



## Coating specification Altech Butterfly Valves

1. **All** casting components to be finish machined **before** any coating is applied to castings.
2. **All** sharp edges on castings must be removed  $\pm 2$  mm radius.
3. **All** casting components must be cleaned of grease and machine oil contamination **before** shot blasting the casting surface.
4. **All** casting components must be shot blast to SA2.5 **before coating is applied**.

**Note: Castings must be ready for coating within 2 hours after shot blasting.**  
If the casting is not coated within 2 hours, the casting must be blast again to remove any oxidation (rust) that may have reoccurred on the casting surface.

5. Before coating, castings must be free of dust and debris.
6. Pre-heat the machined castings to certain temperatures (usually 190 -200°C), duration is depend on castings size.
7. Coat the fusion bonded exoxy powder on whole castings, make sure the thickness of coating on every area is equal and thickness and colour should comply with customer's requirement. (Usually blue colour and 150-200 microns)

**Important:** Coating must be finished before the castings temperature drop down to 160°C if not specified.

8. Heat the castings over again to melt down the powder in oven, temperature and duration is depend on powder performance.
9. Test thickness and appearance.