

DWH 311 P

Product number #0019

Product description

DWH 311 P is a low-viscosity two component adjustment coating designed for the coating of parting lines, mounting surfaces, infusion of bushes and undergrouting of guide rails. Due to the exact moulding technique expensive processing becomes unnecessary.

Characteristics

- Very high accuracy
- Very high compressive strength
- High resistance to cooling emulsions, mineral and synthetic lubrication and cutting materials

Chemical resistance

Please contact our technicians for questions about chemical resistance.

Package size

0,5 kg
1,0 kg
5,0 kg

DWH 311 P is supplied in ready-to-use pack sizes. The product consists of two components. Both components must be completely mixed with each other. In order to avoid mixing errors, a portioning of the components into smaller quantities is expressly discouraged.

Technical data

Technical data	Test procedure	Value
E-Modul [N/mm ²]	DIN EN 13412:2006	8600
Compressive strength [N/mm ²]	DIN EN 12190:1998	160
Viscosity [mPas]	DIN EN ISO 3219:1994	pasty
Density [g/cm ³]	-	1,6
Pot life (+20°C) [min]	DIN EN ISO 9514	50
Curing time (+20°C) [h]	-	24
Curing time until moulding (+20°C) [h]	-	18
Shore-D Hardness	DIN ES ISO 868	84
Shrinkage [%]	DIN EN 12617-4/2002	<0,1
Thermal resistance [°C] permanent temporary	-	-20°C to 80°C -40°C to 125°C
Mixing ratio (A:B) [gr]	-	92:8

Storage / Shelf life

Store in the original unopened container, dry, cool and frost-free (5 ° C - + 20 ° C). Shelf life 2 years. Protect from direct sunlight. Higher temperatures reduce the shelf life.

Important instructions

Please refer to the safety data sheet.

Technical data sheet

Preparation of the liability area

The to be coated guide surface is provided to improve the adhesion with a roughening. The roughness should be 0.5 mm (Rt - 500µm). The roughening can be made on a milling machine with a large-diameter knife head. Dirt, debris, grease and other substances should be completely removed from the bond area. For this we recommend the use of DIAMANT cleaner (# 1417).

Mixing process

For mixing DWH 311 P, component B is completely added to the container of component A. Mix thoroughly with a drilling machine and the DIAMANT mixing propeller (Prod.No. #0789) (max. 250 rpm for approx. 2 minutes). Strip material adhering to the wall of the container with a spatula and add to the mixture. Mix again thoroughly.

Application

Apply a thin layer of adhesive firmly to the primer with the spatula. Filling the remainder in a roof-shaped manner without enclosing air.

Venting

After mixing, immediately remove DWH 311 P from the container and thinly spread over a clean sheet. As a result of spreading, bubbled air bubbles are torn open. The spreading dissipates part of the heat of reaction and thus prolongs the processing time.

Disposal

Any material which is not used, mixed correctly and completely cured can be disposed normally (EAKV 170203). Not mixed material has to be disposed as chemical waste (EAKV 080111). If booked the DIAMANT service team will dispose the waste.

Qualification and service:

It is recommended that the application is performed by schooled DIAMANT technicians.

To guarantee the best possible quality and a correct application, we offer the following services:

- Consultation on the phone or/and in person on your construction site
- Construction site supervision and supervision of the work on site.
- Complete application performed by our experienced application technicians.

Further information can be found in the service data sheet.

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The listed technical data were determined under laboratory conditions and verified by quality assurance processes at the day of production. Changes are reserved and can be implemented without previous information. The customer is responsible for the verification of data topicality and should be requested before the material ordering at DIAMANT. Application, use and processing of the products happen outside of our control options and therefore lie entirely in the area of responsibility of the customer. Should nevertheless a liability come into question so is this liability limited to the value of the items delivered and used by you. We guarantee the perfect quality of our products according our general sale and delivery conditions. All technical data can differ depending on burden and operating conditions. Specific application data will be provided upon request in every individual case.