

DWH 311 FL

Product number #0787

Product description

DWH 311 FL 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 against cooling emulsions, mineral and synthetical lubricants and cutting materials

Chemical resistance

If any questions regarding the chemical resistance occur please contact our technicians.

Package sizes

0.5 kg
1.0 kg
5.0 kg

DWH 311 FL is delivered in ready to use package sizes. The product consists of two components. Both components have to be mixed with each other completely. We do not recommend using smaller portions of the product because it might lead to mixing errors.

Technical data

Technical data	Test procedure	Value
E-Modul [N/mm ²]	DIN EN 13412:2006	8500
Compressive strength [N/mm ²]	DIN EN 12190:1998	158
Viscosity [mPas]	DIN EN ISO 3219:1994	20.000 - 25.000
Density [g/cm ³]	-	1,55
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]	-	87:13

Storage/durability

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

Important notes

Please consider the information given in 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 knife head with a large feed.

Mixing

To mix DWH 311 FL component B has to be put into the container of component A completely. Mix intensely with a drilling machine and the DIAMANT mixing propeller(Prod.-Nb. #0789)(max. 250 U/min for ca. 2 Minutes). Any material which is left sticking to the sides of the container can be put into the mixture with the use of a spatula. Mix again thoroughly.

Processing description

DWH 311 FL has to be poured slowly and in a thin stream into a prepared, sealed cavity. To avoid enclosing air fill out the cavity beginning at the deepest point. Alternatively DWH 311 FL can be injected from the deepest point with a hand cartridge through a prepared inlet port.

Venting

DWH 311 FL has to be poured into a clean container in a thin, uninterrupted stream.

Application Description

Inject the DWH 311 FL with a hand-held cartridge through an inlet channel into the prepared, sealed cavity. To avoid the influence of air, fill the cavity from the lowest point.

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.

