

## TECHNICAL DATA SHEET

# 1099

## SOFT NATURAL RUBBER LINING

July 12, 2012

**Polycorp 1099** is a tan, strained, 35A durometer natural rubber pure gum lining with excellent chemical, abrasion and tear resistance. A-I-E Cure. FDA compliant as per 21CFR177.2600

### Application Notes:

- **Skive** – use open skive construction
- **Repair** – Same or 2042 chemical cure.
- **Cured Durometer** – Shore A Durometer of top surface: 35 ± 5.
- **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 <sup>st</sup> Coat on Metal	C-90 Primer	Chemlok 289
2 <sup>nd</sup> Coat on Metal	C-91 Intermediate	Chemlok 290
3 <sup>rd</sup> Coat on Metal	C-202S Tack	Chemlok 286
4 <sup>th</sup> Coat on lining	C-202S Tack	Chemlok 286
For overlap and cap strips	C210S Tan Tack	N/A

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:

1 hour @ 260°F/121°C (20 psi).  
 ½” thickness 1½ hours @ 260°F (20 psi)

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

3 hours @ 260°F (20 psi) or 6 hours @ 240°F (10 psi)

### Exhaust (Atmospheric) Steam Method – Up to 1/4” thickness:

Minimum 24 hours @ 212°F/100°C.

### Storage:

Store in a cool and 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)	35 A $\pm$ 5	D2240
Tensile Strength (min, psi)	2500	D412
Elongation at Break (min, %)	500	D412
Specific Gravity	0.97	D927
Adhesion to Metal (min, lbs)	25	D429
Maximum Operating Temperature for Optimum Service Life	71°C/ 160°F	N/A

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