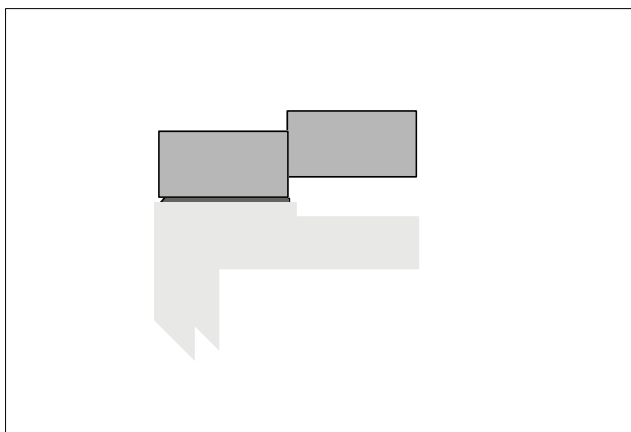
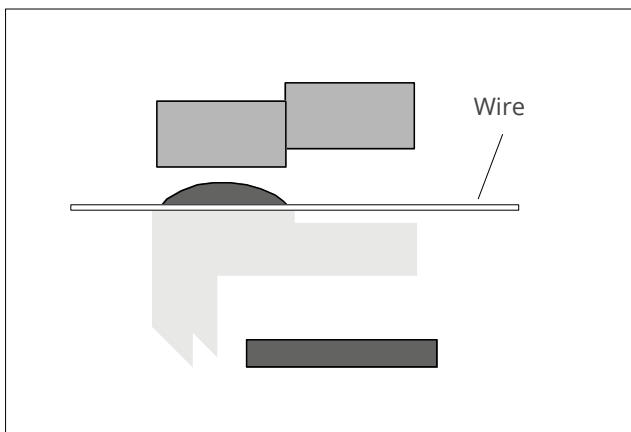
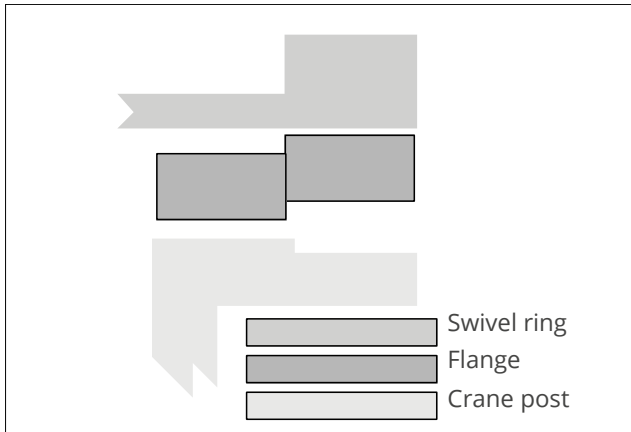


## Crane, swivel ring - casting support

APPLICATION DATA SHEET No. 130



Prior to starting up the application, the compression of the swivel ring must be known.

The compressive tensile strength:  
 Wencon Rapid 58 N/mm sq. (Rcrack)  
 Wencon Cream 112 N/mm sq. (Rcrack)

1. Lift the swivel ring to enable surface preparation of the flange top. Grit blast and Clean the flange top using Wencon Cleaner.
2. Apply Wencon Release Agent to the bottom surfaces of the swivel ring. Allow to dry for 5-10 min., and remove excess release agent and thread the bolts.
3. Mix and apply a suitable amount of Wencon Cream. The final layer must be min. 2-3 mm (0,08-0,12 inch). To avoid air entrapment, apply thickest on the middle. For every 20 cm, place a 2 mm (0,08 inch) metal wire (welding electro de) across the flange to create an even casting.
4. Place the ring in position, and empty the bolt holes for Wencon material. Mount the bolts, but do not tighten them.
5. After curing, loosen the bolts, and take away the wire.

The job is done, and you can mount the swivel ring. If you have got air entrapment, these can be repaired easily, by grinding the dent, and fill it with Wencon Cream, let it cure and grind away excess material.

## 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.