Technical Data Sheet

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® GENAKOR 022

Hard rubber lining for steel components protection with approvals for the transportation of hazardous materials according TRT 010 and TRT 008 Workshop rubber lining

Description
GENAKOR 022 is a graphite-filled hard rubber lining based on isoprene rubber (IR) that is vulcanised in the autoclave. Depending on the requirements, the layer thickness may range between 3 and 6 mm.

Typical uses
GENAKOR 022 is recommended as a protective lining for structural components made of steel that are subjected to chemical exposure.
The primary fields of application include linings for reaction and process tanks that are operated at higher temperatures (125 °C), in particular for shell-and-tube heat exchangers and special steel linings.

Properties
GENAKOR 022 is characterised by its excellent chemical to alkaline and acidic media, as well as organic media.
A particularly notable feature of this lining is its high diffusion resistance and outstanding mechanical properties.
GENAKOR 022 cannot be spark tested.

Chemical resistance
Information on the chemical resistance properties will be furnished on request.

Substrate
The substrate is composed of steel. The steel structures must satisfy the requirements of DIN EN 14879-1.

Surface pret-reatment
The steel surface must be blasted to a metallic white finish. A preparation degree of Sa 2 ½ as specified in DIN EN ISO 12944-4 and a roughness degree of "medium (G)" as specified in DIN EN ISO 8503-1 must be achieved; minimum roughness R_z = 50 µm (Segment 2). After blasting, the steel surface must be primed.
Stainless steel must be blasted with non-ferritic grit.
Grey cast iron must be tempered in the autoclave before blasting, in order to expel any inclusions of moisture.

Application
The GENAKOR 022 rubber lining system is composed of the single-component Vulkodurit adhesive LS3A and the GENAKOR 022 rubber sheet.
For stainless steel and grey cast iron, the single-component Primer 1 and the single-component Primer 2 are applied instead of the pre-coat compound.

Spread the Vulkodurit adhesive LS3A on the substrate. For stainless steel and grey cast iron, spread the Primer 1 on the substrate, followed by the Primer 2 and then apply two coats of the Vulkodurit adhesive LS3A. The rubber sheets are coated with the Vulkodurit adhesive LS3A and bonded to the substrate in accordance with the specifications contained in DIN 28055-1. A durable and solid bonding will be achieved by firmly pressing down the rubber sheet and the subsequent vulcanisation process.

Consumption

Vulkodurit adhesive LS3A	approx. 0.25 kg/m² per coat
For stainless steel/grey cast iron also:	
Primer 1	approx. 0.15 kg/m²
Primer 2	approx. 0.20 kg/m²

Packing
The following standard quantities are available:

Primer 1	23 kg
Primer 2	25 kg
Vulkodurit adhesive LS3A	16, 170 kg

Storage
The products shall be stored in a cool and dry place. With a storage temperature of 23°C the minimum shelf life is as follows:

GENAKOR 022 sheet	6 months
GENAKOR 022 sheet < + 15°C	12 months
Primer 1	12 months
Primer 2	6 months
Vulkodurit adhesive LS3A	6 months

Higher temperatures will shorten the shelf life of this products. The packaging drums are to be kept tightly shut and are to be resealed each time material has been removed. All liquid products must be stored frost-free.

Safety
Adequate ventilation shall be provided during the execution of all work.

Ventilation is compulsory for all work carried out in pits and closed rooms. All vapours that are produced during processing must be continuously suctioned off at floor or bottom level.
Only such amount of material effectively required to continue work is to be stored at the working place. The instructions for the prevention of fire and explosion are to be observed if required.
Please note and ensure that even smallest quantities of the individual components and/or prepared mixtures are not allowed to reach the sewerage.
All regulations for the prevention of accidents stipulated by the employer's liability assurance association, the regulations for the prevention of accidents prescribed at the site of application and the TRGS 507 „Surface treatment in rooms and tanks", as well as the safety precautions listed on the packing (label) required by the provisions of the Hazardous Materials Ordinance shall be adhered to. The operating instructions pursuant to § 14 GefStoffV as well as the EC safety data sheets are to be complied with.

Technical data	Test specification	Unit	Parameter
Density	DIN EN ISO 1183-1	g/cm³	1.40 ± 0.02
Hardness	DIN 53505	Shore D	78 ± 5
Tensile strength *)	DIN 53504	MPa	≥ 20
Elongation at tear *)	DIN 53504	%	> 2
Adhesive strength	DIN EN 24624	MPa	≥ 6
max. surface pressure		MPa	10
max. service temperature		°C	125

*) The values were determined at 4 mm thick rubber samples.

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