



APPLICATION INSTRUCTIONS

Cement SC 4000

FIELDS OF APPLICATION

CHC-free, two-component-adhesive for bonding rubber to rubber, rubber to fabric, rubber to metal, fabric to fabric.

APPLICATION

PREPARING

- Ambient and material temperature + 5 °C up to +45 °C.
- Avoid direct sunlight; avoid the temperature falling below the dew point (Formation of condensation water).
- Bonding surfaces: dry, free from chemicals, grease and oil.
- Metal: Remove rust and roughen metal surface preferably by grit blasting (DIN EN ISO 12944-4, SA 2.5) or by grinding - recommended grinding depth: 60 µm. Remove the grease from the cleaned surface area with cleaner REMA TIP TOP SOLVENT CF-CE, if necessary. Immediately apply one coat of REMA TIP TOP PRIMER PR 200. Allow the coat to dry completely.
- Rubber: Buff thoroughly (no bright surface areas!) Remove dust without using any fluid.
- Fabric: Do not buff the fabric, only buff the rest of the rubber until it is even. Remove buffing dust without using any fluid.

MIXING

Stir CEMENT SC 4000 thoroughly. Mix the required quantity of CEMENT SC 4000 with HARDENER E-40 (4% of the total weight) by stirring thoroughly until a homogeneous mixture is obtained. Use the mixture within 2 hours (potlife).

APPLYING THE COATS

Apply 2 even and thin coats on each bonding surface. Allow the first coat to dry completely (at least 30 minutes, at least 1 hour on metal). Let the second coat dry until it is still slightly tacky (check with the back of your finger). In case of over drying, apply another coat.

Note: Only one coat is required for REMA TIP TOP special rubber with CN bonding layer.

BONDING

Put the bonding surfaces on one another, avoiding air entrapment. Stitch on tightly or press on.

SAFETY NOTES

Keep a good ventilation and air-exhaust at the place of work. For further information see the Safety Data Sheet on our site www.rema-tiptop.com

The above - mentioned information is the result of field trial. Because of the differences in materials and Operating conditions which are beyond our control, we recommend in any event that you conduct adequate tests of your own. No liability of any kind can be deduced from this information.

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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