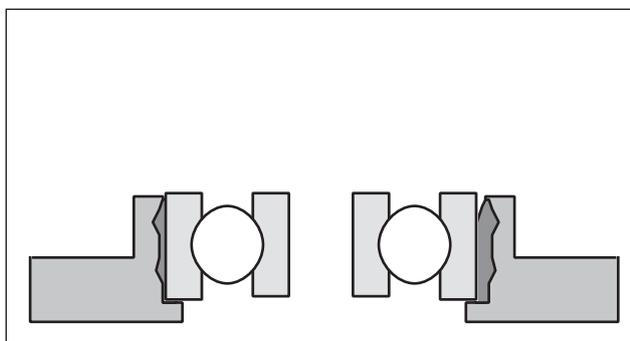
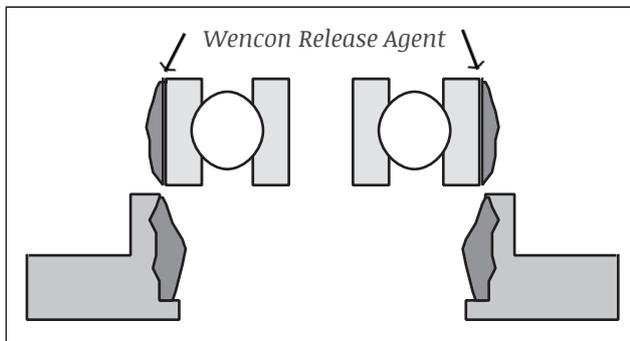
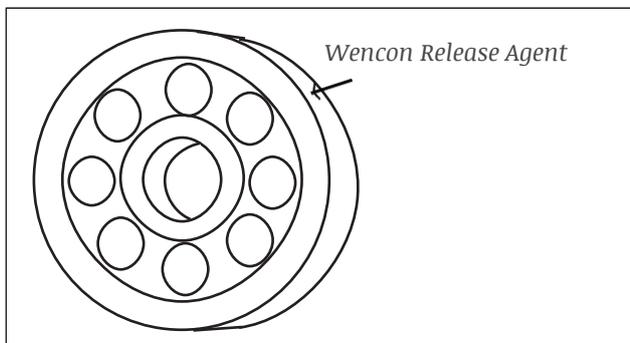
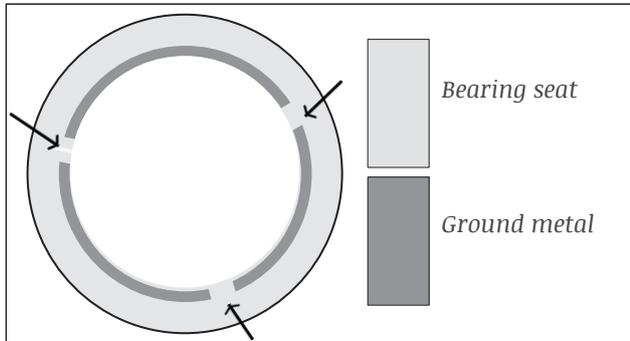


## Bearing seat - oversized



1. Remove the old bearing. Degrease the bearing seat acc. to Wencon surface preparation. Mark out three locations (note the arrows) which must not be grinded. The purpose of these marks is to ensure good centering. Grind between these locations approx. 0.5-1,0 mm (0,02- 0,04 inch) into the metal. Clean again acc. to Wencon surface preparation, next page.

2. Apply a thin layer of Wencon Release Agent to the new bearing. Allow to dry for approx. five minutes, then wipe clean until only a film is left.

3. Mix and apply an adequate layer of Wencon Cream or Rapid to both the bearing seat and the bearing itself.

4. Position the bearing correctly in the seat and allow curing. Please refer also to directions for use.

The repaired bearing seat has a compressive strength 7-12 times higher than normally required.

### Variations:

Seats for bushings are repaired in the same way.

This type of work can also be carried out in a turning lathe. All Wencon products are fully machinable after curing.

In some cases it may be an advantage to use a purpose made mandrel to do the casting.

## Wencon surface preparation

Choose the relevant surface preparation, depending on the nature of the job.

Surface preparation using dry blasting methods:

Application with Wencon products on a dry surface, at minimum 3°C. above dew point.

1. Blast the machine part to SA 2,5 using sharp-edged blasting media, to a roughness of min. 75 microns.
2. Leave the part for sweating out salts in a warm place for at least 12 hours or heat it up to 30 - 40°C (86-104 °F) using gas torches.
3. Blast again to SA 2,5, prior to the application.
4. For parts containing a lot of water and salt, it may be necessary to repeat point 2 and 3, until the surface remains light grey, for at least 2 hours after blasting.
5. For optimal adhesion of Wencon products, always use Wencon Bio Cleaner or Wencon Cleaner prior to application. Follow one of below two methods:
  - 5.1 **Wencon Bio Cleaner**  
**Wet surface:** Apply Wencon Bio Cleaner and let it work for 5-10 min. If necessary use a brush, to make sure the surface is clean. Rinse off with clean water and wipe off with an absorbing cloth. Apply Wencon UW Coating as a primer, and hereafter any Wencon products can be applied.  
  
**Dry surface:** Apply Wencon Bio Cleaner and let it work for 5-10 min. If necessary use a brush, to make sure the surface is clean. Rinse off with clean water and dry with an absorbing cloth or with compressed air for a completely dry surface. Hereafter any Wencon products can be applied.
  - 5.2 **Wencon Cleaner**  
After surface preparation, apply Wencon Cleaner with a brush and allow the product to evaporate before applying other Wencon products. Wencon Cleaner is non-flammable. Use only in large or well ventilated rooms.

Surface preparation using wet/damp methods:

Water jet the entire surface with water and sand to a standard equal, to SA 2,5 as described above.

If the surface is left wet after surface preparation, is it important to dry out the surface or alternatively use a Wencon UW product as a primer.

Surface preparation for emergency/temporary applications:

If above surface preparation methods are not possible, it may be necessary to use one of below methods:

- Blasting
- Grinding
- Needle Gunning

In emergency / temporary applications it may be difficult to prepare the surface according to above methods. In any case, it is important to clean the surface to SA 2,5 and 75 microns roughness. If possible dry the surface before applying. If not possible, use Wencon UW products prior to applying any other Wencon products.

For further information on Wencon surface preparation, please contact our Area Sales Managers.