

PRODUCT INFORMATION

CEMENT BC 3004

PRODUCT DESCRIPTION

CEMENT BC 3004 is a blue two-component adhesive based on Chloroprene rubber (CR).

ADHESIVE SYSTEM

The application of **CEMENT BC 3004** onto steel or concrete surfaces is carried out in combination with **PRIMER PR 304**. 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

CEMENT BC 3004 has been specially designed for rubber lining of larger components or surfaces on construction sites and in workshops, where a long contact bonding time is required.

CEMENT BC 3004 is mainly used to bond the TIP TOP 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**. **CEMENT BC 3004** is particularly applicable for rubber to rubber, rubber to metal and rubber to concrete bonds.

FEATURES

- Extended pot life
- Very long open time (wet / contact life)
- High tack
- Good workability
- High adhesion strength and high dynamic load ability of the bonding

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.

CEMENT BC 3004 must be mixed with 4 % **HARDENER E 40** intensively until a uniform mixture is achieved. The pot life of the adhesive-hardener mixture is max. 4 hours @ 20°C.

APPLICATION METHOD UND CONSUMPTION

Coat	Product	Application Method	Coverage [g/m ²]
1. Coat steel (roughened rubber sheet)	CEMENT BC 3004	Roll	ca. 200 (300)
2. Coat steel (roughened rubber sheet)	CEMENT BC 3004	Brush	ca. 200 (300)
1. Coat on unvulcanised rubber or CN-bonding layer	CEMENT BC 3004	Brush	ca. 200

CONTACT LIFE (OPEN TIME)

Coat	Minimal	Maximal
1. Coat steel	ca. 2 h	ca. 7 Days
2. Coat steel	ca. 30 min	ca. 2 h
1. Coat rubber	ca. 30 min	ca. 60 min

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.



CEMENT BC 3004

PACKING UNITS

The products are supplied in the following standard package sizes:

Product	Size	Article No.
CEMENT BC 3004	4.5 kg	525 4095
CEMENT BC 3004	9 kg	525 4143
CEMENT BC 3004	18 kg	525 4130
CEMENT BC 3004	190 kg	525 4105
HARDENER E 40	30 g	525 1067
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
CEMENT BC 3004	5 - 25°C	24 Months
HARDENER E 40	5 - 25°C	24 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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