RUST-ANODE®

Cold Dip Galvanization

Product of Galvatech 2000, St-Léon le Grand: www.galvatech2000.com

GENERAL INFORMATION

Rust-Anode® is a cold-galvanization technology that can be performed by dipping. The technique is simple and very economical.

USAGE:

SURFACE PREPARATION

- *Standard degree of cleanliness*
- *Rugosity degree: RA 12.5 µm (0.5 mil.)*
- *Surface must be free of oil, grease and any other chemical contamination.*
- *Surface must be dust-free.*
- *Ambient temperature: approximately 70º F*
- *Relative humidity: approximately 60%*
- *Metal temperature: approximately 70º F*
- *Sharp angles must be rounded before sanding.*
- *Parts must be shot-blasted or sandblasted in accordance to at least standard SSPC SP6 (min.) specifications.*
- *Very clean gloves, preferably latex, must be worn when handling blasted parts.*

RUST-ANODE® PREPARATION

- *Mix Rust-Anode® well, being sure that no deposit remains on the sides or bottom of the container.*
- *Dilute Rust-Anode® with Suspension Fluid (100 millilitres per kilos).*
- *Mix the product well again.*
- *Product must be at ambient temperature or the same temperature as the metal.*

DIPPING BATH

- *Avoid using a bath that is too large.*
- *Bath size must be proportionate to part size.*

- *Bath must be large enough so that part can be completely immersed, and the part must be used to stir the Rust-Anode® to keep the product well-mixed.*
- *Always test with one or two parts, and measure the wet coat obtained, which should be 6-7 mils wet.*
- *The dry coat should be 3.5-4.5 mils, which is the CANICSA G164-M92 Hot Dip Galvanizing of Irregularly Shaped Articles standard.*
- *For a thinner coat, add Suspension Fluid as needed.*
- *Results may vary depending on ambient temperature, so the quantity of Suspension Fluid must be increased or decreased accordingly.*
- *It is very important to always test with one or two parts before dipping an entire lot.*
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DRYING

- *With an appropriate hook, hang parts at an angle facilitating drainage, which lasts about five or six minutes.*
- *Hang parts above a receptacle so Rust-Anode® sag can be recovered.*
- *Dripping will leave drops at the base of parts. A brush can be used to remove excess product.*
- *Allow parts to dry for seven to 10 hours, depending on drying and ventilation systems used.*

SAFETY

- *See safety data sheet.*
- *Rust-Anode® must always be used in a well-ventilated area.*
- *All safety standards must be applied to protect workers' health.*

PRODUCT RECOVERY

- *Rust-Anode® can be left in the dipping bath for the next time parts are dipped as long as the reservoir is well-sealed, or Rust-Anode® can be poured into a container and then firmly closed. Either way, the product will have to be mixed well before dipping next time.*