



Glass flake Repairs Procedure

1. Repairs to new Glass Flake Linings

- 1.1 After identification of the defective area e.g. pin holes, remove the cured material back to the substrate by grinding or needle-gunning. The materials removal should be kept to a minimum but should allow adequate preparation for removal and repair of the defect.
- 1.2 Where large areas are to be repaired e.g. mechanical damage, caused by dropped internals scaffolding or equipment, treat the repair as per section 2 of this document.
- 1.3 Under no circumstances should materials be applied to a ground steel repair area which exceeds 6" diameter. When areas exceeding 6" are to be repaired the substrate should be re-profiled by needle gun fitted with chisel points or spot blasted using a Vacuum blast or alternative equipment, to the required standard. (see doc SG20).
- 1.4 After preparation, remove any dust or grit blasting medium with a soft brush or vacuum.
- 1.5 When the local areas are free of dust/ grit wipe the area with solvent cleaner, using a lint-free cloth and allow to dry.
- 1.6 Re-apply the specified system by brush or trowel, working well into edges and bare steel using sufficient pressure to expel any air. When applying trowel applied systems, roll the area using styrene as a rolling aid to blend the repair into the surrounding lining. Allow a slight overlap of repair material onto the surrounding lining in all cases.
- 1.7 Carry out a spark test to the repaired area after curing has taken place.

2. Repairs to in-service glass flake lining or large repairs to newly completed linings.

- 2.1 After identification of repair area remove the defective material back to the substrate by grinding, needle gunning or spot blasting.
- 2.2 Under no circumstances should material be applied to a ground steel repair area which exceeds 6" diameter. When areas are exceeding 6" are to be repaired the substrate should be re-profiled either by needle gun fitted with chisel points, grinder fitted with cup wire brush or spot blasted using vacuum blast or alternative equipment.
- 2.3 Grind back the lining around the repair to form two distinct steps in the coating thickness.
- 2.4 Lightly abrade the surface of the coating approx. 150 mm around the repair area to remove any surface contamination or waxed topcoat. Great care should be taken to avoid digging into the existing lining or substantially removing the lining material. Do not overlap onto the waxed coated areas.
- 2.5 Thoroughly clean area around the repair removing any dust or shot blasting medium.
- 2.6 When the local area is free of dust / grit wipe the area with solvent cleaner, ensuring any oil or other contaminants are removed, allow to dry.

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- 2.7 If the repair can be carried out before the substrate oxidizes, continue as per point 2.8, however, if the repair cannot be carried out immediately, prime the repair area with the correct primer for system to be used.
- 2.8 Apply the first coat of repair material flush with the first step (this coat can be pigmented if required). When applying the specified system by brush or trowel work well into edges and bare steel using sufficient pressure to expel any air. When applying trowel grade systems roll the area using styrene as a rolling aid to blend the repair into the surrounding lining.
- 2.9 Apply second coat of the repair system and blend into the surrounding coating. Allow to cure.
- 2.10 Spark test to the required standard.
- 2.11 Apply waxed topcoat if specified.

