

Repair manuals for MB lifting bag

1. General

Wear the specified personal protective equipment during the gluing procedure:

- Protective goggles
- Protective gloves
- Protective mask



Carry out repairs outdoor **in dry weather or indoor in a properly ventilated space**.
We recommend carrying out repairs at ambient temperature ranging from 20° to 25°C.

2. Repair kit

The repair kit consists of:

- 2x Ø75mm round patches (1x KK900, 1x KK600)
- 2x Ø130mm round patches of material (1x KK900, 1x KK600)
- 2x rectangular shape patches (1xKK900, 1x KK600)

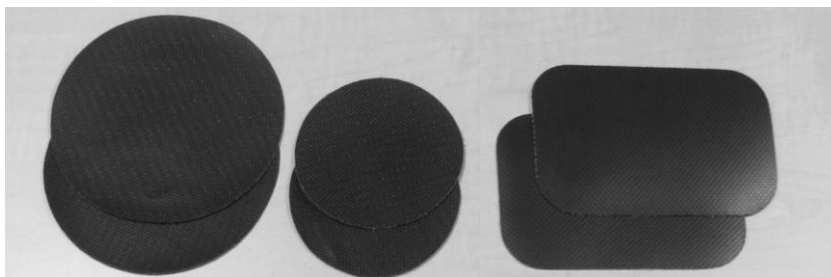


Fig. 1.: Repair patches

3. Repair material and tools

The following materials and tools are used at repairing:

- Ball-point or felt-tip pen
- Paint brush, wooden stick for stirring the adhesive
- Cleaner + cleaning cloth ...
- manual roller or a piece of metal pusher with smooth edges
- appropriate suitable polychloroprene adhesive (SC-2000) with a corresponding hardener.
- Pistol – hot air



SAVATECH d.o.o.
Environmental Protection & Rescue
Škofjeloška cesta 6, 4502 Kranj, Slovenia
Tel: +386 04 206 63 88 Fax: 04 206 63 90 www.savatech.com

4. Gluing procedure

First locate the damaged area on bag. Mark it and dry the damaged area well. Glue only when the surface is completely dry.

The repair kit contains repair patches. Choose the size of the patch which exactly fits the size of the hole. If the hole is larger, cut a patch of suitable size out of the enclosed material. The patch shall be large enough to reach at least 2 cm over the edges of the hole.



Fig. 2: Choose a correct size of the patch.

Place the repair patch over the damage and mark the area to be ground.



Fig. 3: Marking the area to be ground on the bag.

GRINDING

Use the grinding paper and slightly grind the marked area on the bag and the repair patch. Grind until the surface to be glued together becomes slightly rough. Carry out the grinding procedure just before the gluing procedure.

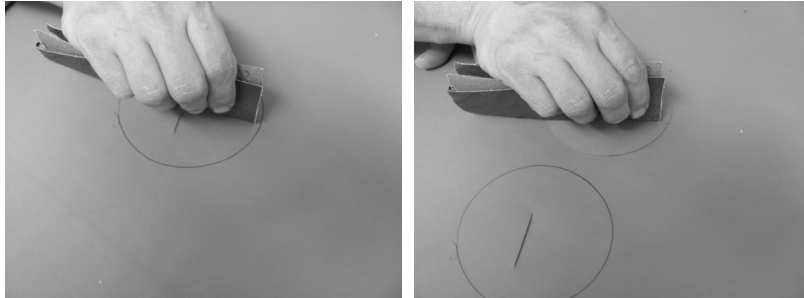


Fig. 4: Grinding the area to be glued on the bag and the repair patch

Use a cloth to remove the dust from the ground area.



Fig. 5: Cleaning of the glued area.

Apply the glue only after making sure that the area to be glued is completely dry.

GLUING

Glue must have approximately the same temperature as the bag.

Mix the glue and the hardener in a specified proportion (See the instructions for the use of glue!) and mix well. Allow 5 to 10 minutes for the glue and hardener to bond. Using a brush apply a thin layer of glue on the area to be glued on both, the bag and the repair patch.



Fig. 6: Glue application. *Glue SC-2000 is black colour.*

Wait until the glue gets almost dry (still slightly sticky if touched) and repeat the procedure. When the glue is almost dry (still slightly sticky if touched), press the repair patch on the bag. **Note! The repair patch shall closely fit the coated section on the bag.**



SAVATECH d.o.o.
Environmental Protection & Rescue
Škofjeloška cesta 6, 4502 Kranj, Slovenia
Tel: +386 04 206 63 88 Fax: 04 206 63 90 www.savatech.com

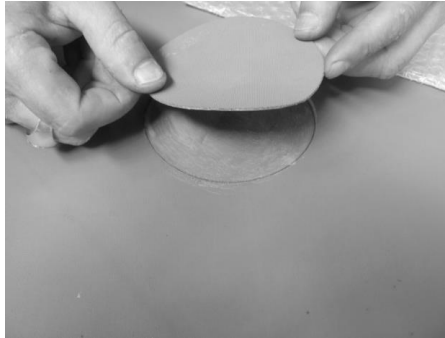


Fig.7: Press the coated repair patch onto the coated damaged area of the bag.

After both surfaces bond, press the patch on the bag by means of a roller or a round metal piece.

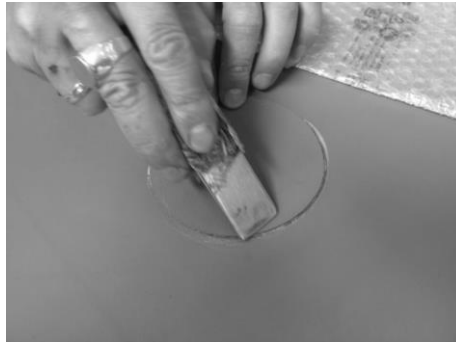


Fig. 9: Pressing the glued surface.

When repairing the lifting bag with glue SC 2000 you do not need to heat the repair surface.

Allow at least 24 hours for the glue to dry, after which test the repaired bag.

Fill the bag with air (pressure max. 0.1 Bbar) and test for leaks with soap water.

If any leaks on the repaired surface are detected, pull off the patch, at which you can use a pair of tongs or warm up the patch with a drier and repeat the gluing procedure.