

PRODUCT INFORMATION

ADHESIVE SH-3A SOLUTION

PRODUCT DESCRIPTION

ADHESIVE SH-3A SOLUTION is a pink coloured adhesive based on Natural rubber (NR).

ADHESIVE SYSTEM

The two-coat primer system **PRIMER HG 1 & PRIMER HG 2** must be applied onto steel surfaces prior to adhesive in case of vulcanisation with steam or hot water. **ADHESIVE SH-3A SOLUTION** must be applied onto the primed steel surface. **ADHESIVE PARA SOLUTION** is used for brushing the rubber sheet.

FIELDS OF APPLICATION

ADHESIVE SH-3A SOLUTION is used in combination with **ADHESIVE PARA SOLUTION** for the bonding of the hard rubber linings:

CHEMONIT 18HT, CHEMONIT 20 KTW, CHEMONIT 31, CHEMONIT 33, CHEMONIT 35, and CHEMONIT 181 onto the steel surfaces.

FEATURES

- Very long open time (wet / contact life)
- High tack
- Good workability
- High productivity
- High adhesion strength
- Good thermal stability (max. +120°C)

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 $R_z \geq 60 \mu\text{m}$ 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.

ADHESIVE SH-3A SOLUTION has to be stirred thoroughly prior to use.

APPLICATION METHOD UND CONSUMPTION

Coat	Product	Application Method	Coverage [g/m ²]
1. Coat steel	ADHESIVE SH-3A SOLUTION	Brush	ca. 200
2. Coat steel	ADHESIVE SH-3A SOLUTION	Brush	ca. 200

CONTACT LIFE (OPEN TIME)

Coat	Minimal	Maximal
1. Coat steel	ca. 3 h	ca. 14 Days
2. Coat steel	ca. 6 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.



// ONE BRAND // ONE SOURCE // ONE SYSTEM

ADHESIVE SH-3A SOLUTION

PACKING UNITS

The products are supplied in the following standard package sizes:

Product	Size	Article No.
ADHESIVE SH-3A SOLUTION	4 kg	538 1410
ADHESIVE SH-3A SOLUTION	8 kg	538 1511
ADHESIVE SH-3A SOLUTION	21 kg	538 1430
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
ADHESIVE SH-3A SOLUTION	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.

TIP TOP Oberflächenschutz Elbe GmbH | Heuweg 4 | 06886 Wittenberg / Germany
Phone: +49 (0) 3491 635 50 | E-Mail: info@tiptop-elbe.de | Internet: www.tiptop-elbe.com

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Replaces all previous editions	PRODUCT INFORMATION	Page: 2/2