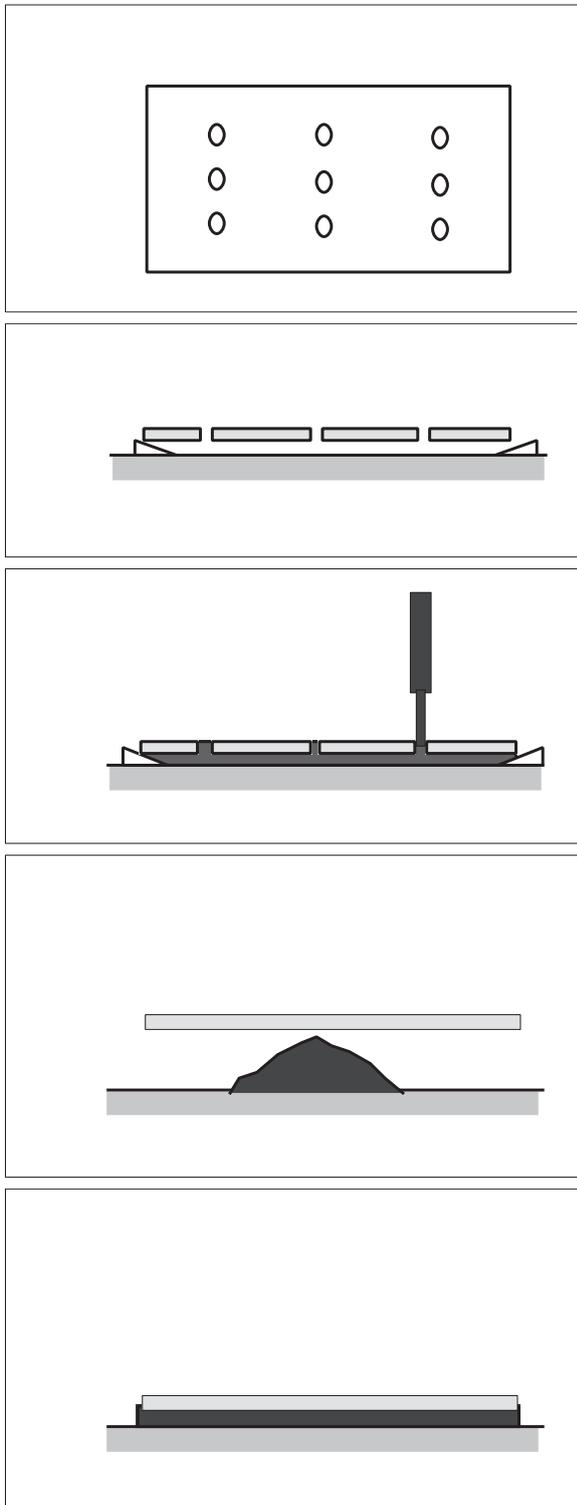


Doubler plates on deck - fixation



Often, it is not possible to fix a doubler by welding. For instance on a tank top.

Below find two methods for the application.

Method 1

1. Drill holes in the doubler 6-8 mm (0,24-0,32 inch) \varnothing for injection. Make one hole for every 400 cmsq. Grind or shot blast the mating surfaces acc. to Wencon surface preparation, next page.
2. Place the doubler on 4 wedges in the desired height min. 3-4 mm (0,12-0,16 inch).
3. Wencon Cream or Coating is mixed, filled into empty cartridges and injected through the holes. Begin in the middle area and work your way out. Make sure the gap being totally filled. After curing (see instructions leaflet) the job is finished.

Method 2

4. The job can be done avoiding the drilled holes. Mix and apply Wencon Cream or Rapid as shown in fig. 4. Make sure, that there is enough material to be squeezed out from the gap during the mounting.
5. Mount the doubler in the wet material and make sure, that excess material is being squeezed out all way round the plate to be sure of total fixation. It may be advantageous to apply a very thin layer of Wencon on both mating surfaces initially. Let it cure before loading.

Method 2 is the fastest, but has limitations with regards to the size of the doubler. If method 2 is used on very irregular surface, it is recommended, that Wencon Cream or Rapid should be used to create an even surface before the mounting. The larger doublers the more difficult it will be to press the plate in position.

Apply vibration by the means of a pneumatic hammer or the like on the top.

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.