

www.nkcoatings.com

**NK COATINGS LTD**

# **Fabricator's Handbook**

**Important notes on venting and  
preparing fabricated items for  
galvanising and powder coating**

*For more information please  
contact our technical staff*

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# IMPORTANT

## Standard Order Forms



To ensure your materials are processed efficiently, NK Coatings provides a Standard Order Form (supplied along with the NK brochure), which should be handed in on arrival or given to the NK Coatings lorry driver on collection from your premises.

Standard order forms are available from our sales department or can be downloaded from our website at

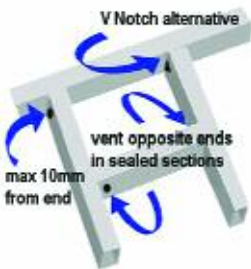
[www.nkcoatings.com](http://www.nkcoatings.com)

# Venting

**Inadequately vented fabrications can explode when dipped in hot baths and trap chemicals during the powder coating process.**

Any tubular or hollow section fabrication must be suitably vented to prevent these explosions.

A detailed example of how to vent these sections is indicated in the sketch below:



# Quick Tips

- ✓ Vent holes should be drilled not more than 10mm from each sealed end
- ✓ Holes must be on opposite sides of each section for easy drainage
- ✓ Hollow sections can be 'V' notched
- ✓ Ensure hole sizes suit section size (see table below)

## Recommended hole sizes

The larger the hole size, the better the drainage and the better the finish.

Section size	Hole diameter
Up to 50mm	12mm
60 – 100mm	16mm
110 – 150mm	20mm
150mm+	25mm

# Structural Steel

## Hollow section base plates

**NO**

One hole will  
leave zinc or  
chemicals inside  
the section

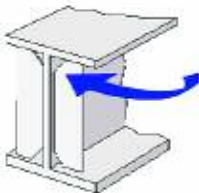


**YES**

Two or four  
holes will allow  
drainage

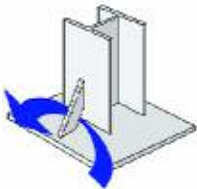
# Structural Steel

## Stiffeners



Stiffeners should have their corners cropped to eliminate dead pockets. This will give a cleaner finish and save money.

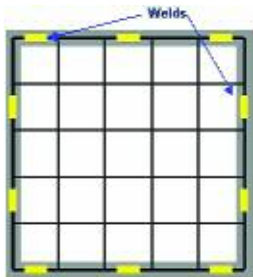
Stays should be made to allow the free flow of zinc for the best finish.



# Mesh Panels

Mesh will expand and contract during the galvanising process.

Welding only every other wire will keep distortion to a minimum.



# Surface Contaminants

The surface of all material must be free of grease, paint, oil, weld-slag and other surface contaminants to achieve maximum surface bonding during the galvanising and powder coating processes. This is achieved using a hot cleaner or shot blasting if necessary and can incur time delays and extra expense.

**Please ensure surfaces are as clean as possible before collection or delivery to NK Coatings Ltd.**

## **DISTORTION**

**Distortion is a natural by-product of the galvanising process due to the high temperatures involved – especially on sheet materials or components made from varying thicknesses of materials. At NK we do all we can to keep this to a minimum.**

# Powder Coating

NK Coatings is an approved applicator of Dupont Polyester Powders.

As part of our Commitment to Quality we can offer a 25-YEAR GUARANTEE on aluminium surfaces and 15-YEAR WARRANTY on galvanised surfaces on all powder coated finishes.

The NK powder coating system is designed to meet the decorative and performance demands of the construction industry. All work is carried out under the British Standard marques BS 6496 and BS 6497.

NK Coatings provides an extensive range in RAL, BS and metallic colours\* and speciality textures in gloss, semi-gloss (satin) and matt finishes.

Contact our sales office for further details.

\*Colour swatches available

# Dimensions

## Galvanising

Bath Size	Max. Dimensions
7.2m long	7.0m single dip 12.0m double dip
1.7m wide	1.5m wide
2.75m deep	2.5m high

## Powder Coating

Bath Size	Max. Dimensions
6.8m long	6.6m single dip
0.85m wide	0.8m wide
2.8m deep	2.7m high

Please telephone for advice on material sizes