

SPECIFICATION FOR ALUMINIUM METAL SPRAYING **FOR ANTI-SLIP SURFACE.**

- 1 Abrasive Blast to grade Sa 3 as defined in ISO 8501-1 with a sharp angular profile of 50 to 100 microns. Any cut edges must be ground to remove case hardening from plasma cutting or any rolled edges from guillotining removed to as to provide a continuous surface.
- 2 Before any deterioration of the cleaned surface occurs, apply 100um Zinc metal spray by the Thermion (Metal Spray Twin Wire Electric Arc Spray), process in accordance with ISO 2063:1991.
- 3 Apply 50um aluminium metal to zinc sprayed surface
- 4 Apply to the areas as required of the plate as instructed by the engineer a coat of HIGH PROFILE Aluminium arc spray, to provide an anti-slip surface.
- 3 The metal to be sprayed shall be 99.5% aluminium in wire form of 3.2 and 4.8mm only and meeting the quality as specified in ISO 209-1. Zinc metal to be 99.99% zinc.
- 4 Validate adhesion of the sprayed metal to the steel surface using a suitable bend test eg: American Welding Society ANS/AWS 2.18.93. Or the Grid test specified in ISO 2063 1993 annex A.
- 5 Apply a seal coat of Thermion Arc Spray Aluminium Sealer within 24 hours and before any deterioration of the clean dry metal spray occurs. Thin as necessary to improve wetting and apply until absorption is complete.
- 6 Apply topcoat to colour as requested by the Architect to achieve 50um DFT approx to surface, produce such as Ameron 645 to colour required.

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