

## LINING DATA SHEET

- COMPOUND #:** NRL 291-6  
**DESCRIPTION:** Medium hardness natural rubber lining for sliding and impact abrasion.
- CURED DUROMETER:** 65 +/- 5 shore A
- GAUGES:** 1/8", 3/16", 1/4"
- APPLICATION:** Polishing drums, slurry pipe & tanks, rock screen separators, agitator blades, etc. General purpose abrasion and chemical resistance.
- ADHESIVE SYSTEM:** Chemlok #289 (1<sup>st</sup> coat – Metal)  
Chemlok #290 (2<sup>nd</sup> coat – Metal)  
Chemlok #286 (3<sup>rd</sup> coat – Metal, 1<sup>st</sup> coat – Rubber)  
  
Goodwest #286 freshening solvent: toluene or xylene
- CURE SYSTEM:** Autoclave:  
Raise temperature to 250° F for 1 hour.  
Remain 2 hrs. @ 250° F. 3 hrs. cool down @ 25 psi.
- Internal Pressure:  
6 hours @ 240° F / 10 psi. (Depending on metal and lining thickness, metal surface temperature will be around 180° 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. Lining to be cured for at least 24 hours at a minimum of 180° F internal temperature. Longer cure time necessary if heat loss is significant.
- REPAIR:** Repair with original lining. NRL 95-65C chemically cured natural rubber may be used if repair area will not be exposed to abrasion.
- INSPECTION:** Use 12,500 volt Holiday tester for 3/16" or 1/4" lining.  
Use 10,000 volt Holiday tester for 1/8" lining.