Technical data sheet

**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**

<table>
<thead>
<tr>
<th>Technical data</th>
<th>Test procedure</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>E-Modul [N/mm²]</td>
<td>DIN EN 13412:2006</td>
<td>8500</td>
</tr>
<tr>
<td>Compressive strength [N/mm²]</td>
<td>DIN EN 12190:1998</td>
<td>158</td>
</tr>
<tr>
<td>Viscosity [mPas]</td>
<td>DIN EN ISO 1219:1994</td>
<td>20,000 - 25,000</td>
</tr>
<tr>
<td>Density [g/cm³]</td>
<td>-</td>
<td>1,55</td>
</tr>
<tr>
<td>Pot life (+20°C) [min]</td>
<td>DIN EN ISO 9514</td>
<td>50</td>
</tr>
<tr>
<td>Curing time (+20°C) [h]</td>
<td>-</td>
<td>24</td>
</tr>
<tr>
<td>Curing time until moulding (+20°C) [h]</td>
<td>-</td>
<td>18</td>
</tr>
<tr>
<td>Shore-D Hardness</td>
<td>DIN ES ISO 868</td>
<td>84</td>
</tr>
<tr>
<td>Shrinkage [%]</td>
<td>DIN EN 12617-4/2002</td>
<td>&lt;0,1</td>
</tr>
<tr>
<td>Thermal Resistance °C</td>
<td>permanent temporary</td>
<td>-20°C to 80°C</td>
</tr>
<tr>
<td>-</td>
<td></td>
<td>-40°C to 125°C</td>
</tr>
<tr>
<td>Mixing ratio [A:B] [gr]</td>
<td>-</td>
<td>87:13</td>
</tr>
</tbody>
</table>

**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.

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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 intensively 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.