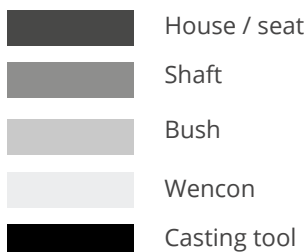
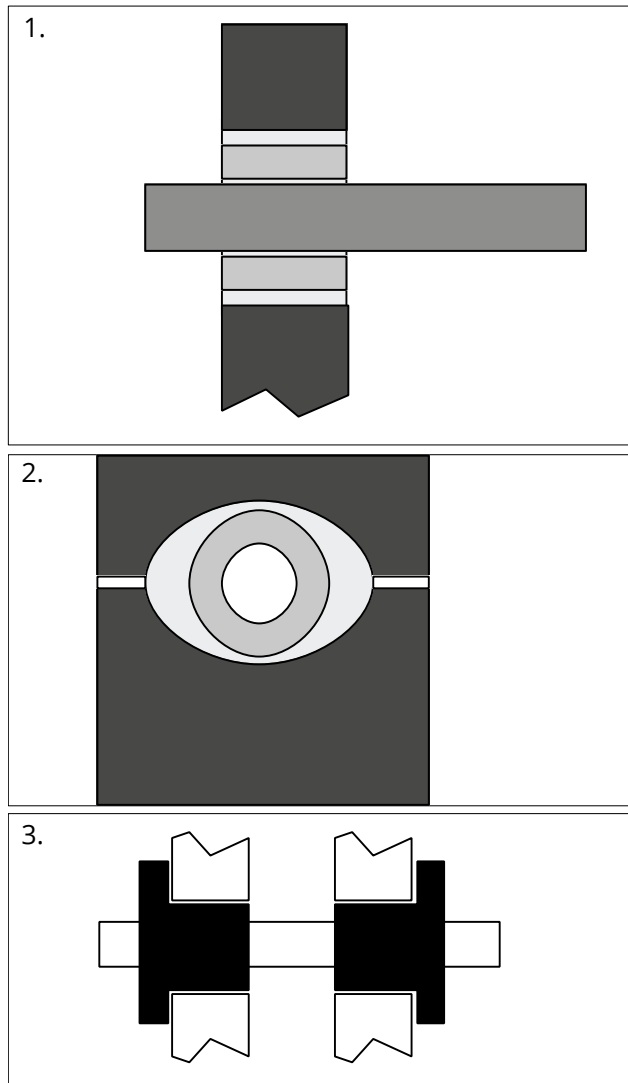


Bushing seats - casting

APPLICATION DATA SHEET No. 140



Casting of seats for bushings, bearings, etc. provide some advantages, compared to more conventional techniques.

1. Remove the old bushing or bearing. Grind and prepare the surface acc. to Wencon surface preparation, next page.

To secure easy disassembly, apply a thin film of Wencon Release Agent on the bushing or bearing.

Basically, there are two different ways of making the application, injecting the material after having mounted the bushing or by applying the material before the bushing is mounted.

2. & 3. Drill holes in the bushing seat as shown in ill. 3. Mount the bushing and hold it in position (typically by inserting the shaft).

Mix a suitable amount of Wencon Cream or Rapid and fill it into an empty cartridge for the injection gun (cartridges can be supplied by Wencon).

The gap between the seat and the bushing can easily be sealed with Wencon Putty. In some cases it is more convenient to drill the holes in the bushing.

If the bushing is not available, the seat can be cast using a casting tool, made to the right measures. See ill 3.

The technique is as described above. Less accurate is the technique, where you apply the Wencon Cream or Rapid to the surface of the bushing as well as into the seat.

Hereafter the bushing is inserted and the centred with the shaft or a tool made for it.

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.