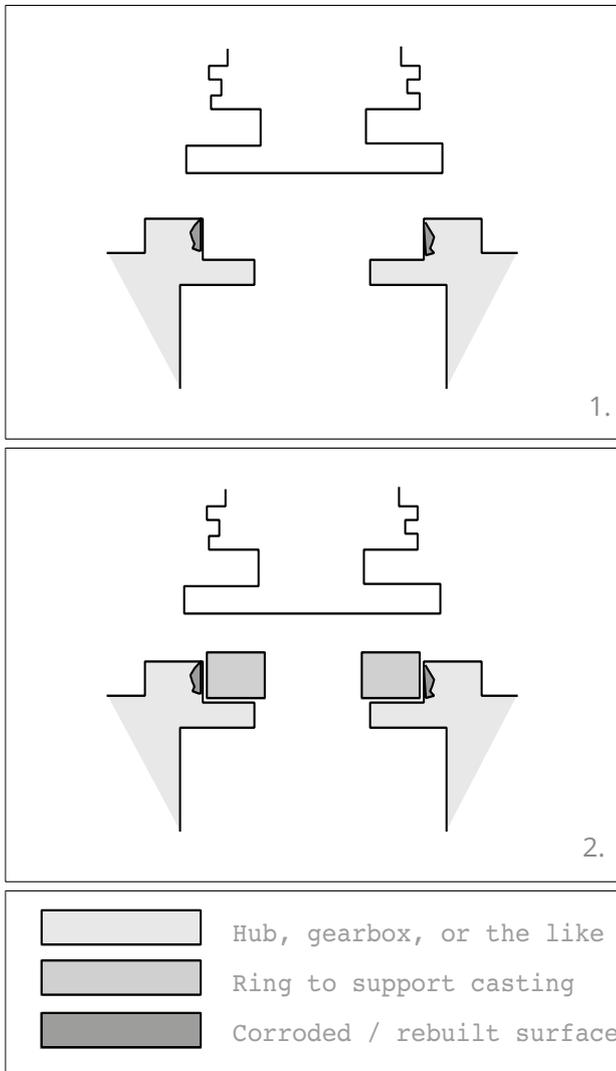


Sealing ring seats - corrosion

APPLICATION DATA SHEET No. 141



Corroded sealing ring seats in a gear box or in the hub in propeller head, etc., may suffer from either bimetallic corrosion or erosion/corrosion due to leakage and fluid flow.

This is a temporary repair solution to the seal in the gearbox. It is not advised to have direct contact between the Wencon material and metal, if there is high friction due to the high rotation.

But in this case, the Wencon material will be in contact with the seal and is therefore ideal.

Method 1: build and grind to fit

1. Grind the repair area acc. to Wencon surface preparation, next page.
2. Mix and apply a suitable layer of Wencon Ceramic Cream
3. After curing, grind or machine the surfaces to the required shape.

Method 2 : Cast to fit

To avoid grinding or machining, make a ring in the correct dimensions and use it to support the casting during the curing.

1. Grind the attacked surface acc. to Wencon surface preparation, next page.
2. Mix and apply a suitable layer of Wencon Ceramic Cream and fill it into the space between the casting ring and the surface of the hub.

If the ring is made of metal, apply a thin film of Wencon Release Agent before casting.

If the ring is made of PE plastic or the like, release Agent is not needed.

The application will be finished after the product is cured and the rings is removed.

Alternative products: Wencon Cream or Wencon Rapid.

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.