



Overview

Shot blasting is a process that improves the surface condition of steel, removing rust and profiling the surface to provide adhesion for the following layer of powder coating material.

Less aggressive options for surface preparation of stainless steel and unprotected areas of pre-galvanized steel using non-ferrous aluminium oxide are also available.

When combined with chemical paint stripping the result is a less aggressive paint removal system.

Key Points

- Enables fabrication without drainage holes required when galvanizing
- Increases design possibilities for complex fabrications
- Reduces some surface defects in base material
- Cleans rusty or pre-painted material to reveal 'new' base metal
- Used before galvanizing to increase the thickness of zinc.

Specification

Achieving a surface profile of SA 2½ on mild steel substrates using steel grit. ISO 12944-4 and ISO 8501-1.

Fine surface profile on stainless steel and galvanized steel substrates – sweep blasting using AlOx or Garnet.

Plant equipment

The plant enclosure is a rubber lined room (to stop the walls and floor being worn away by the abrasive) which contains the shot hopper and gun. This intensely manual process takes place entirely within the plant room.

The plant can process material up to 6500mm long, 750mm wide, 2000mm high.

Material is rested on low beams or trestles to allow 360 degree access to the fabrication.

All shot is sieved before being re-circulated.

Process

Mild steel for powder coating.

Degrease, shot blast, blow down and check for embedded shot.

Mild steel before galvanizing.

Shot blast only

Painted steel, paint removal

Chemically strip (if required), dry, shot blast, blow down and check for embedded shot.

Painted aluminium paint removal

Chemically strip, dry, AlOx blast (if required), blow down and check for embedded shot.

Stainless steel for powder coating

Degrease, AlOx blast, blow down and check for embedded blast media.

All powder coating operations take place within 4 hours of shot blasting.

Applied under ISO 9001: 2008 Quality Management System. Approval Nr: LRQ 0963080

Product information

Project information

Warranty

For C2 and C3 environments: 15-year warranty for gloss, colour and adhesion is offered as standard.

For C4 and C5I & C5M environments: Guarantees are conditional on project location, environmental conditions and pre-contract approval.

Warranties are offered in conjunction with Powdertech standard terms and conditions and a documented cleaning and maintenance programme.

Please note:

Whilst every care has been taken to provide accurate information this document is for guidance only and should be read in conjunction with other data sheets where applicable.

This document forms no part of a contract. Any warranty is subject to individual review.