

PRODUCT INFORMATION

PRIMER HG 1 & PRIMER HG 2

PRODUCT DESCRIPTION

PRIMER HG 1 & PRIMER HG 2 consists of the grey metal primer **PRIMER HG 1** and the black bonding primer **PRIMER HG 2**.

FIELDS OF APPLICATION

PRIMER HG 1 & PRIMER HG 2 is used in combination with adhesives for bonding hard and soft rubber linings to steel substrates. Hard rubber linings are bonded to steel in combination with **ADHESIVE SH-3A SOLUTION / ADHESIVE PARA SOLUTION**. **CHEMOLINE 8** is bonded to steel in combination with **ADHESIVE TC 6000** and **CHEMOLINE RT** in combination with **ADHESIVE TC 5002**.

PRIMER HG 1 & PRIMER HG 2 can alternatively be used instead of **PRIMER PR 500-1 & PRIMER S 500-2** in combination with **ADHESIVE TC 5000**, **ADHESIVE REMACLAVE SOLUTION** or **CEMENT BC 3004** (**CHEMOLINE 3** autoclave vulcanisation). Alternatively, **PRIMER HG 11 & PRIMER HG 21** can be used instead of **PRIMER HG 1 & PRIMER HG 2**.

FEATURES

- Good spreadability
- High spreading rate
- Excellent rubber-metal bond
- Good thermal shock resistance
- High temperature stability

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 to EN ISO 8501-1 and a roughness degree "Medium (G)" according to EN ISO 8503-2 must be achieved. A minimum roughness depth of $R_z \geq 50 \mu\text{m}$ (soft rubber) or $R_z \geq 60 \mu\text{m}$ (hard rubber) 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.

APPLICATION METHOD | CONSUMPTION | OPEN TIME

Coat	Product	Application Method	Consumption	Min. Open Time	Max. Open Time
1. Coat steel	PRIMER HG 1	Roll / brush	ca. 150 g/m ²	2 h	14 d
2. Coat steel	PRIMER HG 2	Brush	ca. 150 g/m ²	1 h	7 d

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. **PRIMER HG 1 & PRIMER HG 2** must be stirred thoroughly before use and must be applied to the prepared substrate in a covering manner.

CLEANING

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

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DELIVERY FORM | MINIMUM SHELF LIFE

Product	Packaging	Article No.	Storage temperature	Min. shelf life
PRIMER HG 1	0.75 kg	525 2949	5 - 25°C	12 Mon
PRIMER HG 1	4.5 kg	525 3050	5 - 25°C	12 Mon
PRIMER HG 1	9 kg	525 2956	5 - 25°C	12 Mon
PRIMER HG 1	25 kg	525 2963	5 - 25°C	12 Mon
PRIMER HG 2	0.75 kg	525 2970	5 - 25°C	12 Mon
PRIMER HG 2	9 kg	525 2987	5 - 25°C	12 Mon
PRIMER HG 2	25 kg	525 2994	5 - 25°C	12 Mon
SOLVENT CF-CE	10 l	595 9163	5 - 25°C	60 Mon

The products must be stored in a cool, dry place protected from direct sunlight. Higher storage and transport temperatures shorten the shelf life. If the minimum shelf life is exceeded, the materials must be checked before use. 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.

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.