

PRELIMINARY ACTIVITIES

In case the lining has been in contact with chemicals, a careful cleaning is required in order to remove them completely.

This procedure must be performed with particular care. Otherwise, a not correct cleaning could compromise the adhesion of the repair.

Prior to lining repair the substrate must be checked and , in necessary, repaired.

In case a welding is required, pay attention to remove, by grinding, the existing lining for a distance of approx 150 mm for the weld area.

This is important in order to avoid burning of the lining.

Substrate preparation

Remove, by grinding, damaged lining up to the metal or bonded lining.

For better adhesion of mastic, smooth edges at the periphery of repair surface preparing chamfer. Clean and degrease carefully the surfaces where mastic is to be applied.

Mastic preparation

Choose the type of mastic to be used in relation to the hard rubber lining to be repaired:

- "NEW PIN-UP®" mastic for standard hard rubber linings
- "NEW PIN-UP®" graphited" mastic for graphited hard rubber lining

Prepare the quantity of mastic necessary for the repair mixing carefully, on a clean surface, 4 parts of component "A" and 1 part of component "B".

Perform the mixing by a spatula.

The mastic tends to solidificate at a temperature below 10° C with no deterioration of its properties.

Before use bring mastic cans into a warm ambient so that its temperature can reach 20°-25° C. When ambient conditions are particularly cold, it is possible to help proper mixing by slightly warming up during preparation.

Remark

While each component "A" e "B", separately, has a pot-life of 2 years (on the cans it is indicated the expiry date), the mixture of the two component "A" e "B" has a very short potlife, approx 30 minutes at the temperature of 20° / 25° C.

Therefore it is convenient to prepare an amount of mastic just enough for the repair, so avoiding wastage of material.

Mixtures even partially hardened are no more useful.

Keep mastic carefully sealed after use.

In case it is necessary to use the components beyond the date of expiration, verify the suitability, by mixing the two components and monitoring that after approx 7 / 8 hours the product is hardened. This allows to extend of 6 months the pot-life of the product.

APPLICATION

Apply the mixed mastic on the surface to be repaired by means of a spatula acting a slight pressure, in order to avoid air bubbles under the product and to improve the adhesion of repair material to the substrate.

When large or thick surfaces are to be repaired, it is advisable to apply the mastic in two layers (applying the second layer after hardening of the first one).

After the application, let mastic harden for at least 6 / 7 hours.

REMARK

During the application, the temperature of the part to be repaired has to be at least 18° C; this temperature has to be maintained until final catalization has been achieved.

In case a fast hardening is required, the applied compound can be locally warmed by a hot air blower. Cleaning of mastic not yet hardened on the tools can be performed by solvent.

FINISHING

If necessary mastic repair can be machined by means of grinding machine after hardening.

INSPECTION

Check result of repair by means of high-frequency spark tester, using the same tension of original lining.

Make sure that no discontinuities or porosities are present.

REMARK

If possible, equipment repaired should be kept out of service for at least 24 hours.