

SURFACE PREPARATION GUIDE

Steel Substrates

Steel surfaces are to be abrasive blasted with chloride free abrasive materials. Exterior applications to SSPC SP-10 (Sa. 2 ½) near white metal finish. Immersion applications to SSPC SP-5 (Sa. 3) white metal finish. Grind flat all burrs, weld seams, radius sharp edges. The surface should be degreased, and free of dust, moisture or any type of contaminant prior to coating. Fresh blasted surfaces to be primed with a suitable Ronass primer.

Galvanized Substrates

Galvanized surfaces should be degreased if oil and grease contamination is present. Degreased surface shall be high pressure washed so surface is clean and free of all contaminants. Existing coating should be air blasted or removed chemically. The surface should be free of dust, moisture or any type of contaminant prior to coating. Uncoated surfaces to be etched with a suitable Ronass etch primer.

Aluminum Substrates

Aluminum surfaces should be degreased if oil and grease contamination is present. Degreased surface shall be high pressure washed so surface is clean and free of all contaminants. Existing coating should be air blasted or removed chemically. The surface should be free of dust, moisture or any type of contaminant prior to coating. Uncoated surfaces to be etched with a suitable Ronass etch primer.

Concrete Substrates

Concrete surfaces should be degreased if oil and grease contamination is present. Degreased surface shall be high pressure washed, acid etched, and high pressure washed again so surface is clean and free of all grease, oils and surface laitance (contaminants). Existing coating should be abrasive blasted to clean concrete. The surface should be free of dust, moisture or any type of contaminant prior to coating. Uncoated surfaces to be primed with a suitable Ronass primer or sealer.

SURFACE PREPARATION STANDARDS

Standard	Code	White Metal	Near White Metal	Commercial Blast	Brush off Blast
National Association of Civil Engineers	N.A.C.E	#1	#2	#3	#4
American Standards	S.S.P.C	SP. 5	SP. 10	SP. 6	SP. 7
Swedish Standards	SIS-5900	Sa. 3	Sa. 2 ½	Sa. 2	Sa. 1
Japanese Standards	S.P.S.S	JASD 3	JASD 2	JASD 1	N/A
British Standards	BS-5934	First Quality	Second Quality	Third Quality	N/A