

PRODUCT INFORMATION

PRIMER PR 304

PRODUCT DESCRIPTION

PRIMER PR 304 is a red primer for pre-treatment of metal and concrete surfaces prior to soft rubber linings.

ADHESIVE SYSTEM

Soft rubber linings are bonded onto steel or concrete substrates in combination with **CEMENT BC 3004**.

Alternatively, **PRIMER HG 1**, **PRIMER PR 200** or **PRIMER PR 500-1** can replace **PRIMER PR 304** and can be used in combination with **CEMENT BC 3004**.

FIELDS OF APPLICATION

PRIMER PR 304 is used in combination with **CEMENT BC 3004** for the bonding of the soft rubber linings:

CHEMOLINE 3, **CHEMOLINE 3 CN**, **CHEMOLINE 3 F CN**, **CHEMOLINE 4 CN**, **CHEMOLINE 8 CN**, **CHEMOLINE 12 CN FDA**, **CHEMOLINE 55 CN**, **CHEMOLINE 70 CN** and **CHEMOLINE RT CN** onto metal or concrete surfaces.

PRIMER PR 304 can alternatively be used for the **PRIMER PR 200** in combination with **CEMENT SC 4000**.

FEATURES

- Good resistance against atmospheric attacks (ozone, humidity)
- Good workability
- High productivity
- Excellent adhesion of rubber to metal

CHEMICAL RESISTANCE

Information on the chemical resistance properties is available upon request.

SUBSTRATE

Substrates are components made of non-ferrous metals, cast iron, non-alloyed or austenitic steel, concrete, screed or plaster. Components to be rubber lined shall be designed and manufactured in accordance with EN 14879-1.

SURFACE PRE-TREATMENT C-STEEL

All surfaces to be rubber lined must be dry and free of contaminants. All contaminants, including non-visible detectable contaminants, must be removed in accordance with DIN TR 55684 or EN ISO 8502.

Non-alloyed steel surfaces shall be abrasive blasted to "Near White Metal" in accordance with EN ISO 12944-4. A surface preparation degree of SA 2½ (SSPC-SP 10; NACE No. 2) as specified in EN ISO 8501-1 and a "medium (G)" roughness degree as specified in EN ISO 8503-2 must be achieved. A minimum surface profile of $R_z \geq 50 \mu\text{m}$ is required.

To prevent flash rust, the primer must be applied immediately after the blasting and cleaning of the substrate or the component must be air conditioned to a relative humidity of $\leq 40\%$.

CONCRETE

Appropriate action shall be taken to prepare the concrete surfaces; dry and free of dust and free of contaminants such as oil or grease. The concrete shall have minimum tensile strength of 1.5 N/mm² and minimum compressive strength of 25 N/mm². The residual moisture content must not exceed 4%. Generally the concrete surface must be smoothed prior to rubber lining application by applying an Epoxy resin based mortar coat. This coat should be conductive to enable a subsequent spark test (**REMAFIX C**).

ENVIRONMENTAL CONDITIONS

Throughout the rubber lining process, the temperatures of the substrate and rubber lining materials shall be maintained within the range specified by TIP TOP. All surfaces shall be maintained at a temperature at least 3K above the dew point in order to prevent condensation.

APPLICATION

During the application of the product, the application instruction must always be observed.

PRIMER PR 304 has to be mixed thoroughly prior to use. During primer application **PRIMER PR 304** must be covering the surfaces to be rubber lined.

If **PRIMER PR 304** is applied by airless spray, **PRIMER PR 304** must be diluted with **SOLVENT CF-CE** in a mixing ratio of 1:1.

APPLICATION METHOD UND CONSUMPTION

Coat	Product	Application Method	Coverage [g/m ²]
1. Coat steel	PRIMER PR 304	Brush / Roll / Spray	ca. 200

CONTACT LIFE (OPEN TIME)

Coat	Minimal	Maximal
1. Coat steel with PRIMER PR 304	ca. 2 h	ca. 7 Days

Note: The Contact Life depends on the ambient temperature. The indicated Contact Life applies to a temperature range of +20 to +25°C.

CLEANING

Clean all equipment with **SOLVENT CF-CE** immediately after use.

SAFETY MEASURES

The material safety data sheets of the individual components, the safety instructions on the packing (label) as well as the legal requirements for handling hazardous materials must be observed.



PRIMER PR 304

PACKING UNITS

The products are supplied in the following standard package sizes:

Product	Size	Article No.
PRIMER PR 304	0.75 kg	525 4112
PRIMER PR 304	10 kg	525 4150
SOLVENT CF-CE	10 l	595 9163

STORAGE

The products must be stored in a cool and dry place, away from direct sunlight. At the specified storage temperatures a shelf life of the products is given of at least for the following periods:

Product	Temperature	Shelf Life
PRIMER PR 304	5 - 25°C	12 Months
SOLVENT CF-CE	5 - 25°C	60 Months

If the storage time is exceeded, the materials must be tested before use. Higher storage and transport temperatures will reduce the shelf life. The containers must be kept tightly closed. Liquid products must be stored frost-proof. In addition, the DIN 7716 must be observed.

Information given in the fact sheet above corresponds to the current knowledge available to us regarding our products at the time of its drafting and is intended as a guideline for informational purposes. However, because of the multiple possibilities regarding possible applications, processing and on site conditions, any information given in the fact sheet above is not legally binding, in particular, without being limited to, such information shall not be interpreted as a warranty of merchantability or of fitness for a particular purpose. Customer therefore is advised to conduct its own testing or make an inquiry with our technical department before ordering. We reserve the right to change the product at any time, in particular, without being limited to, minor changes because of advancements in technology. If by way of exception, the information given in the fact sheet above is incorporated by reference into any contract concluded with us under German Law, such information, shall only be interpreted as determining the specific requirements of the contractual products as set out in § 434 BGB (German Civil Code) and shall not be interpreted as constituting a guarantee of condition.

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