



# CUSTOM | Engineered Elastomeric Linings **SR640**

## LINING DATA SHEET

- ▽ **Type:** Natural (Black)
- ▽ **Tie Gum:** Without Tie Gum / (Available With Tie Gum upon request.)
- ▽ **Properties:** Durometer 45 +/- 5 Shore A - Natural soft, black rubber lining for impact abrasion and Hydrochloric (HCl) Acid resistance.

### Primers and Adhesive System:

- (1) coat Chemlok® 289 on Metal
- (1) coat Chemlok® 290 on Metal
- (1) coat Chemlok® 286 on Metal
- (1) coat Chemlok® 286 on Lining

Follow Lord® adhesive recommended procedures for mixing and set time. Sufficient tack time is crucial to obtain maximum bond. Use SRR approved cements when applicable.

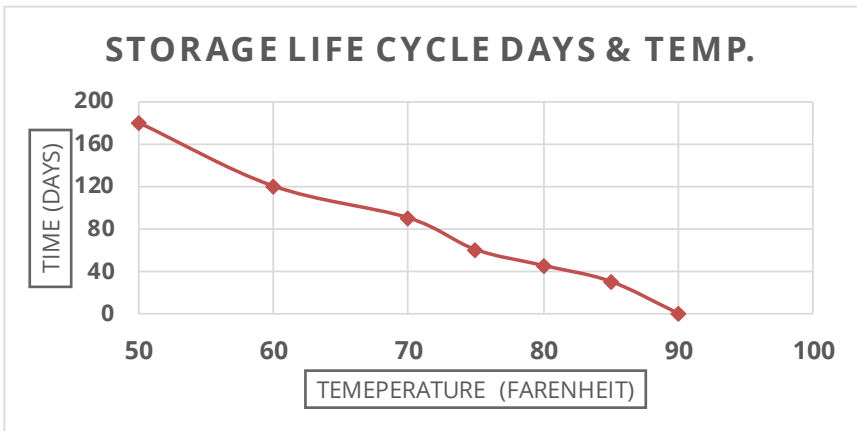
### CURE TIME AND TEMPERATURE: CURE FOR THICKNESS UP TO ¼"

▽ Note: All reference to cure psi represents gauge pressure.

Pressure, Saturated Steam (Autoclave)	1 hr. @ 20psi 260°F (126°C)
Internal Steam Cure	4 hrs @ 10psi 240°F (115°C)
Atmosphere Steam Cure	24 hrs. @ 190°F-205°F (87°C-96°C)

**\*\*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 ¼".**

### COLD STORAGE



Ideal storage temperature is between 50°F and 85°F (65°C).

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



<b>Tensile Strength PSI</b>	ASTM D412	2800 min
<b>% Elongation at Break</b>	ASTM D412	600 min
<b>Durometer</b>	ASTM D2240	45 +/- 5
<b>Specific Gravity</b>	ASTM D297	1.34
<b>Adhesion to Metal</b>	ASTM D429	30 pli min

ASTM standards account for the examination and evaluation of a rubber product to ensure quality and acceptability in safe utilization.

▽ **Skive:** Open (Without Tie Gum), Closed (With Tie Gum)

▽ **Repair lining:** [SR640](#) or [SR627C](#) for Chemical Cure

## APPLICATION SUGGESTIONS:

- ▽ [SR640](#) lining shows acceptable rubber to metal adhesion without or with Tie Gum.
- ▽ For gauges greater than ¼" 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 be installed without or with Tie Gum. The Tie Gum on subsequent layers is not necessary, therefore the top layer may be lapped with an open skive.
- ▽ 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. As long as those procedures fall within NACE Standards lining application guidelines.

*The above procedures are based on a guideline, please to refer to NACE standard practice / Sheet Rubber Linings for Abrasion and Corrosion Services (SP0298-2007) for in depth procedures and methods.*

## GENERAL RESISTANCE TABLES

### CHEMICAL

General Resistance	
Acid (Concentrate)	Excellent
Acid (Dilute)	Excellent
Salt Solutions	Excellent
Oxygenated Solvents	Good
Animal & Vegetable Oils	Poor
Oil & Gasoline	Poor

### ENVIRONMENT

Atmospheric Aging	
Low Temperature Flexibility	Good
Moisture Resistance	Good
Compression Resistance	Good
Permeability	Excellent
Abrasion Resistance	Excellent

▽ Note: This chart reflects common chemical resistance and aging. Please contact Salem-Republic Technical Staff for full Chemical Resistance chart.

Please call **Salem-Republic Rubber Company** at **1-800-686-4199** or visit [www.salem-republic.com](http://www.salem-republic.com) with any questions or more information about our **Custom Elastomeric Linings**.



**SALEM-REPUBLIC RUBBER COMPANY**  
 1-800-686-4199 Phone • 330-938-9809 Fax  
 475 West California Avenue • Sebring, Ohio 44672 • USA  
[www.salem-republic.com](http://www.salem-republic.com)

