

LINING DATA SHEET

COMPOUND #: NRL 96-65
DESCRIPTION: Natural rubber lining for general purpose chemical and abrasion resistance.

CURED DUROMETER: 65 +/- 5 shore A

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

APPLICATION: General purpose chemical resistance. Water treatment vessels.

ADHESIVE SYSTEM: Goodwest #289 (1st coat – Metal)
Goodwest #290 (2nd coat – Metal)
Goodwest #286 (3rd coat – Metal, 1st 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.

Chemical Cure:
Apply heavy coat of chemical curing agent (ZDBCX curing agent) to entire rubber surface. A second coat may be applied after 30 minutes. Heat will speed the vulcanization process.

REPAIR: Repair with original lining.
INSPECTION: Use 12,500 volt Holiday tester for 3/16" or 1/4" lining.
Use 10,000 volt Holiday tester for 1/8" lining.