

TECHNICAL DATA SHEET

1019 HT

TRIFLEX 3-LAYER COMBINATIONS

October 1, 2009

Polycorp 1019 HT 50A durometer high temperature Triflex, Tan / Black / Tan. Excellent chemical resistance properties in high temperature services up to 220 F. Developed for phosphoric acid service.
A-I-E Cure.

Application Notes:

- **Skive** – use closed skive construction
- **Repair** – same
- **Cured Durometer** – Shore A Durometer of top surface: 50 ± 10.
- **Precautions** – Cool down to 120°F/49°C before releasing pressure during pressure cure.
- **Spark Test** – Refer to section 13 of the Application Manual

Adhesive Notes:

See Section 9 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.

<u>Coat</u>	<u>Polycorp Adhesive</u>	<u>Approved Equivalent</u>
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-202S Tack	Chemlok 286
4 th Coat on lining	C-202S Tack	Chemlok 286

For distributors of Chemlok adhesives, see Section 9 of the Application Manual

Curing:

Cure time adjustments may be required to compensate for specific conditions. See Section 11 of the Application Manual for detailed instructions.

Autoclave Method – 3/16” & 1/4” thickness:
3 hours @ 260°F/127°C (20 psi)

Internal Steam Method – 3/16” & 1/4” thickness: 7 hours @ 260°F/127°C (20 psi)

Atmospheric Steam Method – Up to 1/4” thickness: Minimum 32 hours @ 212°F/100°C. Lower durometer readings will result with this type of cure.

Storage:

Store in a cool, 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



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Typical Properties:

<u>Property</u>	<u>Value</u>	<u>ASTM Test Method</u>
Hardness (Face)	50 A \pm 10	D2240
Tensile Strength (min, psi)	N/A	D412
Elongation at Break (min, %)	N/A	D412
Specific Gravity	1.04	D927
Adhesion to Metal (min, lbs)	25	D429
Maximum Operating Temperature for Optimum Service Life	104° C/ 220°F	N/A

All physical property values developed and measured using a press-cured sample sheet prepared in accordance with ASTM D3182.