

PG70

Marflex™ amber, soft, high quality pure gum natural rubber lining. Used exclusively for HCl service. FDA compliant.

SPECIFICATIONS

Durometer of Face Material:

Shore A Scale

Atmospheric Cure:

30-40 A

Pressure Cure:

30-40 A

Skive:

Open

Repairs:

Repair with original lining or C413TN
See Section 16 – Repair Procedures

Storage Life from Date of Shipment:

32°F (0°C) to 50°F (10°C) – 180 days
51°F (13°C) to 65°F (19°C) – 90 days
66°F (21°C) to 75°F (23°C) – 60 days
76°F (23°C) to 85°F (30°C) – 30 days

* Storage temperature must not exceed 85°F (30°C).

Caution: Natural rubber is susceptible to deterioration by sunlight and oxygen. This is known as 'weather checking'. Do not expose rubber lining to sunlight, ozone or oxygen.

CURE METHODS AND TIMES:

Autoclave	Up to 1/4" - 1 hour at 260°F (127°C)
Internal Pressure	Up to 1/4" - 4 hours at 235°F (112°C)
	Insulated vessels: 2 hours at 235°F (112°C)
Atmospheric	24 hours at 200°F (94°C)

Note: Cure times may require adjustment to compensate for heavy metal thickness, low exterior temperatures or other unusual factors. See Section 14 – Curing Instructions.

ADHESIVE SYSTEM

1 st Coat on Metal	Chemlok® 289
2 nd Coat on Metal	Chemlok® 290
3 rd Coat on Metal	Chemlok® 286 or Tack 103
On the rubber	Chemlok® 286 or Tack 103

* Each adhesive component requires thorough mixing before application.

TYPICAL PHYSICAL PROPERTIES

Tensile Strength PSI	ASTM D412	1300
% Elongation at Break	ASTM D412	600
Durometer	ASTM D2240	35 A
Specific Gravity	ASTM D927	.95
Adhesion To Metal	ASTM D429	30 lbs.

APPLICATOR NOTES

1. Plying up layers of rubber lining thicker than 1/4" could results in the rubber flowing or sagging during cure. Test plate is required to determine flow characteristics.
2. The temperature of the substrate must be greater than 60°F (15°C) prior to applying primer and rubber. Temperatures should not exceed 120°F (49°C).
3. A heated table that warms rubber to approximately 120°F (49°C) prior to application is recommended.
4. Strict adherence to adhesive specifications is required. Tack time is critical to the success of the bond.
5. This lining is susceptible to over-cure. Reversion may occur when cure time and temperature parameters are exceeded.

Disclaimer: The above guidelines are based on general industry practices and not applicable to all installations. Please contact Blair Rubber company for specific application instructions. Application methods shall conform to Blair Rubber Company instructions contained in the Engineering & Applicator manual. Deviations from the specifications must be approved inwriting by Blair Rubber Company. Data values are approximate and may vary based on installation techniques and atmospheric conditions. As such, data values should be used as general guidelines and are not a legally binding warranty of product characteristics. This document is copyright to and intellectual property of Blair Rubber company and may not be copied or distributed without prior consent.