

## PRODUCT INFORMATION

### CEMENT SC 4000

#### PRODUCT DESCRIPTION

**CEMENT SC 4000** is a two-component adhesive based on Chloroprene rubber (CR).

#### ADHESIVE SYSTEM

The application of **CEMENT SC 4000** onto steel surfaces is carried out in combination with **PRIMER PR 200**. Alternatively, **PRIMER PR 200** can be replaced by **PRIMER PR 500-1** in combination with **CEMENT SC 4000** onto the steel substrates.

#### FIELDS OF APPLICATION

**CEMENT SC 4000** is used especially for the soft rubber lining of areas either on site or in the workshop. **CEMENT SC 4000** is in particular applicable for rubber to rubber, rubber to metal, rubber to fabric and fabric to fabric bonding.

#### APPROVALS & CERTIFICATES

The ingredients of **CEMENT SC 4000** white are according to CFR 21§175.105 of US Food and Drug Administration FDA permitted for food contact in combination with **HARDENER E-40**.

#### FEATURES

- High adhesive strength
- 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. 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.

**CEMENT SC 4000** 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. 2 hours @ 20°C.

#### APPLICATION METHOD UND CONSUMPTION

Coat	Product	Application Method	Coverage [g/m <sup>2</sup> ]
1. Coat steel, CN-bonding layer (roughened rubber sheet / fabric)	<b>CEMENT SC 4000</b>	Roll	ca. 200 (300 / 400)
2. Coat steel (roughened rubber sheet / fabric)	<b>CEMENT SC 4000</b>	Brush	ca. 200 (300 / 400)
1. Coat on unvulcanised rubber	<b>CEMENT SC 4000</b>	Brush	ca. 300

#### CONTACT LIFE (OPEN TIME)

First coat: min. 30 min., on metal min.1 hour (\*)

Second coat: has to adhere slightly to the back of the finger. In case of over drying, apply another coat.

Due to its short contact life, **CEMENT SC 4000** is an outstanding adhesive for the bonding of rubber sheets under tension (radii and small size parts).

(\*) The pot life, contact life and waiting time naturally always depend on climate and environmental influences such as ambient temperature, air humidity, ventilation etc. Therefore the times indicated are to be understood as guidelines only; the ideal time must be determined locally considering the corresponding climatic conditions.

#### 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 SC 4000

### PACKING UNITS

The products are supplied in the following standard package sizes:

Product	Size	Article No.
CEMENT SC 4000 green	0.7 kg	525 2509
CEMENT SC 4000 green	4.5 kg	525 2516
CEMENT SC 4000 black	0.35 kg	525 2592
CEMENT SC 4000 black	0.7 kg	525 2602
CEMENT SC 4000 black	4.5 kg	525 2619
CEMENT SC 4000 black	9 kg	525 2657
CEMENT SC 4000 white	0.7 kg	525 2704
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 SC 4000	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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