



RUBBER CALENDERED SHEET

DESCRIPTION

DUNLOP 1312 White Uncured Soft Backing for Ebonite – Calendered Sheet

APPLICATION

Autoclave / Cure – Soft Natural Rubber sheet for backing of Ebonite applications. Considered a Tie Gum only. Not to be used for any other applications.

STANDARD PRODUCTS

13.1m x 1200mm roll packed into standard box for transport and storage. Thickness range is 1mm to 15mm.

TYPICAL PROPERTIES (Based on 3mm sheet press cured 10 mins @ 160°C)

Tensile Strength	(ASTM D412 method A)	MPa	16.5
Elongation @ Break	(ASTM D412 method A)	%	550
Hardness	(ASTM D2240 Scale "A")	(A/1)	40 +/-5
S.G.			1.326
Shelf Life	@ or below 7°C	Months	3

TYPICAL CHEMICAL RESISTANCE – 1312 sheet (cured) – up to 70°C Working Conditions

Alkalis	G	Hydrocarbons Oils – Paraffinic (aniline pt>95°C)	U
Acids – Non-oxidising (eg HCL, HCN)	G	Mineral Oils – Naphthenic (aniline pt60-95°C)	U
Acids – Oxidising		Synthetics – Aromatic (aniline pt<60°C)	U
- Sulphuric to 35%	G	Hydrocarbon Solvents >30% aromatics	U
- Nitric	U	5 to 30% aromatics	U
- Others	V	0 to 5% aromatics	U
Inorganic salts - neutral or alkaline	G	Chlorinated Solvents	U
- acidic, refer to parent acid	V	Alcohols	G
Chlorine water	U	Ketones	V
Oxidants	V		
Grading: E=Excellent G=Good P=Poor U=Unsuitable V=Variable. Depends on material and concentration and so check with Fenner Dunlop			

<p>SUGGESTED BONDING SYSTEM</p> <p>Regardless of whether this, or some other system is used, it is the responsibility of the customer to ensure that the chosen calendared sheet and chosen bonding system and procedures is capable of meeting the expected service requirements before committing to production.</p>	<p>Throughout this process surfaces, materials and environment must be maintained at 15 to 30° degrees C and less than 75% Relative Humidity. Avoid dew point throughout all preparation.</p> <p><u>Metal Preparation.</u></p> <ol style="list-style-type: none"> 1.1 Grit blast to AS1627.4 Class 2.5, following full de-grease and removal of flake or other contaminants. 1.2 One coat Chemlock 205 (or Chemlock 289) immediately to dry clean surface. 1.3 One coat Chemlock 220 (or Chemlock 290) 1.4 One coats 1612 solution. <p><u>Rubber Preparation.</u></p> <ol style="list-style-type: none"> 2.1 One or more coat(s) 1612 Solution to absolutely clean, moisture free surface. <p>Solvent: Toluene</p>
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<p>CURING METHOD</p> <p>(Allow additional time for substrate).</p>	<p>Autoclave Cure.</p> <ol style="list-style-type: none"> 1. 30 min. rise to 150°C then <ol style="list-style-type: none"> a) 6mm – 40min @ 150°C b) 12mm – 60min @ 150°C <p>Slow blow down (Minimum 30 mins)</p> <p>NOTE: Excessive temperature or time will reduce physical properties.</p>
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<p>PRECAUTIONS</p> <p>(refer also to solution safety data sheets)</p>	<ol style="list-style-type: none"> 1. Avoid cementing in high humidity conditions to prevent moisture condensation. 2. All solutions are flammable – maintain safety precautions. – 3. Ensure adequate ventilation in confined areas.
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<p>COMMENTS</p>	<ol style="list-style-type: none"> 1. All work should be carried out to BS6374 Part 5:1985 2. For specific chemical resistance contact Fenner Dunlop.
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