

PRODUCT INFORMATION

CEMENT BC 3004 (CFC FREE)

Fields of application

CEMENT BC 3004 is a two component, CFC free adhesive and has been developed especially for construction sites and workshops where larger plant components i.e. surfaces are to be lined with **CHEMOLINE** products and in which cases the bonding with CEMENT SC 4000 was sometimes a problem due to its relatively short window for application. **CEMENT BC 3004** is a two-component adhesive for bonding rubber to rubber and rubber to metal.

The metal surface must be primed by using of our **METAL PRIMER PR 304**; alternatively the **METAL PRIMER PR 300** or **METAL PRIMER PR 500** can be used.

Product Description

Polymer basis:	Chloroprene (CR)
Solvent:	Cyclohexane / Ethyl acetate
Colour:	blue
Specific weight:	0.94 g/cm ³
Indication of Danger:	Highly flammable, Irritant, Dangerous for the environment

Product Advantages

- Extended pot life
- Very long window for application (contact life)
- High tack
- Easy to apply
- Increased productivity
- High bonding strength and/or high dynamic load ability of the bond
- CFC free

Mixing

The **HARDENER E 40** (4 % by weight) is added to the **CEMENT BC 3004** and stirred thoroughly, until cement and hardener are mixed completely and homogeneously (1 min. / 0.7 kg).

Processability (Pot life) *

Once both components (**CEMENT BC 3004 / HARDENER E 40**) have been mixed, the compound must be processed within 4 hours.

Contact Life on steel (Window for Application)

First Coat:	minimum 2 hours *
	Maximum 7 days *
Second Coat:	minimum 30 minutes *
	maximum 2 hours *

Contact Life on rubber (Window for Application)

First Coat:	minimum 30 minutes *
	maximum 60 minutes *

* Pot life, contact bonding times as well as dwell times are naturally always dependent upon climate and environmental conditions, such as ambient temperature, air humidity, ventilation etc. Consequently, the indicated time periods should be regarded as a general guideline only; the ideal time periods must be determined on site while taking the respective climatic conditions into account.

Number of Coats

On metal	2 coats
On CN bonding layer and un-vulcanised rubber	1 coat
On buffed rubber	2 coats

Consumption per m² (for one coat)

On metal	200 g
On CN bonding layer and un-vulcanized rubber	200 g
On buffed rubber	300 g

Limits for the application of materials

Temperature range:	+ 10 °C to + 40 °C
Maximum relative humidity:	80 %

Shelf Life

2 years when storing in unopened original container under storing conditions in accordance with DIN 7716.

Available Packing Units

Description	Contents	Product-No.
CEMENT BC 3004	0,7 kg	525 4088
CEMENT BC 3004	4,5 kg	525 4095
CEMENT BC 3004	9,0 kg	525 4143
CEMENT BC 3004	18,0 kg	525 4130
CEMENT BC 3004	190 kg	525 4105
HARDENER E 40	0,03 kg	525 1067
CLEANER CE	8,3 kg (10 l)	595 9163

This data sheet is for informational purposes only. All data provided herein is based on in-depth research and testing, however no liability whatsoever can be assumed. Since we are constantly endeavouring to up-date and improve our products, we recommend noting the index and issue date indicated on this data sheet and to inquire as to whether any properties have changed in the interim. This Product Information Sheet replaces all prior issues. Please contact our Technical Consultant for detailed information in case of ambiguities.

TIP TOP Oberflächenschutz Elbe GmbH, Heuweg 4, D-06886 Wittenberg
Phone: (0 34 91) 6 35 – 50, Fax: (0 34 91) 6 35 – 5 52

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