

## Recommendations for processing of RenPaste™ model paste (applied by machine)



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- 1.** When starting up the machine, we recommend that you allow approx. 3 - 4 kg of material to pass through in order to achieve a stable pressure in the system and in the hoses.
- 2. Check mixing ratio:**  
 Please start the machine and after approx. 10 seconds place a disposable cup under the mixing head to take a material sample. Fill the disposable cup for approx. 20 seconds at 2 liters / minute.  
 Check the weight in the cups to determine the mixing ratio. Repeat this process 3 times.  
 The optimum mixing ratio between Resin and Hardener is 100:100 (+/- 2,5 %)
- 3.** The hose length should be approx. 3,5 up to 5 m.
- 4.** Now you can start with the paste application.
- 5. Drum change:**  
 Each component must be well vented. We recommend that you drain approx. 1 kg of material from each container in the ventilation area. It should also be ensured that the pressure in the system is at the same level for both components (resin and hardener) after changing the drum.  
  
 In practice, the resin component tends to lose pressure. This leads to a delayed flow when restarting, which in turn can lead to mixing errors in the initial area.  
  
 In most systems, the pressure can be adjusted by manually selecting the resin pump. The pressure in the line should be slightly higher than for the hardener component.
- 6. Restarting the system:**  
 If you want to continue with the paste application after a pause, you should reduce the flow-rate. We recommend a flow-rate of approx. 1 litre/minute. After approx. 1 minute, the flow-rate can then be reset to the original value of e. g. 2 litres/minute in combination with the mixer speed.

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**7.** After finishing the paste application, pressure on the system should be relieved. This is necessary since the density of the paste is increasing when material in the hoses is pressurised for a longer period. Additionally this will lead to loss of time and material when flushing the material at re-starting the application.



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### General recommendations:

- ✓ For the ideal application on flat surfaces we recommend the use of a flow-rate nozzle. A flow-rate of 2 to 3 litres/minute is optimal.
- ✓ For complex geometries you should apply the paste directly from the hose. The flow-rate should be 1,5 to 1,75 litres/minute.
- ✓ In order to obtain an optimal mixing it is recommended to automatically synchronise the mixing speed to the output. Most machines have an automatic control. Older or simplified control systems must be controlled manually.



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***If you have any further questions, please do not hesitate to contact our specialist for paste, Mr. Markus Potthoff.  
You can reach him under the mobile number ++49/173/3230379.***