

PRODUCT INFORMATION

WERKSTOFF 839

PRODUCT DESCRIPTION

WERKSTOFF 839 is a black, conductive soft rubber lining based on NR/SBR/BR rubber with excellent wear properties.

FIELDS OF APPLICATION

Due to its excellent wear properties, **WERKSTOFF 839** is used for workshop rubber linings of drums loaded with chemicals and abrasion. Due to the good conductivity of the material, it can also be used in ATEX systems.

FEATURES

- Excellent resistance against wear
- Good chemical resistance
- Application onto steel components
- Workshop rubber lining
- Good electrical conductivity

CHEMICAL RESISTANCE

Information on the chemical resistance properties is available upon request.

SUBSTRATE

Substrates are components made of non-ferrous metals, cast iron, non-alloyed or austenitic steel. Components to be rubber lined shall be designed and manufactured in accordance with EN 14879-1.

SURFACE PRE-TREATMENT

All surfaces to be rubber lined must be dry and free of contaminants. All contaminants, including non-visible detectable contaminants, must be removed in accordance with DIN TR 55684 or EN ISO 8502.

Non-alloyed steel surfaces shall be abrasive blasted to "Near White Metal" in accordance with EN ISO 12944-4. A surface preparation degree of SA 2½ (SSPC-SP 10; NACE No. 2) as specified in EN ISO 8501-1 and a "medium (G)" roughness degree as specified in EN ISO 8503-2 must be achieved. A minimum surface profile of $R_z \geq 50 \mu\text{m}$ is required.

To prevent flash rust, the primer must be applied immediately after the blasting and cleaning of the substrate or the component must be air conditioned to a relative humidity of $\leq 40\%$.

ENVIRONMENTAL CONDITIONS

Throughout the rubber lining process, the temperatures of the substrate and rubber lining materials shall be maintained within the range specified by TIP TOP. All surfaces shall be maintained at a temperature at least 3K above the dew point in order to prevent condensation.

ADHESIVE SYSTEM

WERKSTOFF 839 is bonded onto steel components by using the two-coat primer system **PRIMER PR 500-1** & **PRIMER S 500-2** in combination with **ADHESIVE REMACLAVE SOLUTION**.

APPLICATION METHOD AND CONSUMPTION

During the application of the product, the application instruction must always be observed.

Coat	Product	Application Method	Coverage [g/m ²]
1. Coat steel	PRIMER PR 500-1	Roll / Brush	ca. 150
2. Coat steel	PRIMER S 500-2	Brush	ca. 125
3. Coat steel	ADHESIVE REMACLAVE SOLUTION	Roll / Brush	ca. 100
4. Coat steel	ADHESIVE REMACLAVE SOLUTION	Brush	ca. 100
1. Coat rubber	ADHESIVE REMACLAVE SOLUTION	Brush	ca. 100

CLEANING

Clean all equipment with **SOLVENT CF-CE** immediately after use.

VULCANISATION

The details given in the application instruction must be observed during vulcanisation.

Place	Vulcanisation Method
Workshop	Vulcanisation in an autoclave under pressure by means hot air or steam.

SPARK TEST

Due to its electrostatic properties (electrical conductive), the rubber lining can not be tested on pores or cracks by means of high voltage test. The rubber lining is tested on pores and cracks by 100% visual inspection with optimal illumination.

SAFETY MEASURES

The material safety data sheets of the individual components, the safety instructions on the packing (label) as well as the legal requirements for handling hazardous materials must be observed.

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PACKING UNITS

The products are supplied in the following standard package sizes:

Product	Size	Article No.
ADHESIVE REMACLAVE SOLUTION	3.5 kg	538 1610
ADHESIVE REMACLAVE SOLUTION	7 kg	538 1620
ADHESIVE REMACLAVE SOLUTION	21 kg	538 1630
PRIMER PR 500-1	4.5 kg	525 2470
PRIMER PR 500-1	9 kg	525 2327
PRIMER PR 500-1	25 kg	525 2334
PRIMER S 500-2	9 kg	525 2341
PRIMER S 500-2	25 kg	525 2358
SOLVENT CF-CE	10 l	595 9163

STORAGE

The products must be stored in a cool and dry place, away from direct sunlight. The rubber sheets must be stored free of pressure, best in the original packaging. The rubber sheets may not receive any pressure points. At the specified storage temperatures a shelf life of the products is given of at least for the following periods:

Product	Temperature	Shelf Life
ADHESIVE REMACLAVE SOLUTION	5 - 20°C	12 Months
WERKSTOFF 839	≤ +25°C	3 Months
WERKSTOFF 839	≤ +5°C	6 Months
PRIMER PR 500-1	5 - 20°C	12 Months
PRIMER S 500-2	5 - 20°C	12 Months
SOLVENT CF-CE	5 - 25°C	60 Months

If the storage time is exceeded, the materials must be tested before use. Higher storage and transport temperatures will reduce the shelf life. The containers must be kept tightly closed. Liquid products must be stored frost-proof. In addition, the DIN 7716 must be observed.

Technical Data	Standard	Unit	Value
Polymer Base	ISO 1629 (ASTM D1418)	-	NR / SBR / BR
Abrasion	ISO 4649 (ASTM D5963)	mm ³	≤ 80
Density	EN ISO 1183-1 (ASTM D792)	g/cm ³	1.14 ± 0.02
Hardness - Shore A	ISO 48-4 (ASTM D2240)	-	65 ± 5*
Surface Resistance	EN 62631-3-1	Ω	≥ 1.2 x 10 ⁴
Elongation at Break **	DIN 53504 (ASTM D412)	%	≥ 470*
Tensile Strength **	DIN 53504 (ASTM D412)	N/mm ²	≥ 21*
Impact Resilience	DIN 53512	%	≥ 40
Peel Strength to Steel	ISO 813 (ASTM D429)	N/mm	≥ 4
Tear Strength	ISO 34-1, Method A (ASTM D624)	N/mm	20

* Press vulcanisation ** Determined on S2

Information given in the fact sheet above corresponds to the current knowledge available to us regarding our products at the time of its drafting and is intended as a guideline for informational purposes. However, because of the multiple possibilities regarding possible applications, processing and on site conditions, any information given in the fact sheet above is not legally binding, in particular, without being limited to, such information shall not be interpreted as a warranty of merchantability or of fitness for a particular purpose. Customer therefore is advised to conduct its own testing or make an inquiry with our technical department before ordering. We reserve the right to change the product at any time, in particular, without being limited to, minor changes because of advancements in technology. If by way of exception, the information given in the fact sheet above is incorporated by reference into any contract concluded with us under German Law, such information, shall only be interpreted as determining the specific requirements of the contractual products as set out in § 434 BGB (German Civil Code) and shall not be interpreted as constituting a guarantee of condition.

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