

## TECHNICAL DATA SHEET

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# 1077 HT

## CHLOROBUTYL “TRIFLEX” COMBINATION

October 1, 2009

**Polycorp 1077 HT** 65A durometer black, chlorobutyl faced Triflex which combines excellent abrasion and chemical resistance properties with low water absorption characteristics. Flexible to withstand rapid changes in temperature and related expansion and contraction. Excellent for FGD scrubber module application and phosphoric acid/defoamer industry. Temperature resistance up to 220°F/104°C.

### Application Notes:

- **Skive** – use closed skive construction
- **Repair** – Same or chemical cure 2040.
- **Cured Durometer** – Shore A Durometer of top surface: 65 ± 10.
- 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 <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 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 @ 250°F/121°C (15 psi). Cool down under pressure.

**Internal Steam Method – Up to 3/16” & 1/4” thickness:** 6 hours @ 250°F /121°C (15 psi). Cool down under pressure.

**Atmospheric Steam Method – Up to 1/4” thickness:** Minimum 24 hours @ 212°F/100°C. Low durometer readings may 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 )	65A ± 10	D2240
Tensile Strength (min, psi)	N/A	D412
Elongation at Break (min,%)	N/A	D412
Specific Gravity	1.15	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:

- In a pressure cure cool down below 120°F/49°C under air pressure before releasing pressure.
- When using the atmospheric steam curing method, the hard center layer will not attain the same hardness resulting in lower hardness surface reading.