

PRIMER PR 500-1 & PRIMER S 500-2

PRODUCT DESCRIPTION

The two-coat primer system **PRIMER PR 500-1 & PRIMER S 500-2** consists of the gray metal primer **PRIMER PR 500-1** and the black adhesive primer **PRIMER S 500-2**.

ADHESIVE SYSTEM

The soft rubber linings **CHEMOLINE 4 A**, **CHEMOLINE 4 B**, **CHEMOLINE 5 B**, **CHEMOLINE 12 FDA**, **CHEMOLINE 13** and **CHEMOLINE 70** are bonded onto steel substrates in combination with **ADHESIVE TC 5000**.

CHEMOLINE 40 and **CHEMOLINE 55** is bonded onto steel substrates in combination with **ADHESIVE REMACLAVE SOLUTION**.

Alternatively, the two-coat priming system **PRIMER HG 1 & PRIMER HG 2** can replace **PRIMER PR 500-1 & PRIMER S 500-2** and can be used in combination with **ADHESIVE TC 5000** as well as with **ADHESIVE REMACLAVE SOLUTION**.

FIELDS OF APPLICATION

PRIMER PR 500-1 & PRIMER S 500-2 is used in combination with **ADHESIVE TC 5000** or **ADHESIVE REMACLAVE SOLUTION** for the bonding soft rubber linings onto steel substrates.

FEATURES

- Good workability
- High productivity
- Excellent adhesion of rubber to metal
- Good resistance to temperature changes
- High thermal stability

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. Components to be rubber lined shall be designed and manufactured in accordance with EN 14879-1.

SURFACE PRE-TREATMENT

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 $\leq 40\%$.

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 500-1 & PRIMER S 500-2 must be mixed thoroughly prior to use. During primer application **PRIMER PR 500-1 & PRIMER S 500-2** must be covering the surfaces to be rubber lined.

APPLICATION METHOD UND CONSUMPTION

Coat	Product	Application Method	Coverage [g/m ²]
1. Coat steel	PRIMER PR 500-1	Brush / Roll / Spray	ca. 150
2. Coat steel	PRIMER S 500-2	Brush	ca. 125

CONTACT LIFE (OPEN TIME)

Coat	Minimal	Maximal
1. Coat steel with PRIMER PR 500-1	ca. 2 h	ca. 14 Days
2. Coat steel with PRIMER S 500-2	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 500-1 & PRIMER S 500-2

PACKING UNITS

The products are supplied in the following standard package sizes:

Product	Size	Article No.
PRIMER PR 500-1	0.75 kg	525 2303
PRIMER PR 500-1	9 kg	525 2327
PRIMER PR 500-1	4.5 kg	525 2470
PRIMER PR 500-1	25 kg	525 2334
PRIMER S 500-2	0.75 kg	525 2310
PRIMER S 500-2	9 kg	525 2341
PRIMER S 500-2	25 kg	525 2358
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 500-1	5 - 25°C	12 Months
PRIMER S 500-2	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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TIP TOP Oberflächenschutz Elbe GmbH	PRIMER PR 500-1 & PRIMER S 500-2	Revision 1.07 - 12.03.2021
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