

Steel Substrates must always be prepared by grit blasting to the following specifications prior to lining with **Archco-Rigidon** materials:

Minimum Cleanliness Standards – All Systems	Swedish Standard	BS4232	NACE	USA Specification	Japanese Standard
Near White Metal	SA 2 ½	2 nd Quality	=2	SSPC-SP10	JASh 2 JASd 2
Anchor Profile 400 System	50-75 microns 2-3 mils				
Anchor Profile 500, 600 & 700 Systems	75-150 microns 3-6 mils				
Maximum Humidity %Rh during Grit blasting	90%				
Minimum Substrate/Dewpoint Differential	Dewpoint +3°C				
Minimum Substrate Temperature for Primer Application	10°C				

Ensure that surfaces are free from oil grease and other contaminants prior to blasting.

Prior to blasting, dress welds, remove weld splatter and radius all sharp corners. Carry out any further preparations as required.

Monitor ambient conditions before and during grit blasting on a regular basis and record. Under no circumstances should grit blasting proceed if the stated ambient conditions are not met.

Remove all blasting medium and dust by vacuum prior to priming.

Priming should be carried out within 4 hours or before any signs of oxidation are evident. The stated ambient conditions should be maintained during the cleaning and priming operations.

Inspection of Prepared Steel Substrates

The surface preparation should be checked for cleanliness standard by comparison with the Swedish Pictorial Standard. The profile should be measured using an approved gauge (e.g. Testex Comparator) prior to application of any materials.

Grinding/Needle Gun Preparation

Grinding and/or Needle Gun preparation should only be carried out to small repair areas where grit blasting is not practical. (See Doc. Ref. 34-/1 for repair procedures).

Wet Blasting

Whilst Dry Grit blasting is the recommended method of surface preparation for applying **Archco-Rigidon** materials, it is recognised that Wet Blasting is employed in certain circumstances. Should Wet Blasting be carried out, a suitable inhibitor must be added to the media water to prevent contamination of the substrate. The substrate must be completely dry prior to application of the primer. During the drying period dehumidification, equipment would be required to ensure any airborne moisture is removed.