



salem-republic rubber company
1-800-686-4199 · (330)938-9809 fax
 475 West California Avenue · Sebring, Ohio 44672 · USA
www.salem-republic.com

CSSTO engineered elastomeric linings

Material Specification Sheet

Lining Code: **SR655**

Type: **Natural**

Tie Gum: **With or Without Tie Gum**

Use: Natural soft, black, excellent chemical, tear and abrasion resistance a highly reinforced compound with Tie Gum.

Cure: **Exhaust Steam or Pressure Cure**

Primers and Adhesive System:

One coat Chemlok® 289 on Metal

One coat Chemlok® 290 on Metal

One coat Chemlok® 286 on Metal

One coat Chemlok® 286 on Lining

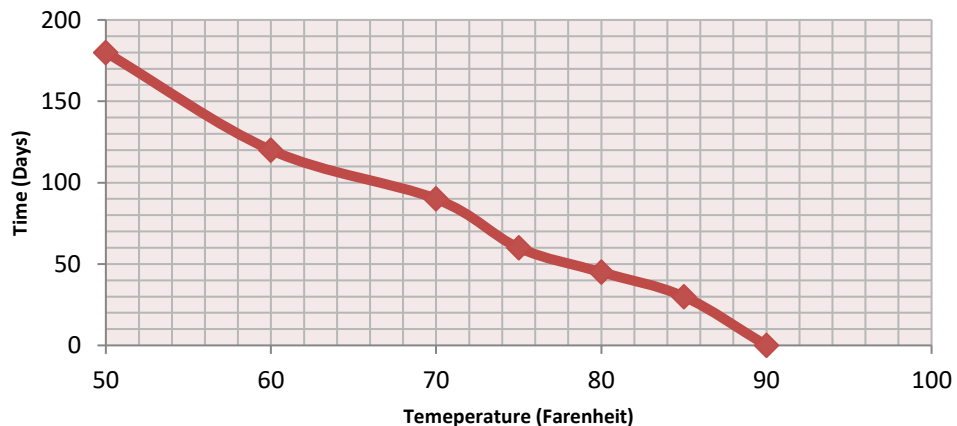
Cure for thickness up to 1/4"

- Pressure, Saturated Steam (Autoclave):
1 hr. @ 20psi 260°F (126°C)
- Internal Steam Cure:
3 hrs. @ 20psi 260°F (126°C)
- Atmosphere Steam Cure:
24 hrs. @ 190°F-205° (87°C-96°C)

Note: All reference to cure psi represents gauge pressure.

****Cure times may require tunings to compensate for low temperatures, heavy metal thicknesses, and other anomalies. Contact SRR Technical Department for recommendations on lining thicknesses over 1/4".**

Storage Life Cycle Days & Temp.



Ideal storage temperature is 50°F not to exceed 85°F and shelf life is 180 to 45 day range respectively.

Depending on storage conditions it may be possible to use rubber linings beyond shelf life. Please contact Salem-Reupublic Rubber Company for technical advisement before usage.



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Designed Physical Properties

Tensile Strength PSI	ASTM D412	3500 min
% Elongation at Break	ASTM D412	550 min
Durometer	ASTM D2240	60 +/- 5
Specific Gravity	ASTM D297	1.1
Adhesion to Metal	ASTM D429	30 pli min

Skive:
 Open (Without Tie Gum)
 Closed (With Tie Gum)

Repair lining:
 Use SR655 or SRXXXC

Application Suggestions:

- SR655 lining shows acceptable rubber to metal adhesion with or without Tie Gum.
- For gauges greater than 1/4" plying up to desired thickness is recommended using a 45°/135° butt splice with offset seams on all but the top layer.
- When plying up, the first layer can installed with or without Tie Gum. The Tie Gum on subsequent layers is not necessary, therefore the top layer may be lapped with an open skive.
- On rare occasions lining may bloom in storage. Warming rubber approximately 120°F will resorb bloom within 30-40 minutes. Wiping off bloom will cause reduced physical properties in cured product.
- Experienced applicators may have techniques which produce equal or superior results and by no means are SRR's application suggestions meant to replace these proven techniques.

Standard Dimensions:

Roll	Standard Gauge	Tolerance	Roll Gauge	Standard Roll	Maximum
A Roll	.120	+/- .05	A Roll	90ft	96
B Roll	.180	+/- .010	B Roll	60ft	66
C Roll	.240	+ .010 or -.020	C Roll	45ft	51
3/8" Roll	.360	+/- .015	3/8" Roll	30ft	33
1/2" Roll	.480	+/- .015	1/2" Roll	23ft	27

*Customer specific gauges and widths, other than standard, are available upon request. Please call **Salem-Republic Rubber Company** at **1-(800)686-4199** with any questions or more information about our **Custom Elastomeric Linings**.

SR
CUSTOM
engineered elastomeric linings