

TECHNICAL DATA SHEET

1024

BLACK SOFT CHLOROBUTYL

March 18, 2012

Polycorp 1024 is a 50A durometer “Pure” black chlorobutyl rubber lining with natural rubber tie gum. Excellent chemical resistance at elevated temperature. Superior lining to handle strong oxidizing solution. Pressure cure only.

Application Notes:

- **Skive** – use skive-butt joint covered with 1024 without tie gum (4” wide x1/8” thick)
- **Repair** – Same
- **Cured Durometer** – Shore A Durometer of top surface: 50 ± 5.
- A heated table to warm the rubber to 110–120°F (43°C) is recommended
- **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 – Up to 1/4” thickness:

4 hours @ 292°F/144°C (45 psi).

Internal Steam Method– Up to 1/4” thickness:

10 hours @ 260°F/134°C (30 psi)

Atmospheric Steam Method –

Not recommended

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 ± 5	D2240
Tensile Strength (min, psi)	1000	D412
Elongation at Break (min, %)	280 %	D412
Specific Gravity	1.30	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.

PRECAUTIONS:

- Skive-butt joint should be covered with a cap strip (4 "wide x 1/8" thick) of 1024 without tie gum.
- Swab mating surfaces of cap strip and lining with toluol solvent. **Do not use cement on cap strips.**
- **Preheat cap strip for at least 10 minutes on a 120°F/43°C heat table.** Thoroughly stitch edges of cap strip so edges are completely sealed.