GALVANISING TOUCH UP PROCEDURE

Revision 2

The following procedure is applicable for touching up minor damage to the galvanised finish on GM Poles products.

Ensure that all painting is undertaken in a well ventilated area

NOTE: For repairs on TMR/Roadtek products, please refer to document "Galvanising touch up process for TMR"

REPAIR METHOD 1: BRUSH REPAIR

EQUIPMENT
- Thinners or soapy water for degreasing
- File
- Sandpaper (80 grit recommended)
- Rags
- Paint brush suitable for the area to be touched up
- Zinga - Galvanising system, or similar galv-rich paint.

PPE
- Safety Glasses
- Work Gloves

1. DEGREASE THE SURFACE
- If there is any grease or oil on the area being repaired, you will need to degrease with either:
- Soapy water (preferably warm), or thinners.

2. FILE
- Remove any sharp burrs or heavy dags with a file.

3. SAND & CLEAN
- Locally sand until smooth, taking care to not sand beyond the area to be painted.
- Dust off any loose material.

4. BRUSH ON PAINT
- Apply two coats minimum of Zinga to achieve a minimum dry film thickness of 100 microns (typical coating thickness per coat is 40 microns). Refer manufacturer's instructions for additional information.

REPAIR METHOD 2: SPRAY REPAIR

EQUIPMENT
- Thinners or soapy water for degreasing
- File
- Sandpaper (80 grit recommended)
- Rags
- Wire brush
- Aerosol zinc rich paint with a 99% zinc purity. GM Poles recommend Callington "Silver Zinc Guard" or equivalent.
- Silver spray paint (optional)

PPE
- Safety Glasses
- Work Gloves
- Face Mask

1. DEGREASE THE SURFACE
- If there is any grease or oil on the area being repaired, you will need to degrease with either:
- Soapy water (preferably warm), or thinners.

2. FILE
- Remove any sharp burrs or heavy dags with a file.

3. SAND & WIRE BRUSH
- Locally sand until smooth, taking care to not sand beyond the area to be painted.
- Use a Wire Brush to clean off any loose material.

4. SPRAY ON PAINT
- Apply minimum of two light coats of "Silver-Guard" to achieve a minimum dry film thickness of 100 microns. Refer manufacturer's instructions for additional information.

- Once completely dry, a thin coat of silver spray paint can be applied over the repair. This step is optional and for aesthetics only.

GALVANISING TOUCH UP PROCEDURE

Revision 2

DRILLING ANG TREATING A HOLE ON SITE

EQUIPMENT

- Thinners or soapy water for degreasing
- File
- Rags
- Paint brush suitable for the area to be touched up
- Zinga - Galvanising system, or similar galv-rich paint.

PPE

- Safety Glasses
- Work Gloves

Ensure that all painting is undertaken in a well ventilated area

NOTE: For repairs on TMR/Roadtek products, please refer to document "Galvanising touch up process for TMR"

1. MARK HOLE

- Mark where the hole is to be placed.
- Centre punch the hole centre using a centre punch.

2. DRILL PILOT HOLE

- Drill a pilot hole If required usually 5mm drill bit. (This step is not required if using a hole saw as they have their own drill bit in the centre.)

3. DRILL HOLE

- Drill desired hole size using hole saw, pulse drill while drilling to make cutting easier. (Use coolant in a spray bottle, this could be water or soluble oil.)

4. FILE

- File finished hole to remove any sharp edges using a round file.

5. CLEAN

- Clean around hole to remove any grease or surface contaminants. (This could be done with a thinners or soapy water on a rag.)

6. BRUSH ON PAINT

- Apply two coats minimum of Zinga to achieve a minimum dry film thickness of 100 microns. Refer manufacturer's instructions for additional information.

FINISHED RESULT