

LINING DATA SHEET

COMPOUND #: NRL 184-7

DESCRIPTION: White FDA natural rubber

CURED DUROMETER: 70 +/- 10 shore A

GAUGES: 1/8", 3/16", 1/4"

APPLICATION: Food grade lining. General purpose chemical resistance. Water treatment.

ADHESIVE SYSTEM: Chemlok #289 (1st coat – Metal)
Chemlok #290 (2nd coat – Metal)
Endurabond 103 (3rd coat – Metal, 1st coat – Rubber)

Endurabond 103 freshening solvent: toluene or Xylene.

CURE SYSTEM: Autoclave:

25 psi. 1 hour air at 25 psi. 1 hour raise to 250° F.
Remain 2.5 hrs. @ 250° F. 3 hrs. cool down @ 25 psi.

Internal Pressure:

8 hours @ 260° F

Atmospheric:

The vessel to be housed in wood box, tarpaulin, or other suitable means to retain heat. Introduce exhaust steam with perforated pipes, jets, etc. as necessary to contact all surfaces. Vessel to be cured for at least 24 hours at a minimum of 180° F. Longer cure time necessary if heat loss is significant.

REPAIR: Repair with original lining or with NRL 184-7C and FDA chemical curing agent.

INSPECTION: Use 12,000 volt Holiday tester for 3/16" or 1/4" lining.
Use 10,000 volt Holiday tester for 1/8" lining.