

PREPARATION OF ZINC PRIMED WELD STEEL TEST PANELS

Application

This procedure describes the method of preparation for zinc primed steel weld test panels.

Apparatus Required

Spray Gun

DeVilbiss Type J.G.A., with No. 30 air cap, Fluid Tip FF, Needle FF.

Source: Aerograph De Vilbiss Co. Ltd.
Ringwood Road
West Howe
Bournemouth, Hants

or, **Simco-Bendix, Mistless type gun**, Suction feed spray or airless spray can be used.

Source:	Simco-Bendix	Miracle Sprayers
	3 Rue d'Industrie	268 Brompton Road
	Monaco (P.T.E.)	London, England

Laboratory Oven

Capable of maintaining temperatures up to 200 +/- 1 °C, preferably with horizontal air flow. The oven must be capable of the following heating rates:

Oven Temperature before insertion of panels (+/- 1 °C)	Maximum heating up time for metal temperature of panels to attain oven air temperature (minutes)
100	8
110	8
120	9
130	9
140	10
150	10
160	11
170	12
180	13
190	14
200	15

Date	Action	Revisions
2001 03 13	Revised	Editorial – no technical change A. Cockman
1989 05 19		

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Thickness Gauge

Permascope with a constant pressure probe.

Source:	Fischer Instrumentation Ltd. Arnhem Industrial Estate Arnhem Road, Newbury Berks	Fischer Messtechnik 7034 Maichingen Industriestrasse 21, Germany
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Test Panels

Steel body skin panels ground to a surface finish of 0.9 - 1.8 microns CLA, or as specified in the relevant Engineering Materials Specification, prepared in accordance with FLTM BV 150-11 as described below:

Sizes:	100 x 300 mm
or,	150 x 300 mm
or,	75 x 230 mm
or,	100 x 200 mm

Paint Mixer or Pallet Knife

Preparation of Test Panels

1. Bake the test panels for 5 minutes at 140 +/- 2 °C metal temperature to remove any surface moisture. Cool to room temperature.
2. The weld primer is applied to two (2) types of panels as follows:

Clean panels - clean, dry steel surface, prepared in accordance with FLTM BV 150-11.

Oiled panels - prepared in accordance with FLTM BV 150-11 oiling grade 'Heavy'.

3. Adjust the spray gun to ensure that a coating thickness of 40 - 60 microns is obtained in two (2) passes maximum.

If the DeVilbiss suction gun is used, apply the zinc welding primer in the following manner:

use 0.41 MN/m² line pressure
use 2.5 - 3.0 m hose from the line to the gun

4. Dry and age the panels as required by the relevant Engineering Materials Specification.

Chemicals, materials, parts, and equipment referenced in this document must be used and handled properly. Each party is responsible for determining proper use and handling in its facilities.