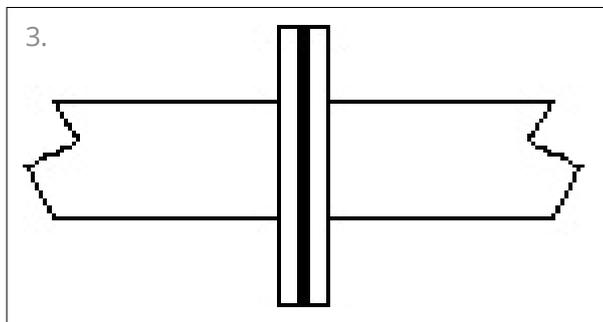
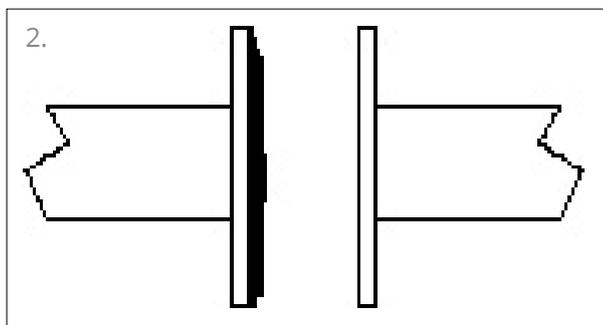
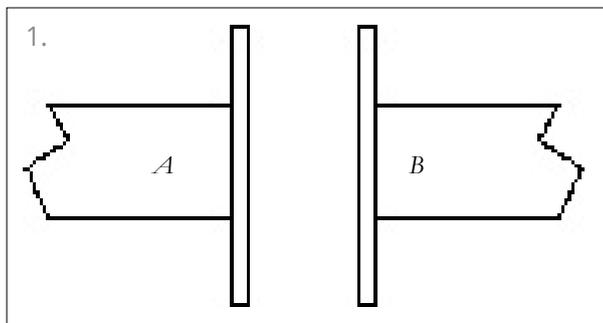


Flange faces, bushings etc. - hard seal

APPLICATION DATA SHEET No. 133



Wencon offers a very easy, quick and long lasting technique for restoring and creating mating surfaces on i.e. flange faces, bushing seats, conical couplings of shafts and/or pipes, condensers, heat exchangers, bearing seats, etc.

Suitable products:

Wencon Cream: cures in 10-15 hrs.

Wencon Rapid: cures in 90 min.

Wencon Ceramic Cream: High strength

Wencon UW Cream: Can be applied in wet

Follow below procedure:

1. Clean flange A using a wheel grinder and the Wencon Bio Cleaner. Clean flange B using only Wencon Bio Cleaner. See Wencon surface preparation, next page.
2. Apply a thin film of Wencon Release Agent on flange B, and let it dry for ten minutes. Mix and apply a suitable amount of the product on flange A.
3. Put together the two flanges, and thereby squeeze out surplus material. After curing, which can be accelerated considerably with heat, the application is finished.

Read the Wencon Instructions for use before application.

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.

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.

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.

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