



CUSTOM | Engineered Elastomeric Linings **SR654**

LINING DATA SHEET

- ▽ **Type:** Natural (Black)
- ▽ **Tie Gum:** With Tie Gum / Available Without Tie Gum upon request.
- ▽ **Properties:** Durometer 60 +/-5 - Natural soft, black, excellent chemical, tear and abrasion resistance highly reinforced compound with Tie gum and antiozonant and antioxidant inhibitors. Good weather 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.

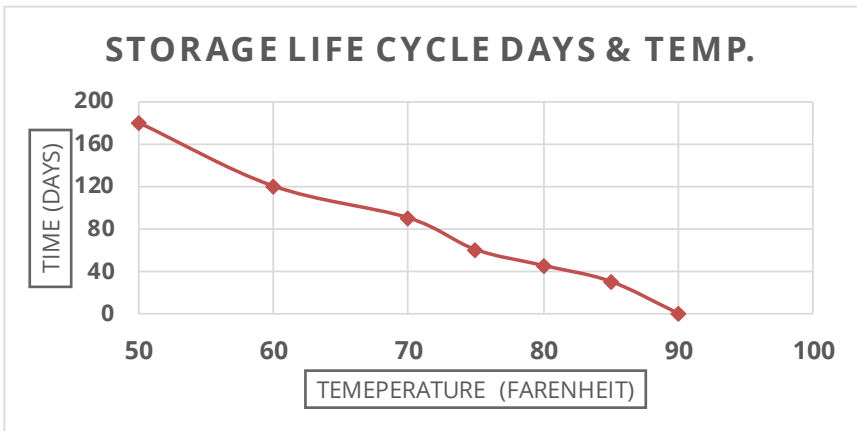
CURE TIME AND TEMPERATURE: CURE FOR THICKNESS UP TO ¼"

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

Pressure, Saturated Steam (Autoclave)	1 hr. @ 20psi 260°F (126°C)
Internal Steam Cure	3 hrs. @ 20psi 260°F (126°C)
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	3800 min
% Elongation at Break	ASTM D412	500 min
Durometer	ASTM D2240	60 +/- 5
Specific Gravity	ASTM D297	1.09
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:** Open (Without Tie Gum), Closed (With Tie Gum)

▽ **Repair lining:** Use [SR654](#) or [SR627](#) for Chemical Cure

APPLICATION SUGGESTIONS:

- ▽ [SR654](#) lining shows acceptable rubber to metal adhesion with or without 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 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.
- ▽ Warming rubber to approximately 120°F will aide in applying and is recommended.
- ▽ 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	Good
Oxygenated Solvents	Good
Animal & Vegetable Oils	Poor
Oil & Gasoline	Poor

ENVIRONMENT	
Atmospheric Aging	
Low Temperature Flexibility	Excellent
Moisture Resistance	Excellent
Compression Resistance	Good
Permeability	Fair
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 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

