



RELINES

by Mike Petkovich, 8/28/06

1. Strip

First and foremost in any reline project is the stripping technique. Here at Hammond Roto-Finish we utilize an environmentally friendly oven to strip the old lining. The oven brings the entire bowl weldment up to 880° to burn out the lining.



This will ensure that the bowl weldment integrity will remain intact during this process. Unlike others who may use a torch to remove the lining, we do not experience hot spots. Hot spots can cause warpage and metal fatigue.

2. Blast Clean

After stripping, all bowl weldments are blast cleaned with 60-grit aluminum oxide. This creates a good bonding surface for the urethane on the inside diameter and good bonding surface for paint on the outside diameter.



Hammond Roto-Finish blast room

3. Molds



All molds are designed, constructed, and maintained by Hammond Roto-Finish. All molds are stored indoors to eliminate moisture contamination and UV attack.

4. Mold Setting

All molds are set to exacting standards to ensure proper urethane thickness on the sides and bottom of bowl.



5. Controls

The urethane pouring room is temperature and humidity controlled to exacting standards.



Climate Controlled
Monitoring Temperature
and Humidity

All linings are probed after completion to assure that the proper thickness is maintained.

6. Mixing Machine

The urethane is mixed at proper ratio through the mixing machine. There



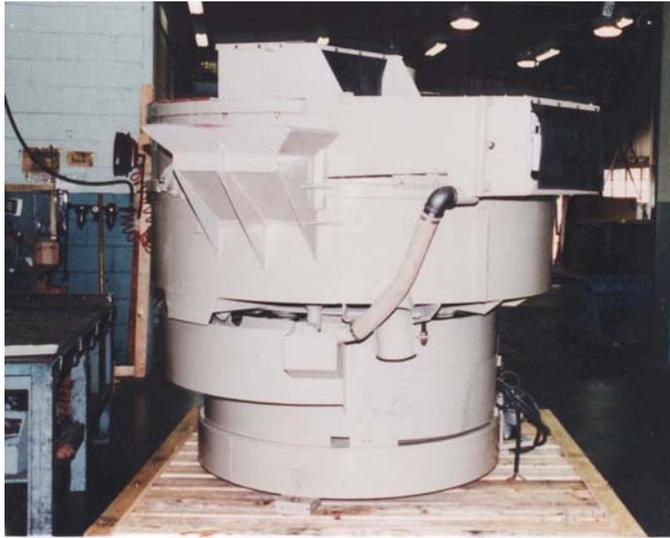
are no pours from 5-gallon pails.

7. Coupons

A coupon retain is kept on hand for each and every pour. These coupons are kept on file for three (3) years.



8. Before and After



9. Included Items

All relines include the following, as applicable:

Burnout, blast and reline the vibratory process bowl.

Install gate, gate shaft, bearings and gaskets.

Replace pipe and fittings for oil recirculating system if required.

Pipe and fittings for solution system (including spray nozzles) if required.

Access cover limit switch as required.

4" pop-in drain plugs.

Separation screen as required.

Paint Roto-Finish "Adobe", "Machine Tool Gray", or "Vista Green".