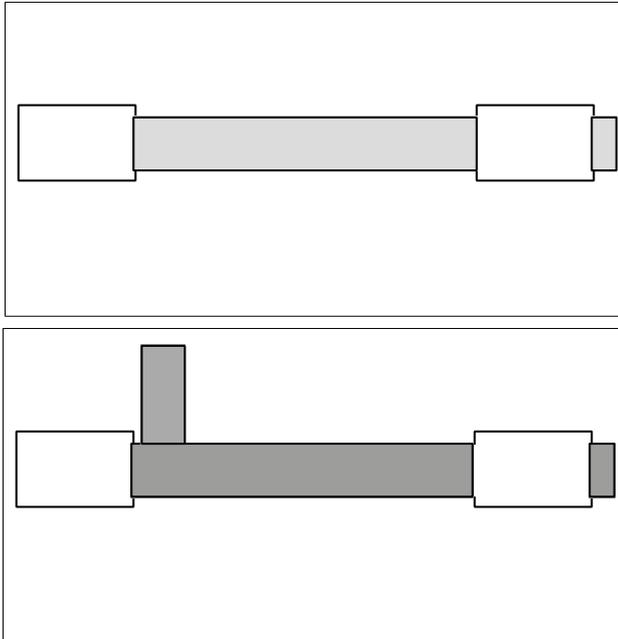


Rudder tail shaft / stock - coating

APPLICATION DATA SHEET No. 139



For new parts, leave out point 3. For corroded parts, start at point 1.

If the shaft has been exposed to salt water or oil, heat the shaft to 30-40° C (102-136°F), prior to grit blasting, in order to sweat out salt and oil.

1. Grind or grit blast the surface acc. to Wencon surface preparation, next page.
2. Mix and apply a suitable amount of Wencon Rapid to fill out the pits. Let it cure to a degree, where the surface is still a bit tacky.
3. Mix and apply the first layer of Wencon Coating, white in a thickness of 300 μ (0,3 mm) Use a flat angled brush having cut off half of the length of the bristles.
4. Wrap a layer of Wencon Reinforcement Tape tight around the shaft with an overlap of approx. 2 cm. Make sure, that some of the coating is pressed through the tape during the wrapping.
5. Leave it for curing for approx. one hour, and apply a layer of Wencon Coating, blue on the top to finish the application. Let it cure.

Handle the shaft carefully, in order not to damage the coating.

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.