



# RUBBER CALENDERED SHEET

## DESCRIPTION

DUNLOP 27255 Uncured Neoprene Rubber – (CR) – Polychloroprene Calendered Sheet

## APPLICATION

Autoclave Cure – Polychloroprene Water & Flame Resistant sheet

## 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 15 mins @ 160°C)

<b>Tensile Strength</b>	(ASTM D412 method A)	MPa	15.0
<b>Elongation @ Break</b>	(ASTM D412 method A)	%	500
<b>Hardness</b>	(ASTM D2240 Scale "A")	(A/1)	65 +/-5
<b>S.G.</b>			1.55
<b>Shelf Life</b>	@ or below 7°C	Months	3

## TYPICAL CHEMICAL RESISTANCE – 27255 sheet (cured) – upto 70°C Working Conditions

<b>Alkalis</b>	<b>V</b>	<b>Hydrocarbons Oils – Paraffinic (aniline pt&gt;95°C)</b>	<b>G</b>
<b>Acids – Non-oxidising</b> (eg HCL, HCN)	<b>U</b>	Mineral Oils – Naphthenic (aniline pt60-95°C)	<b>G</b>
<b>Acids – Oxidising</b>			
- Sulphuric to 35%	<b>U</b>	Synthetics – Aromatic (aniline pt<60°C)	<b>V</b>
- Nitric	<b>U</b>	<b>Hydrocarbon Solvents</b> >30% aromatics	<b>U</b>
- Others	<b>U</b>	5 to 30% aromatics	<b>U</b>
<b>Inorganic salts</b> - neutral or alkaline	<b>U</b>	0 to 5% aromatics	<b>U</b>
- acidic, refer to parent acid	<b>U</b>	<b>Chlorinated Solvents</b>	<b>U</b>
<b>Chlorine water</b>	<b>U</b>	<b>Alcohols</b>	<b>P</b>
<b>Oxidants</b>	<b>U</b>	<b>Ketones</b>	<b>P</b>

Grading: E=Excellent                      G=Good                      P=Poor                      U=Unsuitable  
 V=Variable. Depends on material and concentration and so check with Fenner Dunlop

<p><b>SUGGESTED BONDING SYSTEM</b></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. <b>Avoid dew point throughout all preparation.</b></p> <p><b><u>Metal Preparation.</u></b></p> <ol style="list-style-type: none"> <li>1.1 Grit blast to AS1627.4 Class 2.5, following full de-grease and removal of flake or other contaminants.</li> <li>1.2 One coat Chemlock 205 (or Chemlock 289) immediately to dry clean surface.</li> <li>1.3 One coat Chemlock 220 (or Chemlock 290)</li> <li>1.4 One coat S7E solution.</li> </ol> <p><b><u>Rubber Preparation.</u></b></p> <ol style="list-style-type: none"> <li>2.1 One coat S7E Solution to absolutely clean, moisture free surface.</li> </ol> <p><b>Solvent:</b> Toluene</p>
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<p><b>SUGGESTED CURING METHOD</b></p> <p>(Allow additional time for substrate).</p>	<p>Autoclave Cure.</p> <ol style="list-style-type: none"> <li>1. 30 min. rise to 150°C then             <ol style="list-style-type: none"> <li>a) 6mm – 40min @ 150°C</li> <li>b) Greater thickness's – reduce temperature and increase time.</li> </ol> </li> </ol> <p>Slow blow down (Minimum 30 mins)</p> <p>NOTE: Excessive temperature or time will reduce physical properties.</p>
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<p><b>PRECAUTIONS</b></p> <p>(refer also to solution safety data sheets)</p>	<ol style="list-style-type: none"> <li>1. Avoid cementing in high humidity conditions to prevent moisture condensation.</li> <li>2. All solutions are flammable – maintain safety precautions. –</li> <li>3. Ensure adequate ventilation in confined areas.</li> <li>4. Autoclave blow down gives off strong odour, ensure adequate ventilation to avoid irritation.</li> </ol>
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<p><b>COMMENTS</b></p>	<ol style="list-style-type: none"> <li>1. All work should be carried out to BS6374 Part 5:1985</li> <li>2. For specific chemical resistance contact Fenner Dunlop.</li> </ol>
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