

**FENZI**

1941 **70** 2011

# CUSTOMER SERVICE

## Mixing ratio test



Please send us 4 cups cured sealant in a sequence, write 1,2,3,4 on the cups.

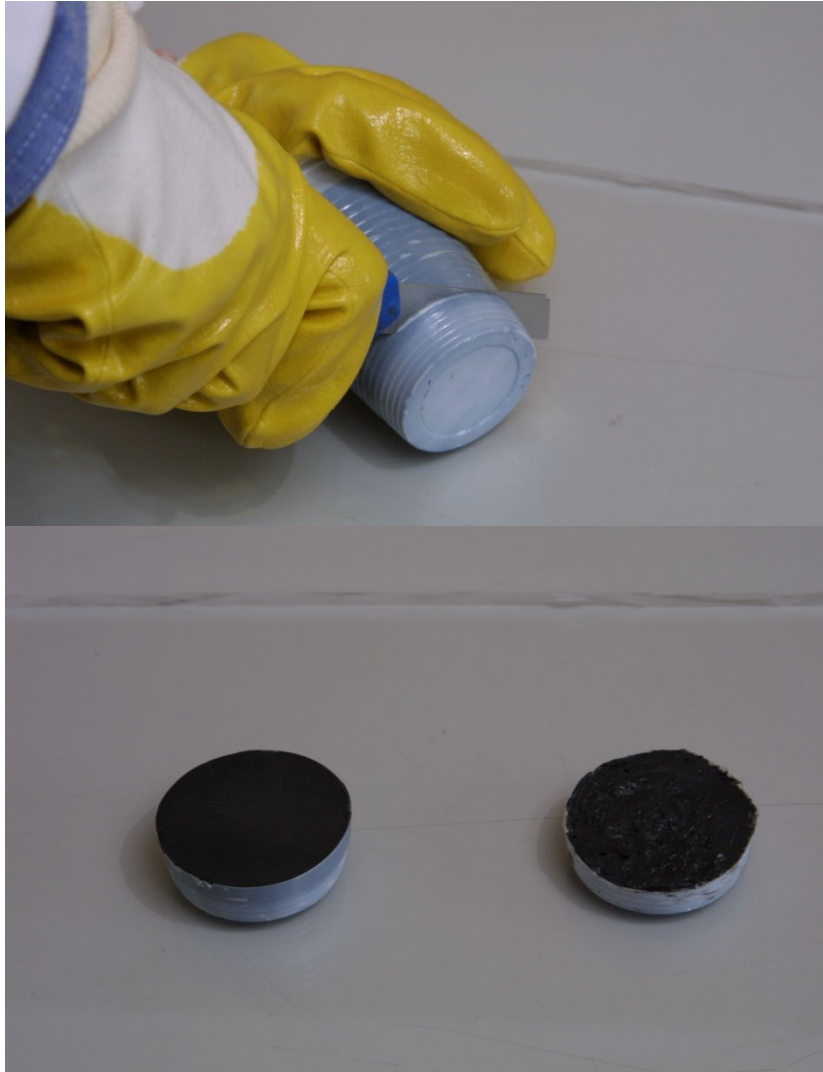
Write you company name, batch numbers of A and B-part , date and the line number or the name of your line

Send the samples to:

**Dr. Gianluca d'Emanuele**

**FENZI SpA - Zona Industriale - Via Trieste 13/15  
20067 Tribiano (Milano) ITALY**





## Mixing ratio test

Determination of Mangan content by X – ray absorption spectroscopy in each sealant layer



## Mixing ratio test

### Specification for Mixing ratio profile:

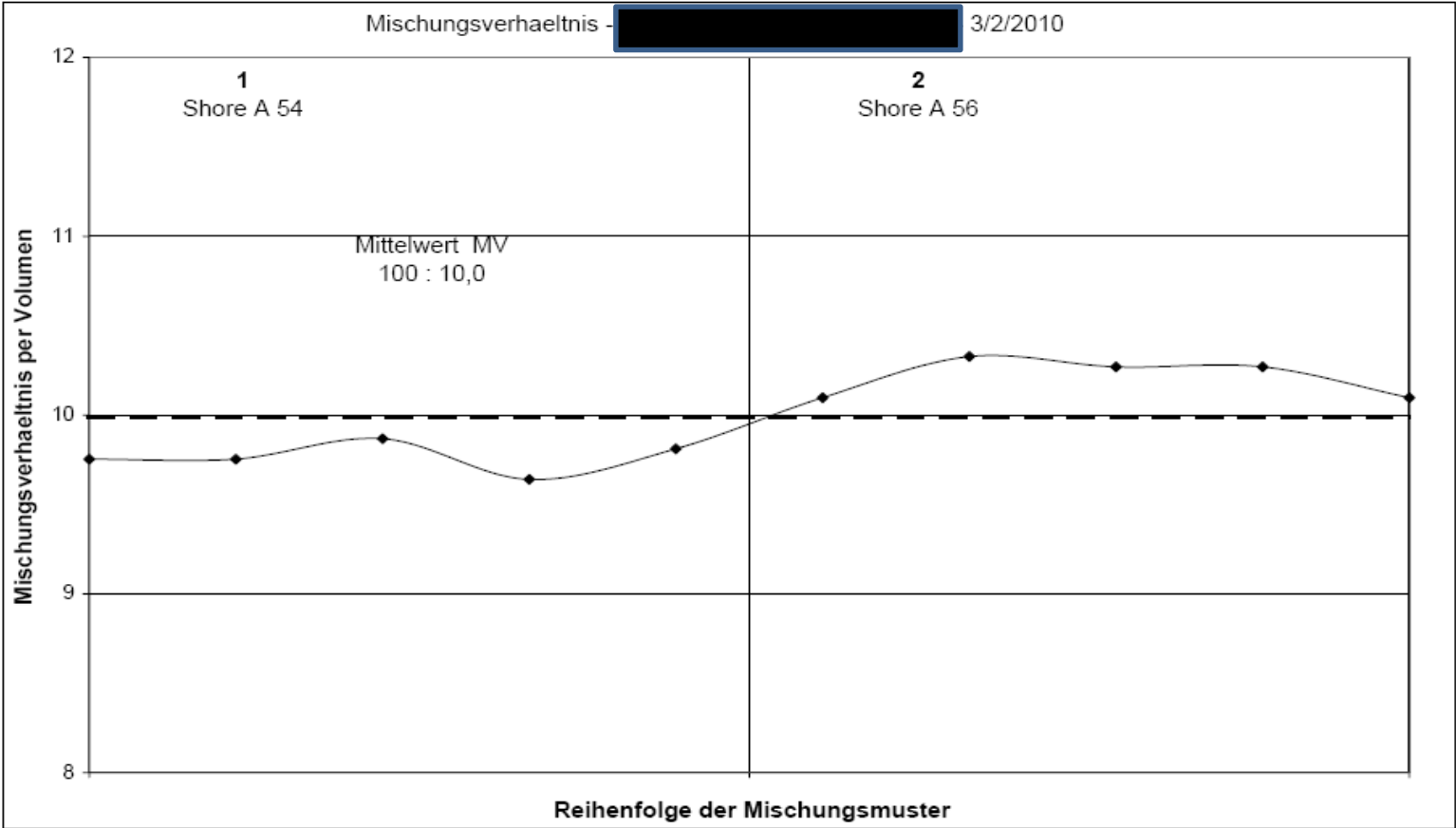
Average of mixing ratio: 100 : 10  $\pm$  10% by volume

Maximal single peak deviation: 100 : 10  $\pm$  20% by volume

Shore A after 24h at 23°C 50% r.h. > 50

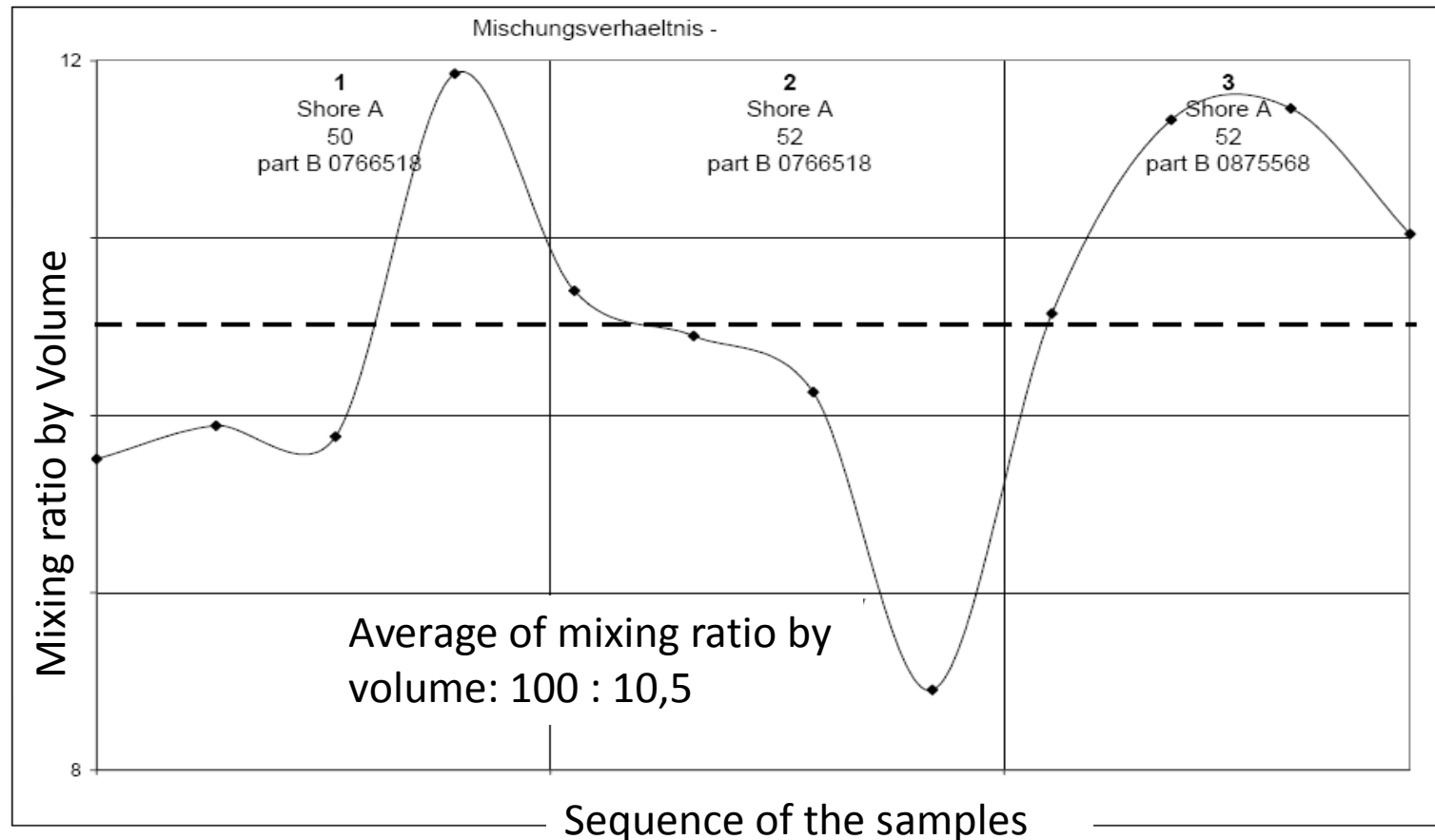
**Example of Mixing ratio profile:**

- average of mixing ratio is 100 : 10 by volume
- machine is dosing and mixing properly,
- sealant properties correspond to FENZI THIOVER specification



## Example of Mixing ratio profile:

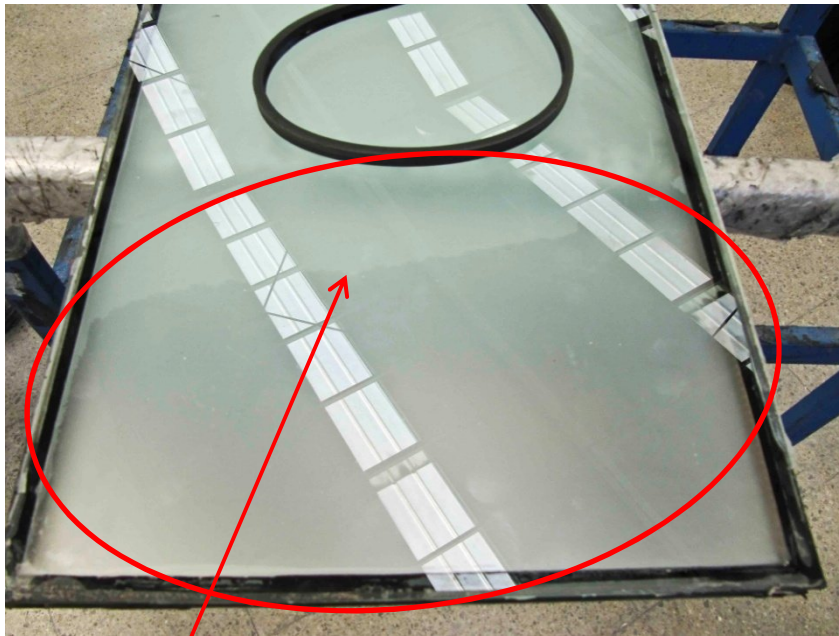
- average of mixing ratio is 100 : 10,5 by volume
- Visible peaks of single measurements show major fluctuations, mixing profile is on the borderline of the specification
- Recommendation: check the valves on the machine



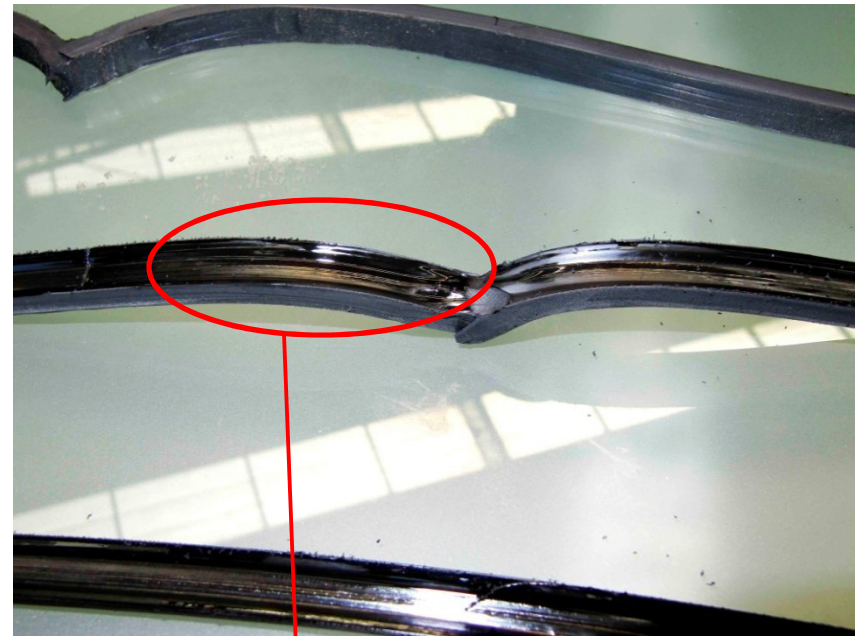


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**What can happen if the mixing ratio is not correct?**



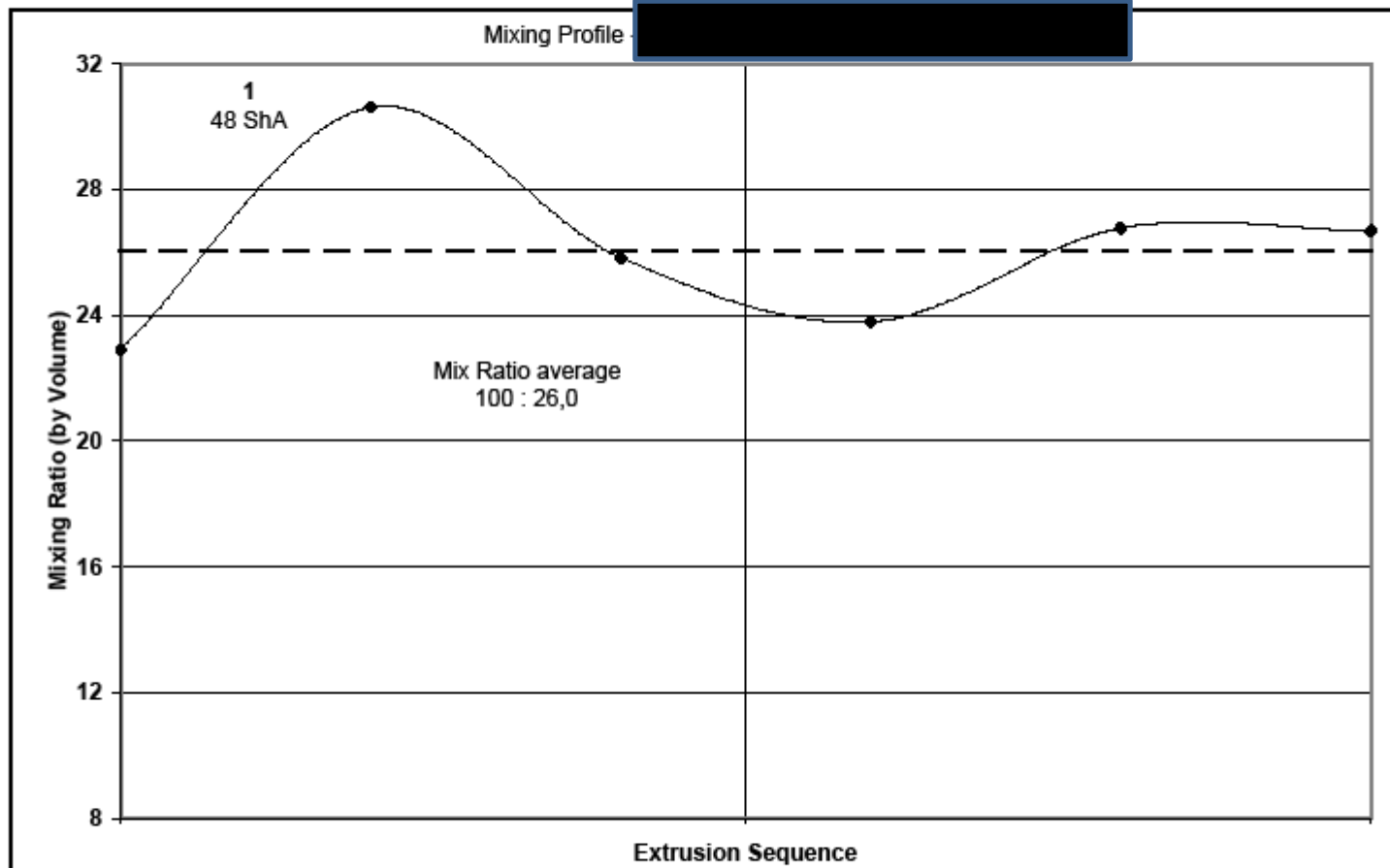
IG unit with oil inside, oily surface of the sealant, bad adhesion to glass and spacer



Mixing ratio analyse of the sealant strip

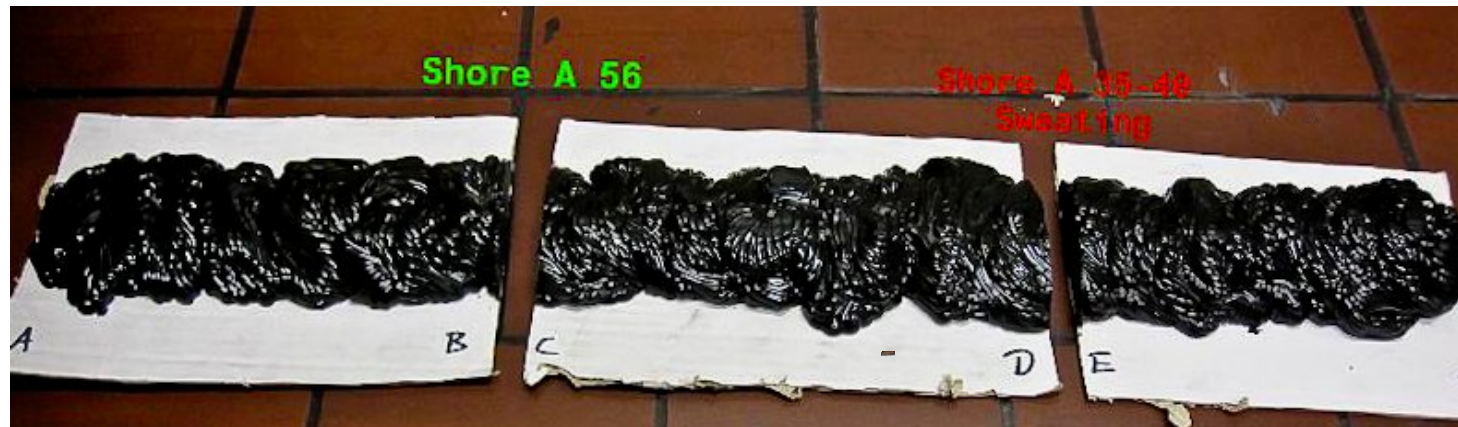
# CUSTOMER SERVICE

Mixing ratio analyse of the sealant strip: 2,6 time so much B-part as necessary!!



Example of B-part overdosing:

												Sweating	
A		B		C		D		E		F			
	57	56	56	57	35	28	47	48	54	56	56		



If the valves are not working properly, bad mixing ratio can happen only on few places. It is possible to identify it with regular control of Shore A on the snake



**Oily surface**



Mixing ratio analyse of the sealant snake: mixing ratio on the place with oily surface is 100 : 24 instead of 100 : 10 (2,4 time so much as necessary)!!

