

All blast-cleaning on all Zinga projects must be done to the **ISO19840-2004** Standard.

All blast-cleaning must be done to a minimum cleanliness of SA2.5 with a minimum roughness factor of 12.5 - 15µm.

The blast-profile depths will vary according to the job at hand.

Readings:

All blast-cleaning contractors, both approved and unapproved, must always observe<

1. Pre-blast cleanliness (degreasing)
2. Blast cleanliness
3. The depth of blast-profile readings
4. The rate of blast-profile readings per m²
5. The rate of DFT readings per m²
6. The readings taken per m²

< 1m² = 5 readings per m²

1 - 3 m² = 10 readings per m²

3 – 10m² = 15 readings per m²

Blast-profile depths:

The 80/20 Rule will normally apply in all cases, unless the client prefers the 90/10 Rule.

Under the 80/20 Rule, at least 80% of the surface area being blast-cleaned must show a minimum blast-profile depth either equal to, or above, the minimum depth as shown on the specification.

The remaining 20% of the area being blast-cleaned must have a minimum of 80% of the specified blast-profile depth.

Example – If the specified depth of the blast-profile is 60µm, then 80% of the surface area must have a profile depth of 60µm or above.

The remaining 20% of the surface area being blast-cleaned must have an absolute minimum profile-depth of 48µm.

If this is not the case, the blasting will be failed by an inspector if there is one present on site.

Note: The same applied to the DFT readings

Roughness:

The roughness of a blast-profile is controlled by the type of media used. You can achieve a blast-profile depth of 60µm using round shot, but there would be no roughness factor whatsoever and hence no mechanical 'key' for Zinga or any other organic coating.

The minimum rugosity Rz (roughness factor) for Zinga (and most high-performance coatings) is Rz12.5µm and this ensures optimum coating performance every time.

| Media Type | Grade | Remarks |
|------------------------|---|--|
| Copper slag | Black beauty or similar, coarse grade | Used on most carbon steels, and is the cheapest good blast-media available |
| Garnet | Coarse | Mainly used for slurry-blasting and UHP AB over or near open water. Excellent media |
| Aluminium Oxide | Minimum Grade 2 for light work and grade 3 for general work | For blasting-cleaning and surface-profiling on cast and extruded aluminium |
| Steel grit | G40 or G40/G25 blend | Excellent for blasting general steelwork. Very easy to control Ra (roughness) factor |
| Chilled iron | G17 or a blend of G17/G34 | The best blast-media for steelwork. It can be recycled up to 18 times. Always remains hard and sharp, and never 'rounds off' |
| Olivine | N/A | Never to be used. Too soft to form a profile |
| Sand | N/A | Never to be used. Illegal and banned from use |
| Calcium oxide | Normal grade | Used for cleaning vehicle bodywork |
| Stone Grit | Normal grade | Never to be used as it shatters with no cutting |
| Stainless steel | G17 | Excellent for blasting aluminium |