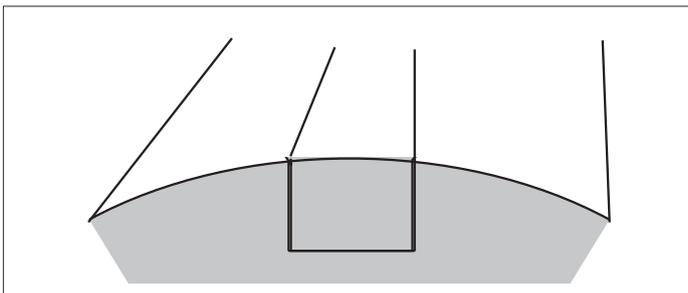
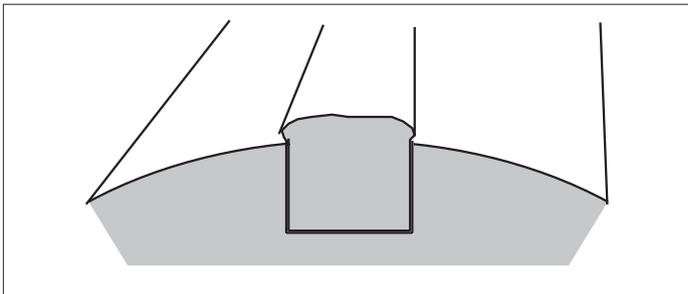
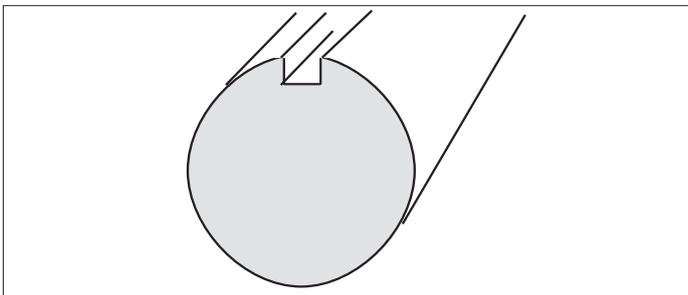
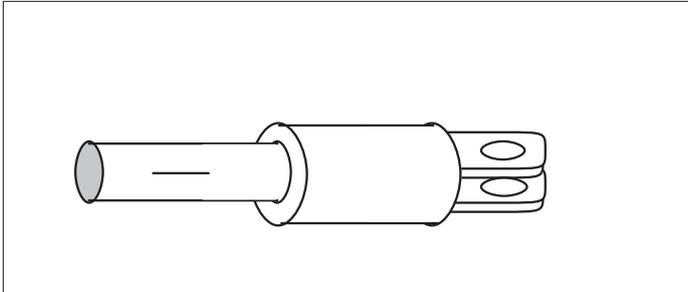


Hydraulic rams - repair of scores



1. Clean the ram thoroughly acc. to Wencon surface preparation, next page.
2. Grind the score down with a wheel grinder, until the grinding score is more or less as wide as it is deep. Clean again thoroughly acc. to Wencon surface preparation next page. To aid cleaning, the ram can be heated, but only to approx. 40° C using hot air or oxygen/gas.
3. Mix and apply an adequate amount of Wencon Cream or Rapid (see diagram). Allow the Wencon to semi harden and cut off the superfluous material with a sharp knife. Allow the Wencon to harden completely and then grind the surface clean with a fine grained emery cloth.
4. To have a grinding tool in the right shape, you can use a hardened brick of Wencon Putty to hold the emery cloth. Apply a thin layer of Wencon Release Agent to a not damaged area of the ram. Mix and apply some Wencon Putty on the ram where you have applied the Release Agent, and let it cure. After it is cured you can break it of and use it as a tool to hold the emery cloth.

Variations:

The damage can also be due to a blow, or can be sore arising from contact with electric cables.

If the damage is a result of normal wear and tear and covers a large area, the repair described above is not particularly suitable. In such cases machining must be recommended after Wencon material has cured. In special cases it is an advantage to turn a mandrel, especially if the ram has a large diameter.

Alternative products: Wencon Ceramic Cream

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.