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REMA TIP TOP  
Bonding Systems

## REMA TIP TOP BONDING SYSTEMS

REMA TIP TOP was one of the originating companies that developed rubber bonding adhesives in the early 1900's. Since the original formulation, REMA TIP TOP has continued to invest in research and development to provide a wide offering that meets a variety of application and environmental needs. REMA TIP TOP chemical products have often been copied but lack the exact formulation that provide the premium adhesion values that our customers expect from our products. REMA TIP TOP believes in continued investment in new products that meet the needs and requirements of our customers.

Our stringent quality control system guarantees that REMA TIP TOP products meet our high level of quality, beginning with carefully controlled raw materials exclusively from certified suppliers. REMA TIP TOP believes in and stands behind our products 100%, providing you peace of mind when buying any REMA TIP TOP product.

Worldwide REMA TIP TOP expertise and quality sets the standard. Rely on REMA TIP TOP.

Field of application	Series	Adhesive / Hardener	Metal Primer	Solvent
Wear Protection, Conveyor Belt Splicing and Repair Pulley Lagging	SC-Series	SC 2000 UT-R 20 (non-flammable)	PR 200	#13
		SC 4000 E-40 (CFC-free)	PR 200 PR 304	R-50
Corrosion Protection	BC-Series	BC 3004 E-40 (CFC-free)	PR 304 PR 200*	R-50
Splicing and Repair of PVC Conveyor Belts, Bonding of PVC and PU materials	PC-Series	Plastic Cement PC-4 E-40 (CFC-free)		R-50

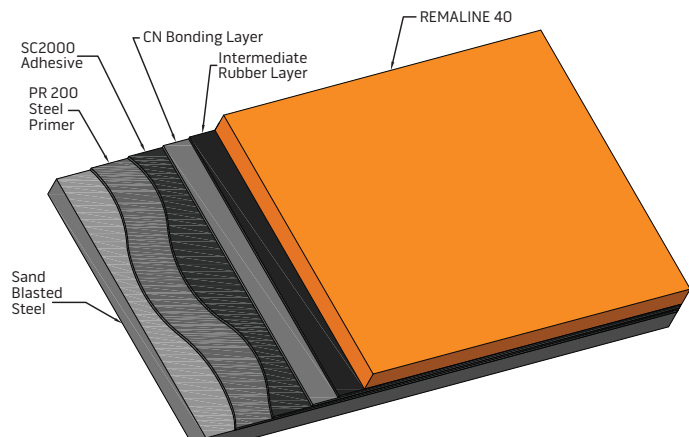
\* REMA TIP TOP recommends using PR 200 with a dry coat of SC 4000 when using BC 3004.

### Adhesives and Solutions Approximate Coverage Information

SC2000, C320	1 kg	30 ft <sup>2</sup>
	5 kg	150 ft <sup>2</sup>
SC4000, BC3004	660 g	29 ft <sup>2</sup>
	3.3 kg	142 ft <sup>2</sup>
PR200 Metal Primer	1 qt.	95 ft <sup>2</sup>
	1 gal.	380 ft <sup>2</sup>

### CN Bonding Layer with Intermediate Layer

The REMA TIP TOP CN bonding layer is specially formulated to work with REMA TIP TOP bonding systems to create the greatest adhesions possible between the rubber and substrate. The CN bonding layer is a semi-cured layer that when activated with the bonding system completes the vulcanization process, creating cross links between the materials that provides the strongest bonds available. The intermediate layer between the rubber sheet and CN bonding layer is propriety to REMA TIP TOP and ensure the base rubber and bonding layer are inseparable. REMA TIP TOP's intermediate layer is differentiated by the softer, more elastic durometer that allows for flexibility and prevents shearing.



# REMA TIP TOP

## CEMENT SC Series

### CEMENT SC Series

The Bonding Systems of the CEMENT SC Series are applicable for durable rubber-rubber, rubber-fabric, rubber-metal and fabric-fabric bonds in the fields of wear and corrosion protection as well as in conveyor belt technology.

In general, the SC Series provides excellent initial and final bonding strength. Optimum adhesion will be achieved when bonding REMA TIP TOP products with CN bonding layer. The adhesives have a user-friendly long open time and are easy-to-process even at low temperatures.

SC Series Cements are ideal for conveyor belt splices and repairs. SC Series bonding system provide a superior dynamic loading capacity. To achieve optimum results we recommend the use of appropriate REMA TIP TOP primers and cleaning fluids.

#### Properties

- Outstanding initial bond strength
- High dynamic load rating
- High-strength bonds
- Can be universally used on many materials
- Future-proof, REACH compliance
- Excellent adhesion
- Proven product quality
- Easy to apply
- Brand quality from REMA TIP TOP
- Economic in consumption
- Complements REMA TIP TOP wear protection and repair systems with CN bonding layer
- Good resistance to water, acids and alkalis

#### Area of application

- Cold splicing and repairs of conveyor belts with fabric reinforcements
- Bonding of rubber components and linings
- Bonding of elastomer laggings for drive pulleys



### CEMENT SC 2000

#### Properties

- Non-flammable
- High initial adhesion strength
- Excellent contact adhesion
- Available in three colors (green, black and white)
- Long shelf life (4 years if stored according to DIN 7716)
- Processed with Hardener UT-R 20
- Underground approval
- Pot life of 2 hours

#### SC 2000 Black

U.S. Part Number	Product Number	Size
101 000 041	SC2000B	Pint / 1/2 kg
101 000 042	SC2000B 1KG	Quart / 1 kg
101 000 043	SC2000BG	Gallon / 5 kg
101 000 053	SC2000B-DRUM	Drum / 290 kg

### CEMENT SC 4000

#### Properties

- Free of CFC and aromatics
- Excellent contact adhesion
- High initial bonding strength
- Available in three colors (green, black and white)
- Long shelf life (2 years if stored according to DIN 7716)
- Pot life of 2 hours.
- Processed with E-40 Hardener

#### SC 4000 Black

U.S. Part Number	Product Number	Size
101 000 045	SC4000B-PINT	Pint / 0.33 kg
101 000 046	SC4000-QT	Quart / 660 g
101 000 047	SC4000-GAL	Gallon / 3.3 kg
101 000 052	SC4000-DRUM	Drum / 190 kg

Adhesive - System	SC 2000	SC 4000
Coating	Consumption	Consumption
On metal or onto CN - layer	37 g/ft <sup>2</sup>	18 g/ft <sup>2</sup>
Onto roughened or unvulcanized rubber	46 g/ft <sup>2</sup>	27 g/ft <sup>2</sup>
Onto fabric	70 g/ft <sup>2</sup>	37 g/ft <sup>2</sup>
Onto primer coated metal	37 g/ft <sup>2</sup>	18 g/ft <sup>2</sup>
	<b>PR 200</b>	<b>PR 200</b>
Sand blasted metal	8 g/ft <sup>2</sup>	8 g/ft <sup>2</sup>

Adhesive - System	SC 2000 / UT-R20	SC 4000 / E-40
Coating	Number of coats	Number of coats
Onto metal , roughened rubber and fabric	2	2
Onto CN – bonding layer and unvulcanized rubber	1	1
Contact Bonding Time	Drying time	Drying time
Coat	Min. 30 Min (metal 1h)	Min. 30 Min (1h)
Coat	Slightly tacky	Slightly tacky



## REMA TIP TOP

### CEMENT SC Series - White

#### CEMENT SC Series - White

REMA TIP TOP's white SC Cements, when catalyzed with the appropriate amount of REMA TIP TOP Hardener provide all the advantages and strength of our SC Black Cements with the advantage of being food grade adhesives with FDA compliance.

Developed for use in splicing light and heavy duty industrial belting, White SC Cement is suitable for the repairs and endless splicing of chloroprene belts, bonding rubber to metal, fabric to fabric, and rubber to fabric. White SC Cement is also used for splicing fabric carcass belts and will bond a wide range of elastomers commonly used in the food processing industry. For example, SC Cement is used for bonding cleats to belting and pulley lagging to metal.

White SC Cement is also ideal for use in lining installations, when bonding rubber to rubber, rubber to fabric, rubber to steel, rubber to concrete, fiberglass, and urethane, as well as the splicing and repair of fabric conveyor belting. Repair to existing rubber lined vessels and rubber components are also recommended.

#### Properties

- Non-flammable
- Excellent contact adhesion
- Final strength after 24 hours
- Optimum adhesion with white REMA TIP TOP food grade rubber and CN Bonding Layer
- Ideal for rubber lining in the food processing, animal food and detergent industries
- Long shelf life (4 years if stored according to DIN 7716 - unmixed, 2 hours shelf life - mixed)
- Processed with UT-R 20 Hardener
- Applicable also at low temperatures

#### C 320 / SC 2000 WHITE CEMENT - Food Grade Cold Vulcanizing Adhesive

REMA TIP TOP's C 320 White Cement is a Food Grade Cold Vulcanizing Adhesive, and is FDA-compliant for repairing conveyor belts in splice repair applications, adhering pulley lagging, adhering and repairing sidewalls and cleats. 21 CFR 175.105. Based on TOR Exemptions 303, 306, 307.



#### Properties

- Non-flammable

#### C 320 (SC 2000 WHITE)

U.S. Part Number	Product Number	Size
101 000 031	C 320 1/2 KG	Pint / 1/2 kg
101 000 032	C 320 1KG	Quart / 1 kg
101 000 033	C 320G	Gallon / 5 kg
101 000 064	C 320-DRUM	Drum / 290 kg

#### CEMENT SC 4000 White

Food contact applications: CEMENT SC 4000 white with HARDENER E-40 has been tested and approved for food contact. The ingredients of CEMENT SC 4000 white meet the regulations of U.S. Food and Drug Administration (FDA, CFR 21§175.105). For HARDENER E-40 a TOR has been granted (CFR 21§170.39).



#### Properties

- CFC-free

#### SC 4000 White

U.S. Part Number	Product Number	Size
101 000 101	SC4000W-PINT	Pint / 0.33 kg
101 000 102	SC4000W-QT	Quart / 0.66 kg
101 000 103	SC4000W-GAL	Gallon / 3.3 kg
101 000 104	SC4000W-DRUM	Drum / 190 kg

# REMA TIP TOP

## CEMENT BC Series

### CEMENT BC series

REMA TIP TOP's BC Series Cements are specially developed for rubber lining large surface areas and applications where extended drying time is desirable. Under normal working temperatures, BC Series Cements have a pot life of up to six hours, and a tack time of six hours, which enables you to bond large surface areas without the risk of over drying.

BC Series Cements have excellent bonding properties and are perfect, in the fields of wear and corrosion protection, for applying rubber to rubber or rubber to metal over large surfaces, like large vessels, hoppers and tanks, lagging of large pulleys as well as on-site applications.

Optimum adhesion is achieved when bonding the REMA TIP TOP products with CN-Bonding layer.

#### Properties

- Long open time
- High dynamic load rating
- High-strength bonds
- Can be universally used on many materials
- Future-proof, REACH compliance
- Excellent adhesion
- Proven product quality
- Easy to apply
- Brand quality from REMA TIP TOP
- Economic in consumption
- Complements REMA TIP TOP wear and corrosion protection and repair systems with CN bonding layer
- Good resistance to water, acids and alkalis

#### Area of application

- Tank linings
- Lagging of large-size pulleys
- On-site rubber linings
- Large-area surface protection linings



### CEMENT BC 3004

Long open contact adhesion time - especially for large-area corrosion protection linings. Long curing time. Not suitable for repairing and splicing conveyor belts or for bonding that requires high initial adhesion strength.

#### CEMENT BC 3004

- Free of CFC and aromatics
- Long contact life (open time)
- Color: blue
- Long shelf life (2 years if stored according to DIN 7716)
- Processed with Hardener E 40
- Use SC 4000 as dry coat\*
- Pot life of 6 hours

#### BC 3004

U.S. Part Number	Product Number	Size
101 000 063	BC3004-GAL	Gallon / 3.3 kg
101 000 051	5254105	Drum / 190 kg.

Adhesive - System	BC 3004 / E40
Coating	Consumption
On metal or onto CN - layer	18 g/ft <sup>2</sup>
Onto roughened or unvulcanized rubber	27 g/ft <sup>2</sup>
Onto primer coated metal	18 g/ft <sup>2</sup>
	PR 400
Sand blasted metal	18 g/ft <sup>2</sup>

Adhesive - System	BC 3004 / E40
Coating	Number of coats
Onto metal , roughened rubber	2
Onto CN – bonding layer and unvulcanized rubber	1
Contact bonding time	Drying time
Coat	min. 1h
	max. 14 d
Coat	min. 20 mins
	max. 2 h

\*When using BC cements, REMA TIP TOP recommends that the initial dry coat of adhesive be of an SC Cement to decrease the amount of time needed for the coat to dry. Adhesion between the SC and BC Cements are excellent. The color difference in the two adhesives act as a indicator of coverage, ensuring proper application of the BC cement.

## CEMENT PC series

REMA TIP TOP's Plastic Cement PC-4 was specially developed for the durable splicing of PVC and PU conveyor belts and the repair and bonding of foils and sheets made of soft PVC and polyurethane.

Plastic Cement PC-4 offers superior adhesion for bondings and splices exposed to high dynamic load. The two-component bonding system provides a user-friendly open time with high initial and final adhesion strength.

### CEMENT PC 4

- Free of CFC and aromatics
- Good initial and final adhesion strength
- Color: transparent
- Long shelf life (2 years if stored according to DIN 7716)
- Processed with Hardener E 40
- Pot life of 2 hours

#### Properties

- Long open time
- High dynamic load rating
- High-strength bonds
- Future-proof, REACH compliance
- Excellent adhesion
- Proven product quality
- Easy to apply
- Brand quality from REMA TIP TOP
- Economic in consumption

#### Area of application

- Cold splicing and repairs of PVC conveyor belts
- Repair of soft PVC items
- Bonding of polyurethane materials

#### CEMENT PC 4

U.S. Part Number	Product Number	Size
101 000 094	PC4-PINT	Pint / 320 g
101 000 099	PC4-QT	Quart / 640 g
101 000 095	PC4-GAL	Gallon / 3.2 kg.



Adhesive - System	Plastic Cement PC4 E-40
Coating	Consumption
Onto roughend PVC, PVG or PU	46g/ft <sup>2</sup>
Onto fabric	68g/ft <sup>2</sup>

Adhesive - System	Plastic Cement PC4 E-40
Coating	Number of coats
Onto PVC, PVG or PU	2
Onto openmeshed, absorbent fabric	3
Contact bonding time	Drying time
Coat	min. 1h
Coat	max. 14 d
	Slightly tacky

## SOLUTION NRX-MOD

SOLUTION NRX-MOD is a two-component solution, which can improve the strength of rubber-to-rubber bonding. NRX-MOD modifies the surface of many rubber mixtures, which have a high natural rubber content and that way improves their bonding ability.

Can be used with SC 2000 or SC 4000 Cements.

#### Properties

- Reliable adhesion to natural rubber
- No mistakes when mixing (dosed components)
- Easy to apply (1 coat)
- Long shelf life (2 years)
- Brand quality from REMA TIP TOP
- Economic in consumption
- Activated with hardener

#### Area of application

- Seam bonding of rubber components
- Bonding of buffed
- REMALINE 25
- REMALINE 35
- REMALINE 40 orange
- REMALINE 40 black
- REMALINE 40 HR
- REMALINE 40 WHITE FOOD



## REMA TIP TOP

### METAL PRIMERS / CLEANING FLUID

#### METAL PRIMER

REMA TIP TOP Metal Primers are used to promote adhesion strength and temperature stability of elastomer-metal bonds with high dynamic and static loads. They help ensure a complete and longlasting bond between rubber and metal.

Primers and adhesives that are designed to work together produce a bond with superior adhesions. These one-component, quick drying metal primers can be used on a wide range of metal surfaces.

Aside from excellent adhesion of rubber-metal, the primers offer additional temporary corrosion protection for the prepared steel surfaces with low consumption of materials and easy application.

##### Properties

- Future-proof, REACH compliance
- Economic in consumption
- Excellent adhesion in combination with REMA TIP TOP Cements
- Short drying time
- Additional temporary protection for atmospheric corrosion (humidity)

##### Area of application

- METAL PRIMER are used to pretreat metal surfaces of elastomer-metal bonds prior to rubber-metal bonding with high dynamic and static loads



#### METAL PRIMER PR 200

- CFC-free
- Short drying time
- Temporary corrosion protection for metal surfaces after pre-treatment and prior to rubber lining.

##### PR 200 READI FAST METAL PRIMER

Product Number	Size
PR200-QT	Quart / 32 fl. oz.
PR200-GAL	Gallon / 1 US gal

#### METAL PRIMER PR 304

- Free of CFC and aromatics
- Good resistance against atmospherical influences such as humidity
- Temporary corrosion protection for metal surfaces after pre-treatment and prior to rubber lining
- Color: RED
- Color differentiation allows for visual indication of coverage in subsequent coats

##### PR 304 READI FAST METAL PRIMER

Available on special order.



#### CLEANING FLUID

REMA TIP TOP cleaning fluid provide clean surfaces (free of dust, oil and grease) for all kinds of bondings or coatings. It has proven highly effective for cleaning metal surfaces subsequent to blasting or grinding.

##### Properties

- Excellent oil and grease-dissolving
- Economic in consumption

##### Area of application

- REMA TIP TOP cleaning fluids can be universally used to remove oil and grease from surfaces and to clean used brushes (i.e. CFC-free adhesive systems, primers, vulcanizing and heating solutions)

#### #13 CLEANING SOLVENT (Non-Flammable)

##### Properties

- Non-Flammable

##### 13 REMA SOLVENT

U.S. Part Number	Product Number	Size
101 000 059	13-QT	Quart / 32 fl. oz.
101 000 060	13-G	Gallon / 1 US gal.
101 000 058	13-DRUM	Drum / 54 U.S. gal.

#### R-50 CLEANING SOLVENT (Flammable)

##### Properties

- Flammable

##### R-50 CLEANING SOLVENT

U.S. Part Number	Product Number	Size
101 000 061	R-50-QT	Quart / 32 fl. oz.
101 000 062	R-50-GAL	Gallon / 1 gal.
101 000 050	R-50-DRUM	Drum / 54 US gal.

Add: \* REMA TIP TOP recommends using PR 200 with a dry coat of SC 4000 when using BC 3004.

## REMA TIP TOP Product & Solutions

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### CONVEYING SOLUTIONS

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#### Pulley Lagging

- PERFORMANCE GRIP 70
- REMAGRIP
- REMAGRIP Ceramic Lagging
- UNIGRIP
- UNILAG
- T-REX

#### Belt Cleaners

- REMACLEAN - T-Bar Scrapers
- REMACLEAN - Green Combi
- REMACLEAN - Grey Combi
- REMACLEAN - Cleaning Brush

#### Skirting

- REMASKIRT
- Combi-Skirt
- T-REX
- UNISKIRT

#### Repair Products

- Repair Patches
- Repair Strips
- REMA GOO
- RG 7000
- T2 Repair System

#### Other

- Conveyor Belting
- REMACLEAT
- Edge Wall
- Impact Slider Bed Bars
- REMAMILL
- REMASCREEN

#### Rollers & Pulleys

- REMASLEEVE
- REMAROLL
- REMATRACK

### WEAR & CORROSION PROTECTION

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#### Wear Protection Lining

- REMA Performance Line
- REMALINE
- REMASTAR
- UNILINE
- REMATHAN
- T-REX

#### Rubber Linings

- CHEMOLINE
- CHEMONIT

#### Heavy Wear Protection

- REMALOX
- REMALOX HD
- KG Bars
- ZP Profile Bars
- REMA WEAR Repair

#### Anticaking

- REMAFLOX
- REMALEN
- REMASLIDE

#### Corrosion Coatings & Linings

- COROFLAKE
- COROGARD
- COROFLOOR
- TOPLINE
- RCC LININGS
- COROFLEX

#### Material Handling Hose

- Fixed Flange
- Split or Swivel Flange
- Cut End Hose

### ADHESIVES & SOLUTIONS

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#### Cements & Adhesives

- SC 2000 Black / White
- SC 4000 Black / White
- BC 3004 Blue Cement
- PC-4 Plastic Cement

#### Solutions

- PR 200 Metal Primer
- #13 Cleaning Solvent
- R-50 Cleaning Solvent
- TIP TOP Hand Cleaner
- A&B Vulc Compound

#### Splice Kits

- Hot Splice Kits
- MSHA Splice Kits
- WK Press and Splice Material
- Filler Rubber
- CN Bonding Rubber

### TOOLS & REPAIR

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#### Tools

- Rubber Cut Saw
- Extruder Gun
- Vulcanizing Presses
- Combi Stripper
- Grooving Tool

#### Other

- REMAWRAP Pipe Repair
- OTR Tire Patches



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REMA TIP TOP/North America, Inc.  
1500 Industrial Blvd.  
Madison, GA 30650  
Phone: 800.334.REMA (7362)  
706.752.4000  
Fax: 706.752.4015  
[www.rematiptop.com](http://www.rematiptop.com)