

**RUBBER LINING DATA SHEET**

**COMPOUND #:** NRL 985  
**DESCRIPTION:** Semi-hard natural rubber lining.  
**CURED DUROMETER:** 85 +/- 5 shore A

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

**APPLICATION:** General purpose chemical resistance. Water treatment.

**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)  
  
Chemlok #286 freshening solvent: toluene

**CURE SYSTEM:** Autoclave:  
3 hours @ 275 deg. F

Internal Pressure:  
8 hours @ 260 deg. 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 deg. F. Longer cure time necessary if heat loss is significant.

**REPAIR:** Repair with original lining. If necessary, repair with NRL 985C chemical cure material.

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

**TYPICAL PHYSICAL PROPERTIES**

**Tensile Strength.....1800** (ASTM D 412)  
**% Elongation.....190** (ASTM D 412)  
**Durometer..... 85 +/-5 shore A**  
**Adhesion to Metal..... 30 lbs.** (ASTM D 429)