



PRODUCT INFORMATION

CEMENT BC 3004

PRODUCT DESCRIPTION

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

FIELDS OF APPLICATION

CEMENT BC 3004 has been specially developed for use on-site and in workshops where larger areas or surfaces are lined with **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 suitable for rubber-to-rubber, rubber-to-metal and rubber-to-concrete bonding.

For the **CEMENT BC 3004** bonding system, **PRIMER PR 304** is required for bonding to steel or concrete substrates. Alternatively, **PRIMER HG 1**, **PRIMER PR 200** or **PRIMER PR 500-1** can be used instead of **PRIMER PR 304** in combination with **CEMENT BC 3004** on steel substrates.

FEATURES

- Long pot life
- Long open time (contact bonding time)
- High tack
- High adhesive strength and dynamic load-bearing capacity after bonding

CHEMICAL RESISTANCE

Requests for chemical resistance can be sent to awt@tiptop-elbe.de.

SUBSTRATE

Substrates are components made of non-ferrous metals, cast materials, unalloyed or austenitic steel. The components must be designed and manufactured in accordance with EN 14879-1. The substrate must remain dry during application.

SURFACE PRE-TREATMENT

STEEL

EN14879-1 and the TIP TOP specification "Corrosion protection of metallic components" must be observed. Unalloyed steel must be blasted to "Near White Metal" in accordance with EN ISO 12944-4. A surface preparation degree of SA 2½ according EN ISO 8501-1 and a roughness degree "Medium (G)" according EN ISO 8503-2 must be achieved. A minimum roughness depth of $Rz \geq 50 \mu\text{m}$ is required. After blasting, the formation of new rust should be prevented by suitable measures (e.g. priming).

CONCRETE | SCREED

EN 14879-1 and the TIP TOP specification "Requirements for concrete structures and cementitious substrates" must be observed. The substrate must be prepared by suitable measures so that it is dry, free of cement slurries, cement skin, loose and friable parts, structural defects and substances with a separating effect. The residual moisture of cementitious substrates must not exceed 4%. The substrate is usually trowelled with a conductive epoxy resin filler (**REMAFIX C**) approx. 1-3 mm.

CLIMATIC CONDITIONS

During application, direct or indirect sunlight must be avoided and the climatic conditions specified in the application instruction must be observed. To avoid condensation, a dew point difference of at least 3K must be maintained. During application, the materials must never be colder than the ambient temperature at the workplace.

APPLICATION METHOD | CONSUMPTION | OPEN TIME

Coat	Product	Application Method	Consumption	Min. Open Time	Max. Open Time
1. Coat steel	CEMENT BC 3004	Brush / roll	ca. 200 g/m ²	2 h	7 d
2. Coat steel	CEMENT BC 3004	Brush	ca. 200 g/m ²	30 min	2 h
1. Coat rubber	CEMENT BC 3004	Brush	ca. 200 g/m ²	30 min	1 h

Always observe the current application instruction before using the products. The specified open times apply to a temperature range of +20°C to +25°C. The consumption of **CEMENT BC 3004** on concrete & roughened rubber is



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

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approx. 300 g/m². **CEMENT BC 3004** must be mixed intensively with approx. 4% **HARDENER E-40** until homogeneous. The pot life of the adhesive-hardener mixture is max. 4 hours at 20°C.

CLEANING

All equipment should be cleaned with **SOLVENT CF-CE** immediately after use. The equipment should be cleaned in a well-ventilated area.

DELIVERY FORM | MINIMUM SHELF LIFE

Product	Packaging	Article No.	Storage temperature	Min. shelf life
CEMENT BC 3004	0.7 kg	525 4084 New	5 - 25°C	24 Mon
CEMENT BC 3004	0.7 kg	525 4088	5 - 25°C	24 Mon
CEMENT BC 3004	4.5 kg	525 4091 New	5 - 25°C	24 Mon
CEMENT BC 3004	4.5 kg	525 4095	5 - 25°C	24 Mon
CEMENT BC 3004	9 kg	525 4144 New	5 - 25°C	24 Mon
CEMENT BC 3004	9 kg	525 4143	5 - 25°C	24 Mon
CEMENT BC 3004	190 kg	525 4102 New	5 - 25°C	24 Mon
CEMENT BC 3004	190 kg	525 4105	5 - 25°C	24 Mon
HARDENER E-40	30 g	525 1067	5 - 25°C	24 Mon
SOLVENT CF-CE	10 l	595 9163	5 - 25°C	60 Mon

The products must be stored in a cool, dry place protected from direct sunlight. Higher storage and transport temperatures shorten the shelf life. If the minimum shelf life is exceeded, the materials must be checked before use. The containers must be stored frost-free and tightly closed and resealed after each removal. DIN 7716 must be observed. Information on handling, storage & transport can be found in the safety data sheet.

SAFETY MEASURES

The safety data sheets for the individual components and the legal regulations for handling hazardous substances must be observed. The prescribed personal protective equipment must be worn. Information on disposal can be found in the safety data sheets for the individual products. The safety data sheets can be downloaded from our homepage in the download area.

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.