



# zandleven coatings

## Before blasting

- \* Carry out activities like welding, grinding, breaking edges, drilling carefully.
- \* All the weld seams must be fully welded and if necessary polished, grind the doubles away, remove all weld slugs and weld spots and break all sharp-edges.

## After blasting

- \* The surface to be preserved must be free of water-soluble salts up to an upper limit of 50 mg/m<sup>2</sup> according to ISO 8502-6.
- \* Clean the surface carefully from blasting medium, dust, dirt and so on.
- \* Apply after the blasting and cleaning of the surfaces the first coating layer as soon as possible.
- \* At the beginning of the spray application the surface must be equally to the prescribed purity level.
- \* The application of the coatings has to be carried out at temperatures between 5°C and 35°C and a relative humidity of maximum 85%.
- \* During the application the surface should be dry and the temperature should be at least 3°C above dew point (unless a different temperature is mentioned on the product's technical information sheet).
- \* During application, please take care of sufficient ventilation for drying and hardening.
- \* Keep sufficient colour difference between the different coating layers.
- \* Also on the edges, corners and difficult reachable places the obligatory film thickness has to be applied.

## Dry film thickness

Unless otherwise agreed the individual dry film thicknesses between 80% of the NDFT and the NDFT are acceptable provided that the number of these measurements is less than 20% of the total number of individual measurements taken; according ISO 12944-5

## Transport and assembling

- \* Transport of the coated steel parts to building-places can only occur after sufficient hardening.
- \* During the transport of the coated steel parts take care of sufficient buffer wood between the coated steel parts.
- \* During assembly use canvas or with canvas covered halters.
- \* If possible, use bolts and nuts, which have been covered with a metallic coating layer.

## Inspection

If any inspection during pre-treatment and application is desired, it is necessary to inform approximately 1 week ahead our technical department/engineer where and when the activities should be carried out.

## Always consult the corresponding technical information sheets

These data have been drawn up to the best of our knowledge and were correct at the date of issue. However we cannot accept full responsibility, because the choice of products and circumstances during elaboration of the systems fall outside our judgement. This documentation sheet will not automatically be replaced in case of modification.

