

PRODUCT INFORMATION

Priming System PRIMER HG 1 / PRIMER HG 2

Fields of application

The 2 layer priming system **PRIMER HG 1 / PRIMER HG 2** is used exclusively for the preparation of metal surfaces to be lined with TIP TOP hard and soft rubber linings. The primers **PRIMER HG 1** and **PRIMER HG 2** have to be used as system at all times.

The primer system **PRIMER HG 1 / PRIMER HG 2** is applicable TIP TOP hard rubber linings and must be used for rubber-metal bonds with **ADHESIVE SOLUTION SH-3A**, which are vulcanised in an autoclave by steam or alternative on site by hot water. A vulcanisation in an autoclave by means of hot air can be done as well.

Special soft rubber lining materials like for example **CHEMOLINE 8**, **CHEMOLINE RT**, and **CHEMOLINE 14** are applied with **PRIMER HG 1** and **PRIMER HG 2** in combination with the respective adhesive.

Details on the use of the primer system **PRIMER HG 1 / PRIMER HG 2** are given in the respective Product Information.

This 2 layer primer system can also be used for the application of hard rubber onto stainless steel and grey cast iron as well as for special applications.

If required, **PRIMER HG 1** and **PRIMER HG 2** can be used as a replacement of the TIP TOP primer system **PRIMER PR 500-1 / PRIMER S 500-2**.

Vice versa **PRIMER PR 500-1 / PRIMER S 500-2** cannot be used as a replacement for **PRIMER HG 1** and **PRIMER HG 2**.

Product advantages of PRIMER HG 1 and PRIMER HG 2

- Good workability
- Economical consumption
- Excellent bonding of rubber to metal
- Good resistance to temperature changes
- Good thermal stability

Product description: PRIMER HG 1

Polymer basis:	polymer-mixture
Solvent:	Methyl isobutyl ketone, Xylene
Colour:	grey
Spec. weight:	0.92 - 0.94 g/cm ³
Consumption:	approximately 150 g/m ²
Number of coats:	1 coat onto metal
Drying time:	min. 1 hour *
Classification:	highly flammable, harmful

Product description: PRIMER HG 2

Polymer basis:	polymer-mixture
Solvent:	Xylene
Colour:	black
Spec. weight:	0.93 - 0.97 g/cm ³
Consumption:	approximately 150 g/m ²
Number of coats:	1 coat onto metal prepared with PRIMER HG 1
Drying time:	min. 1 hour *
Classification:	flammable, harmful

* The drying naturally always depends 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.

Preparation of Primers

Both materials, **PRIMER HG 1** as well as **PRIMER HG 2** has to be stirred thoroughly before applying.

Environmental conditions

Object Temperature:	+10 °C to + 35 °C
Maximum relative humidity 1 st coat onto steel	60 %
Maximum relative humidity additional coats	80 %
Minimum distance to the dew point	3 K

Shelf life

PRIMER HG 1 and **PRIMER HG 2** can be stored without any loss of quality for a period of up to 1 year when storing in unopened original container under storing conditions in accordance with DIN 7716.

Available Packing Units

Description	Contents	Product-No.
<i>PRIMER HG 1</i>	0.75 kg	525 2949
<i>PRIMER HG 1</i>	9 kg	525 2956
<i>PRIMER HG 1</i>	23 kg	525 2963
<i>PRIMER HG 2</i>	0.75 kg	525 2970
<i>PRIMER HG 2</i>	9 kg	525 2987
<i>PRIMER HG 2</i>	25 kg	525 2994

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: +49 (0) 34 91 / 6 35 – 50, Fax: +49 (0) 34 91 / 6 35 – 5 52

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