

PRODUCT INFORMATION

CHEMONIT HG DISC

PRODUCT DESCRIPTION

CHEMONIT HG DISC is a pre-vulcanised hard rubber disc fabricated from **CHEMONIT** hard rubber lining material.

FIELDS OF APPLICATION

CHEMONIT HG DISC is applied to the flange faces. Vessels lined on-site by using **CHEMONIT** hard rubber linings must have a hard rubber lining on the flange faces.

CHEMONIT HG DISC is also often applied on-site if the vessel is lined with a self-vulcanizing or pre-vulcanized TIP TOP rubber lining system.

FEATURES

- High chemical resistance to mineral acids, concentrated hydrochloric acid and bases
- High continuous operating temperature
- Pre-vulcanised in the workshop
- Application on metallic substrates
- On-site rubber lining

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

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 $Rz \geq 60 \mu\text{m}$ is required. After blasting, the formation of new rust should be prevented by suitable measures (e.g. priming).

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.

ADHESIVE SYSTEM

CHEMONIT HG DISC is bonded to flange faces with **REAMFIX H**. Alternatively, **REMAFIX 111** can also be used.

APPLICATION METHOD | CONSUMPTION | OPEN TIME

Coat	Product	Application	Consumption	Min. Open Time	Max. Open Time
1. Coat rubber	REMAFIX H	Brush	ca. 2000 g/m ²	8 h	10 h
1. Coat steel	REMAFIX H	Brush	ca. 2000 g/m ²	8 h	10 h

CHEMONIT HG DISC is cut to size with a jigsaw and ground completely (on both sides) using an angle grinder. Subsequently the **CHEMONIT HG DISC** is cleaned with **SOLVENT CF-CE**. The adhesive system is applied to the adhering side of the hard rubber plate as well as to the flange surface before the **CHEMONIT HG DISC** is applied to the flange facing. 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.

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CLEANING

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

VULCANISATION

Location	Vulcanisation
On-site	As vulcanisation has already taken place in the workshop, no thermal post-treatment is required

SPARK TEST

The spark test is carried out in accordance with EN 14879-4. Only the Elmed Isotest IIRT, Isotest 3P or Isotest Inspect 35 high-voltage testers and the Wegener WEG 20, WEG 22 or WEG 100 test pistols may be used. Multiple tests can reduce the dielectric strength of the lining materials and must be taken into account by reducing the test voltage by at least 1 kV/mm. Special agreements are required for linings that have already been in operation.

CHEMONIT HG DISC	Test voltage	Max. Test voltage
vulkanisiert	3,0 kV/mm	20,0 kV

DELIVERY FORM | MINIMUM SHELF LIFE

Product	Packaging	Article No.	Storage temperature	Min. shelf life
REMAFIX 111 COMP. A	0.6 kg	525 1211	5 - 25°C	24 Mon
REMAFIX 111 COMP. A	9 kg	525 1230	5 - 25°C	24 Mon
REMAFIX 111 COMP. B	0.4 kg	525 1221	5 - 25°C	24 Mon
REMAFIX 111 COMP. B	6 kg	525 1240	5 - 25°C	24 Mon
REMAFIX H COMP. A & B	1 kg	525 0563	5 - 25°C	12 Mon
SOLVENT CF-CE	10 l	595 9163	5 - 25°C	60 Mon

Dimensions	Article No. (DIN*)	Article No. (MIN)	Storage temperature	Min. shelf life
3 mm x 1100 mm x 10000 mm	529 6950	-	≤ +25°C	24 Mon
4 mm x 1100 mm x 10000 mm	529 6960	-	≤ +25°C	24 Mon
5 mm x 1100 mm x 10000 mm	529 6970	-	≤ +25°C	24 Mon
6 mm x 1100 mm x 10000 mm	529 7000	-	≤ +25°C	24 Mon

* Tolerances according to EN 14879-4

The products must be stored in a cool, dry place protected from direct sunlight. Higher storage and transport temperatures shorten the shelf life. 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.

PHYSICAL DATA

Properties	Standard	Unit	Value
Adhesive strength steel	EN ISO 4624 (ASTM D429, Method E)	N/mm ²	≥ 6
Max. Surface pressure	-	N/mm ²	10



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PHYSICAL DATA

Properties	Standard	Unit	Value
Shore hardness	ISO 48-4 (ASTM D2240)	Shore D	> 62 (ground)
Temperature range	-	°C	-20 up to +110

The specified temperatures depend on the existing load and can therefore vary.

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.