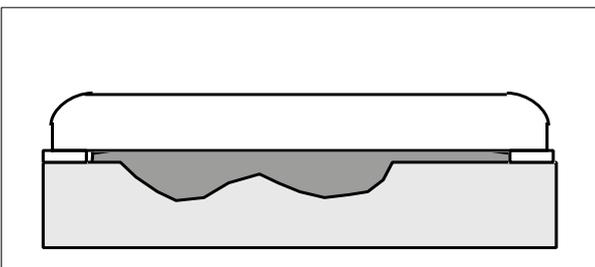
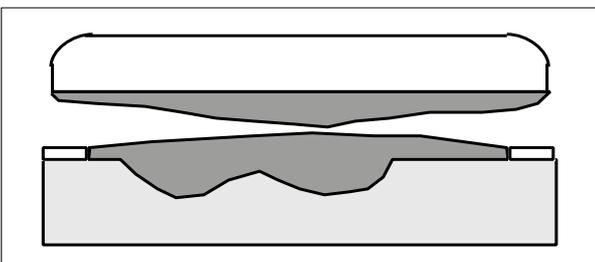
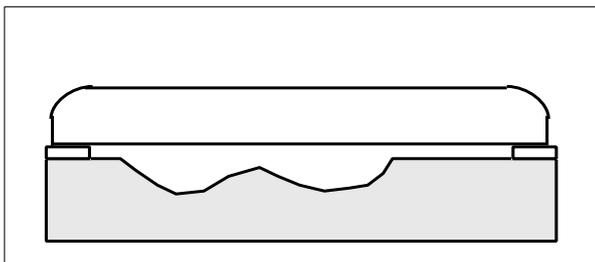
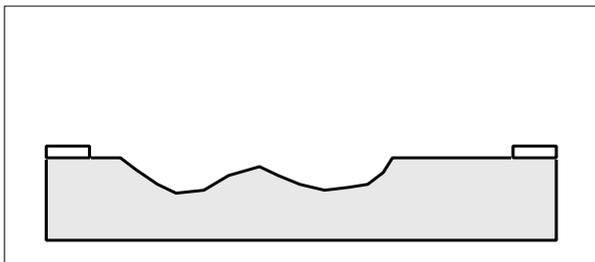
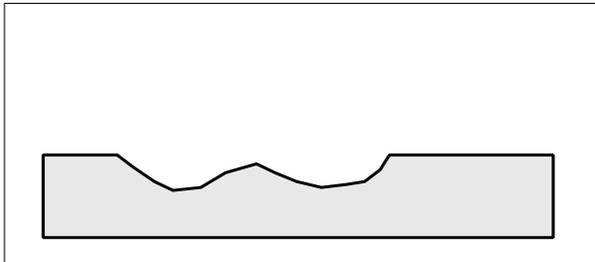


Wear plates - casting support

APPLICATION DATA SHEET No. 119



It is often the case that wear plates are replaced too late. This results in excessive wear of the surface of the seat for the plate. Welding and machining of this surface can be expensive. By using the Wencon application, these surfaces can easily be built up to exact alignment with the wear plate. In many cases it is even possible to avoid the necessity of machining the rear side of the wear plates.

1. Clean the worn surface acc. to Wencon surface preparation, next page.
2. On each seat, fix four small iron shims to guide the wear plate during the casting. They must ensure a minimum casting height of 2 mm (0,08 inch), and must be removed after casting.
3. Before casting, check the plate for correct positioning. Then apply a film of Wencon Release Agent to the rear of the plate, to prevent adhesion between the plate and Wencon. Allow the release agent to dry for at least 5 minutes.
4. Clean the worn surface with Wencon Bio Cleaner. Mix an adequate amount of Wencon Cream. Build up a layer, as shown in the diagram, on both the seat and the plate. Allow some 30% of the Wencon to be squeezed out when fitting in order to ensure a complete support.
5. Press down the plate on to the shims, either by means of the bolts that holds the plates or by means of a jack. Thereafter remove the excess Wencon material and the job is finished. Curing time depends on temperature. At 20°C (68°F) Sit will be about 10-15 hours. Curing time can be shortened at higher temperatures. After curing, remove the shims, and re tighten the plates to the required tension.

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.