

INSTRUCCIONES DE SUSTITUCIÓN DEL ALOJAMIENTO DEL BASTON



NOTA: Traslade la tapa a un área de trabajo segura fuera de la zona 2 y tape la boca de la arqueta abierta.

1 **Equipo de Seguridad**

Gafas de Protección

Guantes

Retire todas las piezas restantes de la carcasa de la llave original de la cubierta utilizando un martillo y un cincel.

3

x2

Con el papel de lija, lijar las superficies de contacto del alojamiento de la llave y el retén. Lijar también los huecos de la brida de la tapa.

2

Remove the original adhesive and thoroughly clean the cover flange recesses (top & bottom) and the key housing accommodation hole.

5

After mixing, ensure that the adhesive is used within the time shown below for 'Usable life'.

NOTE: The cure speed of 2 part epoxy resins is generally affected by the ambient temperature. A fall of 8°C will roughly double the cure time; a rise of 8°C will tend to halve it.

4

Mix the Resin (32A) and the Hardener (32B) components together in the correct ratio until a uniform Grey colour is achieved. This is the adhesive compound.

Typical Performance				
Cure Speed	Usable Life	Handling Strength	Working Strength	Full Strength
at 23°C	2 hours	8 hours	24 hours	72 hours

Resin Hardener Mixing Ratio		
Mix Ratio	(32A) Resin	(32B) Hardener
By Weight	5	4
By Volume	1	1

KEY HOUSING REPLACEMENT INSTRUCTIONS



6

Apply a continuous film of adhesive to the contact surfaces of the key housing. Insert the key housing into the cover, locating the key housing flange in the cover top flange recess.

7

Turn the cover over.

8

Apply a continuous film of adhesive to the contact surfaces of the retainer. Locate the retainer ring over the key housing. Push the retainer into position until the flange locates into the cover flange recess - ensure the retainer is fully home.

9

Ensure the key housing flange is supported on a solid surface for the next operation.

10

Insert the Swaging Punch into the bore of the retainer and strike with hammer; turn the Swaging Punch through approx 45° and strike again to achieve an additional mechanical bond. Remove excessive adhesive.

Note: caution should be exercised when swaging the retainer to ensure no cracking of the retainer occurs.

Insert the Swaging Punch into the bore of the retainer and strike with hammer; turn the Swaging Punch through approx 45° and strike again to achieve an additional mechanical bond. Remove excessive adhesive.

Note: caution should be exercised when swaging the retainer to ensure no cracking of the retainer occurs.

11

Drive the bung into the key housing bore until it engages on the taper.

12

Apply a bead of 40fc sealant to the edge of bung and smooth over to seal.