



CUSTOM | Engineered Elastomeric Linings **SR648**

LINING DATA SHEET

- ▽ Lining Code: **SR648**
- ▽ Type: Natural
- ▽ Tie Gum: Without Tie Gum
- ▽ Properties: Durometer 40 +/- 5 Shore A – Natural Rubber Lining, Tan Gum, with No Tie Gum with chemical and abrasion resistance properties. FDA compliant.

Note: Natural rubber will “weather check” (prematurely degrade) if exposed to sunlight, ozone, and concentrated oxygen.

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.

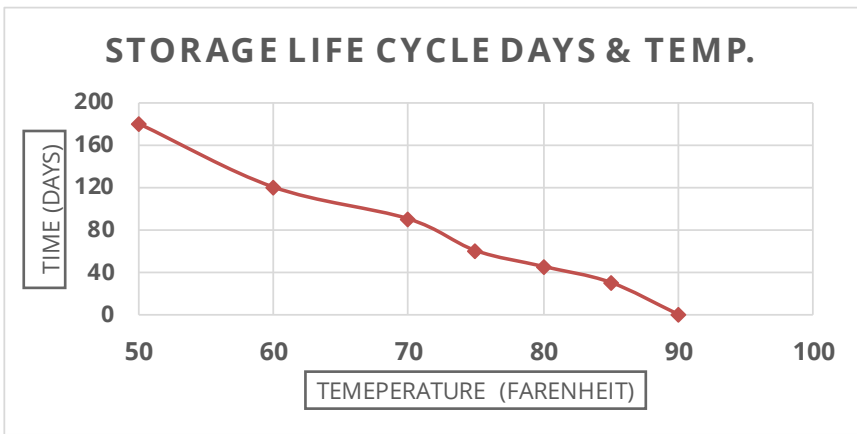
CURE TIME AND TEMPERATURE: CURE FOR THICKNESS UP TO ¼”

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

Pressure, Saturated Steam (Autoclave):	2 hrs. @ 15psi 250°F (121°C)
Internal Steam Cure	1 hour rise to 250°F (121°C) Hold @ 15psi 250°F (121°C) for 2 hrs.
Atmosphere Steam Cure	24 hrs. @ 190°F-205° (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.



Tensile Strength PSI	ASTM D412	2500 min
% Elongation at Break	ASTM D412	500 min
Durometer	ASTM D2240	40 +/- 5
Specific Gravity	ASTM D297	0.95
Adhesion to Metal	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:** Closed

▽ **Repair lining:** Use [SR648](#)

APPLICATION SUGGESTIONS:

- ▽ Plying up lining thicker than 1/4" is not recommended due to sagging during cure process.
- ▽ Warming rubber to approximately 120°F will aide in applying and is recommended.
- ▽ Over-curing is possible, if temperature specifications and cure times are exceeded, resulting in reversion.
- ▽ 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

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



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