	1000	D412
Elongation at Break (min, %)	500	D412
Specific Gravity	1.27	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.

SPECIAL TREATMENT AFTER APPLICATION:

- After application, brush the rubber surface with three (3) separate coats of cure activator C-600 activator. Allow to dry for 30 minutes between each coat.