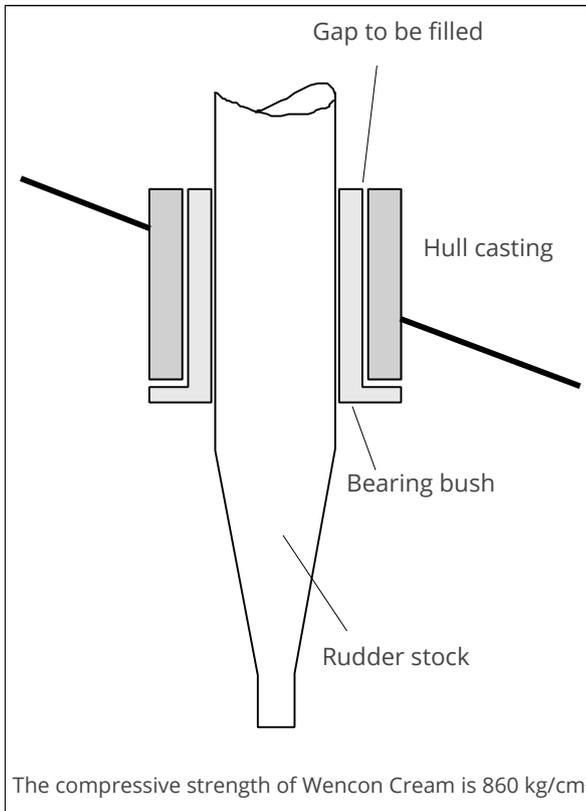


Rudder stock bearing - casting of seat

APPLICATION DATA SHEET No. 110



Before making this type of application, it is highly recommended to contact the local Wencon supplier and the classification society in charge.

Below is an example, how the majority of this type of application is done.

1. Grit blast the seat for the bearing to SA 2,5. During winter time apply heat.
2. Machine the bushing leaving min. 3 mm (0,12 inch) space to be filled. If the bushing is mounted as shown on the figure, apply Wencon Release Agent to the surface of the bushing. If no bolts are being used to secure the bushing, do not use release agent.
3. Drill injection holes in the hull casting. Four holes in the bottom approx. 30 mm (1,2 inch) from the bottom (spread around the circle), four holes in the middle, and two or four venting holes in the top.
4. Mount the bushing. The shown type can be mounted without use of the stock. Other types can be mounted by help of the rudder stock.
5. Make sure, that the gap is filled in the bottom to prevent injected material to get out. Use Wencon Rapid.
6. The appropriate amount of Wencon Cream or Coating is mixed and injected using compressed air cartridges in a sealant gun. Fill from the bottom and continue until material gets out of the venting holes in the top. Mount a self cutting screw in the holes when not using them anymore.
7. Curing. If the temperature is low, apply heat to the heel 30-40°C (86-104°F). Do not apply heat to the bearing. After approx. 8 hours at min. 20°C (68°F) the work can proceed.

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.