



## SPRAYING PARAMETERS for SafTrax TH604 CF “Patented” Non Skid

### Basic Parameters;

Spray Material: 1/8" Diameter.

Base Material: Steel, Aluminum, most all metals, and concrete

Thickness: 20 to 50 mils normal, thicker coatings can be applied with restricted spray techniques. Thickness can be measured using a standard ferrous mil gauge in conformance with SSPC-PA2. Note; with having such a high peak to valley ratio it is recommended to average together the coating thickness readings.

Layers: Apply layers in a cross hatching pattern. Stronger bonds are achieved by applying multiple layers, rather than one heavy layer.

Travel Speed: 12" inches per second (305 mm per second)

Gun Angle: 90 degrees to surface is ideal, angles of up to 45 degrees produce satisfactory coatings.

Spray Distance: 3" to 8" (76 mm to 203 mm) is ideal, while distances from 3" to 10" (76 mm to 254 mm) produce satisfactory coatings

Bond Strength: Min. 1000 psi, ASTM D454I TYPE V or Equivalent.

**Amperage: 300-450**

**Voltage: 36-40**

<b>Texture</b>	<b>Grade #1 (Rough)</b>	<b>30 psi</b>
	<b>Grade #2 (Moderate)</b>	<b>50 psi</b>
	<b>Grade #3 (Light Texture, top coat)</b>	<b>90psi</b>

### Surface Preparation:

For Steel substrate, grit blast to a near white or white metal with a minimum 3 mil profile using sharp course angular grit. \*DO NOT USE ROUND SHOT.\* 16-24 Mesh recommended

For Aluminum substrate, grit blasting can be use or alternatively a stainless steel wire brush can be used to clean and roughen up the substrate. \* For touch up work or smaller area you can grind clean metal with a sanding disk of 24-36 grit. Substrate should be clean of any contaminants prior grinding.

### Technique for spraying:

Method #1 (PREFERRED METHOD) - Holding the gun at angles from 45 to 90 degrees from work piece at a distance of 3"-8", for first layer start spraying in a circular motion about 4"-6" dia. circle. Overlap each pass or circle by about 1/3<sup>rd</sup> as you move across the substrate. Be sure to move at consistent one revolution a second as to avoid heavy build up in any one area and insure even coverage. Air pressure should be set according to the texture desired. Once the entire area is covered, spray over the already covered area in the adjacent direction making a crosshatch pattern. Once the initial (textured) hatched coating is applied turn the air pressure up to 90 psi for the topcoat. Note; the spray pattern will increase in size. Spray the entire area topping the already coated areas as well as filling in any lightly coated areas in a standard cross hatch method.

Method #2- Holding the gun at angles from 45 to 90 degrees from work piece at a distance of 3"-8", start spraying a line from a set point, being sure to move at a rate of 1 ft. per second consistently to avoid heavy build up. Your air pressure should be set according to the texture desired. Continue following this sprayed line indexing about 2" between the sprayed coatings. Once the entire area is covered, spray over the already covered area in a opposite direction to make a cross hatch pattern. Once the initial (textured) hatched coating is applied turn the air pressure up to 90 psi for the topcoat. Note; the spray pattern will increase in size. Spray the entire area topping the already coated areas as well as filling in any lightly coated areas.