SURFACE PREPARATION FOR COATINGS & SEALANTS

PREPARATION FROM SCRATCH



GUIDE FOR HEAVY DUTY COATINGS

MONTIPOWER
Surface Preparation Technologies
Part of Monti Group

THE WORLD'S BEST COATINGS DESERVE THE WORLD'S BEST SURFACE PREPARATION

IN THIS GUIDE

This pictorial guide addresses the Bristle Blasting method of surface preparation with MontiPower® tools using carbon or stainless steel spring wire belts. Marketed under the trade names Bristle Blaster® or MBX®, Montipower's power tools are used for weld seam, spot repair and rehabilitation or maintenance. We are an alternative to abrasive blasting, hand tool cleaning and other power tools such as grinders, sanders and needle guns.

This guide addresses the removal of heavy duty coating systems. Using steel panels supplied by Carboline, we describe the bristle blasting surface preparation method using the Bristle Blaster® and MBX® tools from MontiPower®. The results of the bristle blasting method are shown for many common substrates, including verifications of different parameters with 3D scans using a Keyence machine.



Surface preparation is about:

- Removal of millscale
- Removal of contaminants
- Removal of existing coatings or foils
- Surface profiling without a flat area between the peak and the valley
- Removal of imperfections

In addition to Bristle Blasting the steel panels, we also address surface preparation of wood, stone, composite, aluminium, and stainless steel.

- **EPOXY PNENOLIC**
- **EPOXY SILOXANE**
- **SILICONE ACRYLICS**
- **ZINC WITH SILICONE TOPCOATS**
- **NORSOK 2 LAYER SYSTEM**
- **MILLSCALE**
- **ORGANIC ZINC COATING**
- **INORGANIC ZINC COATING**
- **3 LAYER PE/PP**
- **THERMAL SPRAY ALUMINIUM**
- **HOT DIPPED GALVANISED STEEL**
- **PAINTED SURFACES**
- **THERMALLY SPRAYED ZINC AND ALUMINIUM**

A proper surface preparation is essential for ensuring that applied coating systems achieve their optimal performance in terms of adhesion and corrosion prevention.

Surface preparation requirements refer to both the requirements for cleanliness and the requirements for a roughness profile.

The cleanliness and roughness profile for a coating system should be as prescribed for the primer (first layer) of the system.



The Bristle Blaster® is the world's first and only hand-held power tool that produces a quality of surface roughness comparable to that achieved by grit blasting.

It is a "blasting without grit" alternative surface preparation method that creates a surface clenaliness similar to ISO 8501-1 Sa 2.5 or a SSPC SP 10 near white metal finish.

The Bristle Blaster® tool has been developed and enhanced over the years and today a wide range of bristle blasting tools are available:

- Bristle Blaster® Pneumatic, which has ATEX approval for use in Zone 1 (potentially explosive atmospheres) with aircooling.
- Bristle Blaster® Electric Single, 110V and 240V units for standard electric power sources
- Bristle Blaster® Cordless, electric battery operated for use in remote locations and for rope-access work
- Bristle Blaster® Double, 110V and 240V providing larger belts for greater surface coverage and increased productivity
- Bristle Blaster® Axial – specially designed for difficult-to-reach areas such as weld seams, corners, flanges and more
- Bristle Blaster® Subsea – for underwater surface preparation

The MBX® range of belts featuring fine, medium and course carbon steel belts and stainless steel belts, in both straight and bent knee formats, offer excellent surface preparation and cleanliness where a deep roughness profile is not required.

The Bristle Blaster® and MBX® tools both operate at low noise, low vibration and low speed at approximately 2500 RPM.

BRISTLE BLASTING PROCESS

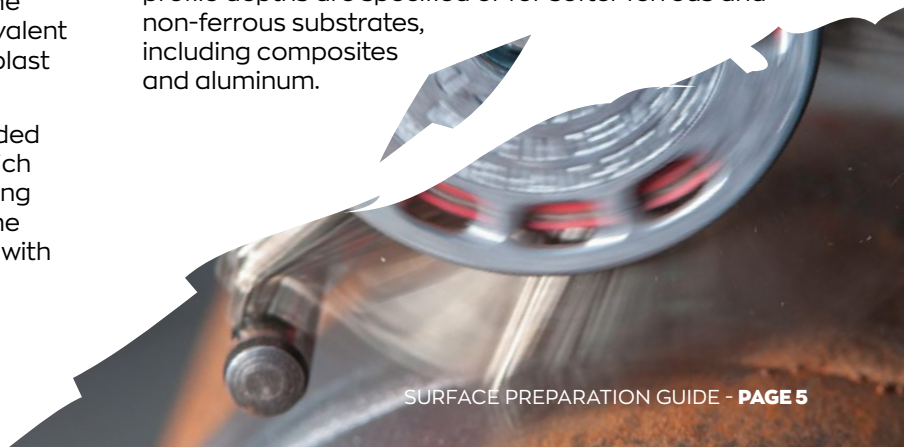
The Bristle Blasting process is an innovation that both removes corrosion and generates an anchor profile by using specially designed rotary carbon and stainless steel Bristle Blaster® belts.

A Bristle Blaster® belt consists of spring steel wire bristle tips that are bent forward and dynamically tuned to the hand-held power tool. The bristle tips are specially designed and sharpened to strike the corroded surface with kinetic energy that is equivalent to conventional blasting processes that use grit blast media.

Immediately after the bristle tips strike the corroded steel surface, they retract from the substrate, which results in the removal of mill scale, rust, and existing paints and creates a new surface profile where the peaks and the valleys form a continuous pattern with no smooth, unprofiled areas.

Consequently, surfaces that have been treated by Bristle Blasting have a texture and visual cleanliness that mimics those obtained by conventional grit blasting processes.

The tools should be used with the accelerator bar when higher surface profiles depths are required or without the accelerator bar when lower surface profile depths are specified or for softer ferrous and non-ferrous substrates, including composites and aluminum.



The Bristle Blaster® with the with the accelerator bar can regularly achieve roughness profiles greater than 75 microns (3 mil), while the norm using the tool without the accelerator bar is circa 25 micron (1 mil).

Standard pneumatic and electric variomatic (also cordless) drive units without the accelerator bar are available as MBX®. MBX® stands for metal blasting and Bristle Blasting for steel substrates.

The MBX® wire bristle tips are shorter than the Bristle Blaster® wires. The MBX® carbon brush bristle tips are hardened. The MBX® bristles are available with a knee like the Bristle Blaster® belts, but also without the knee as a straight variant for finer homogeneous surface profile grades. The MBX® comes in course, medium and fine variants similar to sanding machines.

Bristle Blasting simplifies the surface preparation operation and reduces costs when compared to abrasive blasting through the elimination of expensive equipment, media and extensive environmental and safety measures.

Although the Bristle Blasting process is ideally suited for spot repair applications, it can also be readily applied to larger surface areas where the use of other metal cleaning processes may be prohibited or where power tool cleaning is simply a better option for the application.

For any coating job, it is recommended to first make an assessment of the proper tool and belt for the surface desired and the application at hand.

This is particularly true for difficult to prepare areas such as corners, edges, and weld seams. For flat surfaces, the Bristle Blaster® Double or Prepper® Quattro can bring significant efficiency gains in terms of time and costs.



An assessment of the operating area will also need to be considered, though the Bristle Blaster® or MBX® is specially designed for a wide range of environments:

- Bristle Blasting does not use or produce hazardous materials – steel bridges can be Bristle Blasted safely while passenger trains continue to operate
- Bristle Blasting is a green alternative with low vibration levels and sound pressure –pipelines in environmentally protected areas can be safely prepared with the Bristle Blaster® and the consumed belts can be recycled
- Bristle Blasting is a cost-efficient alternative – set-up is quick and easy and there is no need for protective enclosures, waste media recovery, breathing apparatus or other complex equipment.
- Bristle Blasters are portable and lightweight – weighing as little as 1.1kg and vacuum control units (also cordless) can be easily connected
- New features are regularly being introduced – such as dead man's switch, safety caps, and rope access fittings – continually making Bristle Blasters even safer and more convenient on the job

Bristles are available in carbon steel and stainless steel, with belts available in a range of sizes from 43mm, 23mm, 11mm and half 11mm bristles. Vinyl Zapper wheels in grey silicone for use on cordless tools at 1300 RPM or as yellow hardened rubber erasers for use up to 3500 RPM are available for edge feathering of thick polyethelyene or polypropylene surfaces or for the removal of foils, stickers and glue from surfaces.

MontiPower® surface preparation equipment is also available for use with drones, magnetic wall crawlers or walk-behind solutions, ideal for decks and floors.

Before using MontiPower® tools, it is highly recommended that the user be trained by qualified individuals. Understanding the proper tools for use in different applications and the proper technique for use of the tools is essential for achieving best results in terms of efficient tool use and best possible coating or sealant adhesion.

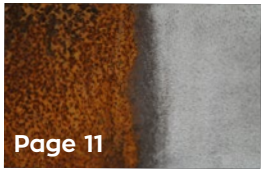
ADVANTAGES OF THE BRISTLE BLASTING METHOD

- No special skills required (training recommended for best use)
- Minimal safety and hazmat requirements when compared to abrasive blasting
- Much smaller environmental footprint when compared to abrasive blasting
- Cleanliness grades similar to ISO 8501-1 Sa2.5/SSPC-VIS1 SP 10/Nace No.2
- Complimentary to abrasive blast cleaning for critical areas such as weld seams and hard to reach areas
- Low noise, low vibration and low rotational speeds of approximately 2500 RPM
- Versatile with different tool configurations and different sized belts for different applications
- Efficient surface profiling solutions in combination with other methods such as induction coating removal or water jetting
- Bristles can be resharpened for longer use, and bristles can be recycled
- Removes mill scale
- Bristle Blaster® Axial drive units are specially designed for difficult to reach areas
- Bristle Blaster® Pneumatic units are ATEX approved for surface preparation in potentially explosive environments
- No burnishing, polishing or smearing effect

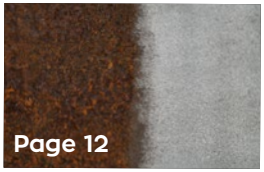
SUITED FOR

Whether removing, cleaning or profiling, the Bristle Blaster® is a powerful technology ideally suited to a wide range of fabricating and infrastructure-support operations such as onshore/offshore well drilling installations, bridge refurbishment, the fabrication and repair of naval / marine vessels and industrial maintenance applications.

SURFACE PREPARATION THROUGH BRISTLE BLASTING



Removal of rustgrade C



Removal of rustgrade C2



Removal of high temperature resistant coating



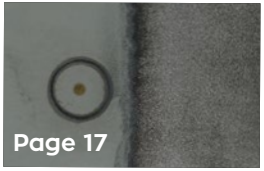
Removal of inorganic zinc coating



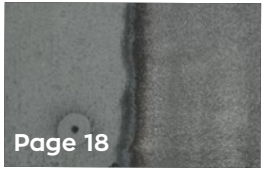
Removal of epoxy coating



Removal of epoxy pnenolic



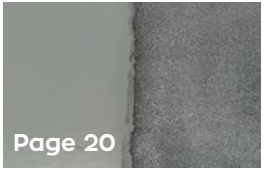
Removal of epoxy siloxane



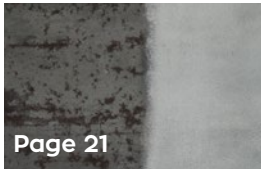
Removal of silicone acrylics



Removal of organic zinc with silicone topcoats



Removal of Norsok 2 layer system



Removal of millscale - a



Removal of millscale removal - b



Removal of ST304



Removal of stainless 304



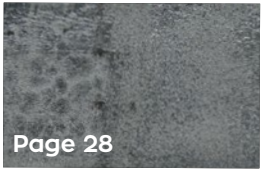
Wood Cleaning and Roughening



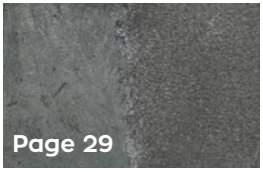
Removal of concrete



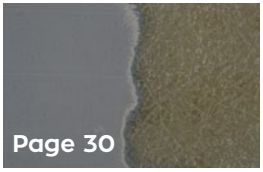
Removal of composite



Removal of zinc coating



Removal of inorganic zinc



Removal of composite gel coat



BEFORE

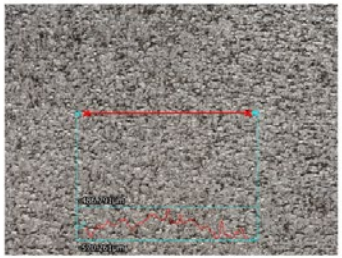
AFTER

REMOVAL OF RUSTGRADE C

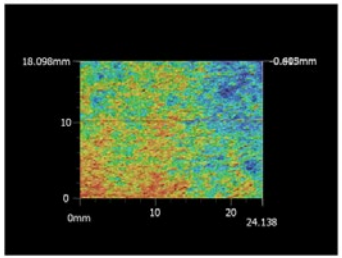
Line roughness measurement 1. Rustgrade C- BB-033

KEYENCE VR-5000 series

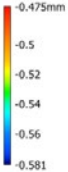
Main image



3D image



Height color



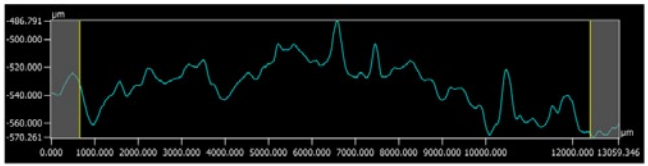
Analysis condition

Correct tilt	None
Measurement type	Roughness
Cutoff	λs =None λc =None
End effect correction	Enabled
Double gaussian	OFF
No. of sampling lengths	1

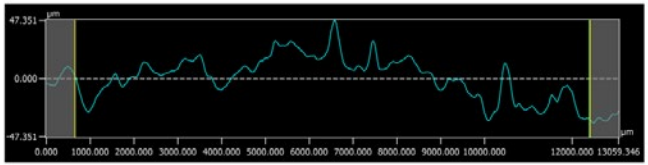
Measurement result

No.	Measurement name	Measured value	Unit
1	Ra	14.038	μm
2	Rz	81.658	μm

Total profile



Roughness/Primary/Waviness profile



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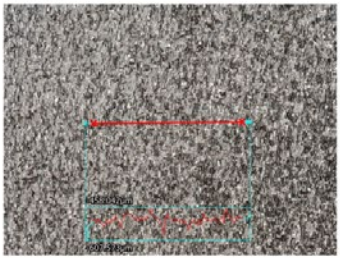
Measurement conditions: 12x Auto



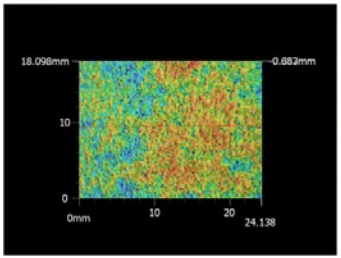
REMOVAL OF RUSTGRADE C (2)

Line roughness measurement 2. Rustgrade C (2) BB-033 KEYENCE VR-5000 series

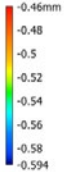
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3D image



Height color



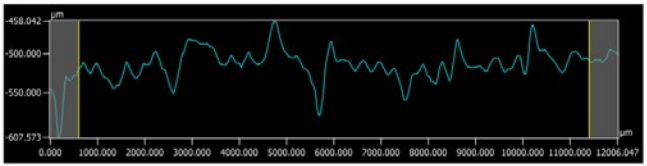
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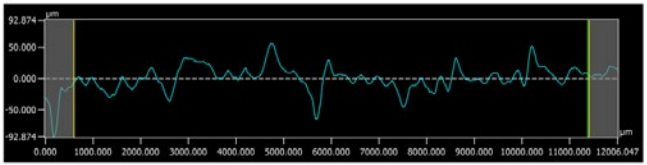
Measurement result

No.	Measurement name	Measured value	Unit
1	Ra	13.408	μm
2	Rz	120.804	μm

Total profile



Roughness/Primary/Waviness profile



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Measurement conditions: 12x Auto

BEFORE

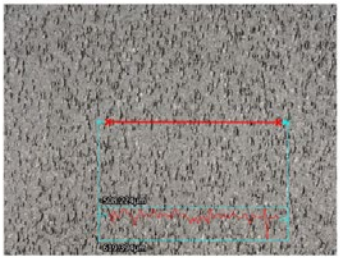
AFTER

REMOVAL OF HIGH TEMPERATURE RESISTANT COATING

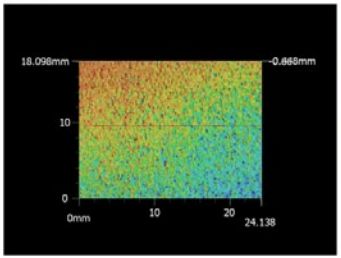
Line roughness measurement 3. HT coating - BB-033

KEYENCE VR-5000 series

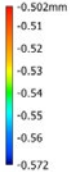
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3D image



Height color



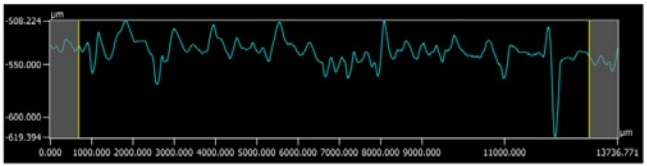
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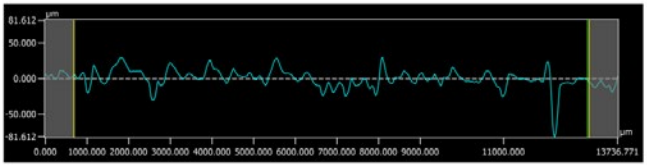
Measurement result

No.	Measurement name	Measured value	Unit
1	Ra	8.893	μm
2	Rz	111.169	μm

Total profile



Roughness/Primary/Waviness profile



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Measurement conditions: 12x Auto



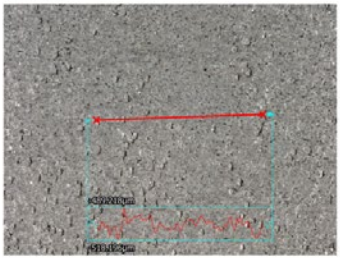
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REMOVAL OF INORGANIC ZINC COATING

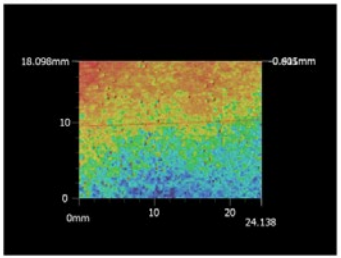
Line roughness measurement 4. IOZ -BB-033

KEYENCE VR-5000 series

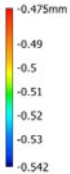
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3D image



Height color



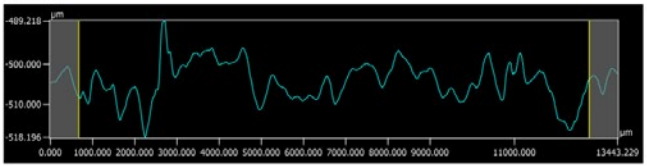
Analysis condition

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Measurement type	Roughness
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Double gaussian	OFF
No. of sampling lengths	1

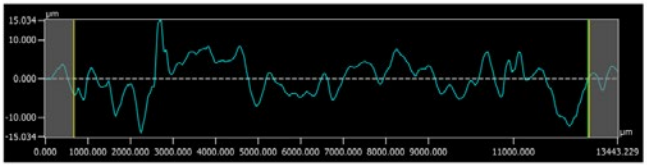
Measurement result

No.	Measurement name	Measured value	Unit
1	Ra	4.095	μm
2	Rz	28.978	μm

Total profile



Roughness/Primary/Waviness profile



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Measurement conditions: 12x Auto



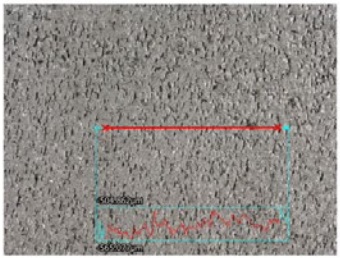
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AFTER

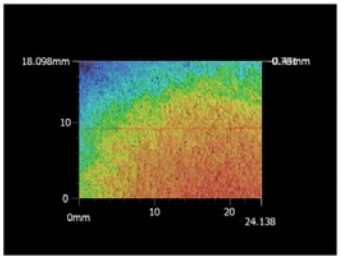
REMOVAL OF EPOXY COATING

Line roughness measurement 5. Carboline -BB-033 KEYENCE VR-5000 series

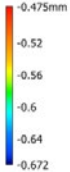
Main image



3D image



Height color



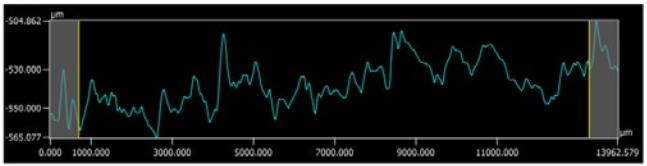
Analysis condition

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Measurement type	Roughness
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End effect correction	Enabled
Double gaussian	OFF
No. of sampling lengths	1

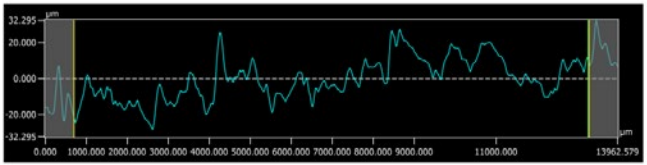
Measurement result

No.	Measurement name	Measured value	Unit
1	Ra	9.252	μm
2	Rz	55.344	μm

Total profile



Roughness/Primary/Waviness profile



Measurement date and time: 24/01/2023 16:09:32

Measurement conditions: 12x Auto

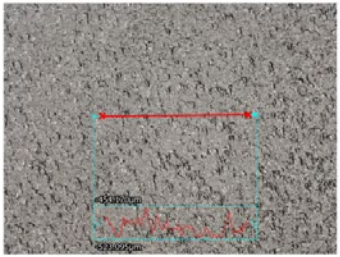


BEFORE AFTER

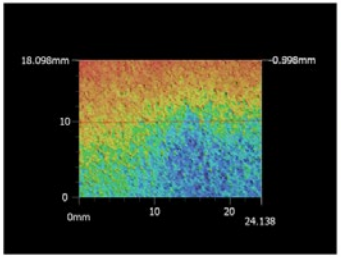
REMOVAL OF EPOXY PNENOLIC

Line roughness measurement 6. Epoxy phenolic -BB-033 KEYENCE VR-5000 series

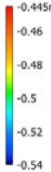
Main image



3D image



Height color



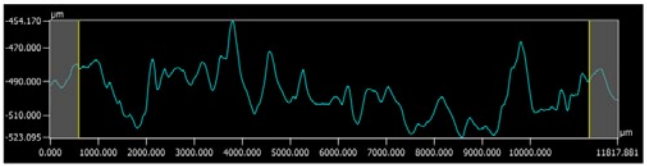
Analysis condition

Correct tilt	None
Measurement type	Roughness
Cutoff	λs =None λc =None
End effect correction	Enabled
Double gaussian	OFF
No. of sampling lengths	1

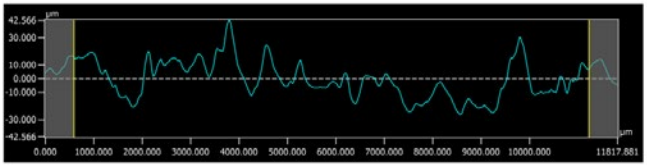
Measurement result

No.	Measurement name	Measured value	Unit
1	Ra	11.362	μm
2	Rz	68.925	μm

Total profile



Roughness/Primary/Waviness profile



Measurement date and time: 24/01/2023 16:12:40

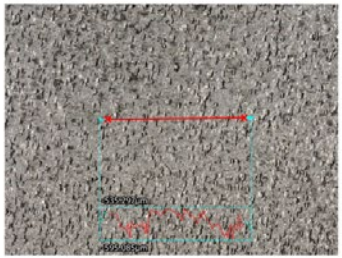
Measurement conditions: 12x Auto



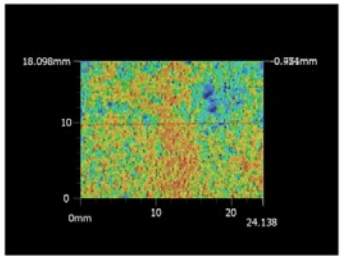
REMOVAL OF EPOXY SILOXANE

Line roughness measurement 7. Epoxy siloxane- BB-033 KEYENCE VR-5000 series

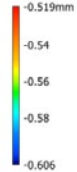
Main image



3D image



Height color



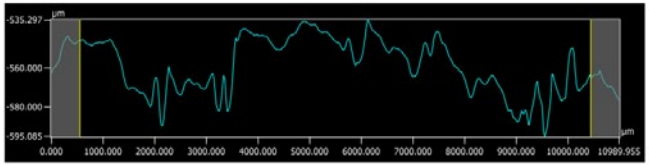
Analysis condition

Correct tilt	None
Measurement type	Roughness
Cutoff	λs =None λc =None
End effect correction	Enabled
Double gaussian	OFF
No. of sampling lengths	1

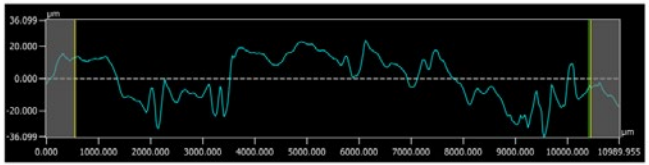
Measurement result

No.	Measurement name	Measured value	Unit
1	Ra	12.701	µm
2	Rz	59.787	µm

Total profile



Roughness/Primary/Waviness profile



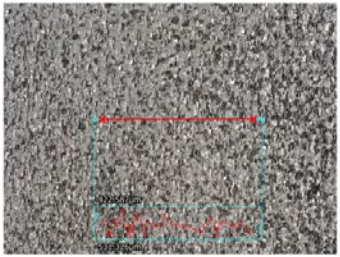
Measurement date and time: 24/01/2023 16:14:30
Measurement conditions: 12x Auto

BEFORE AFTER

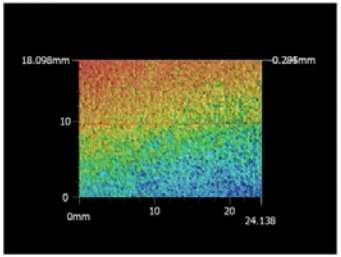
REMOVAL OF SILICONE ACRYLICS

Line roughness measurement 8. Silicone acrylic -bb-033 KEYENCE VR-5000 series

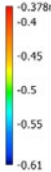
Main image



3D image



Height color



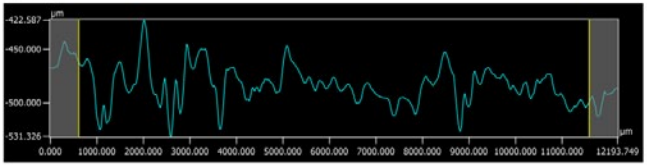
Analysis condition

Correct tilt	None
Measurement type	Roughness
Cutoff	λs =None λc =None
End effect correction	Enabled
Double gaussian	OFF
No. of sampling lengths	1

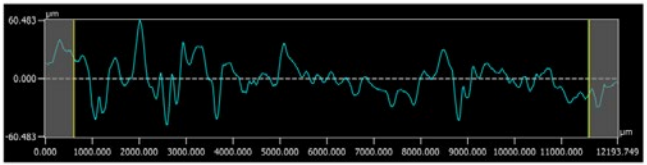
Measurement result

No.	Measurement name	Measured value	Unit
1	Ra	13.292	μm
2	Rz	108.739	μm

Total profile

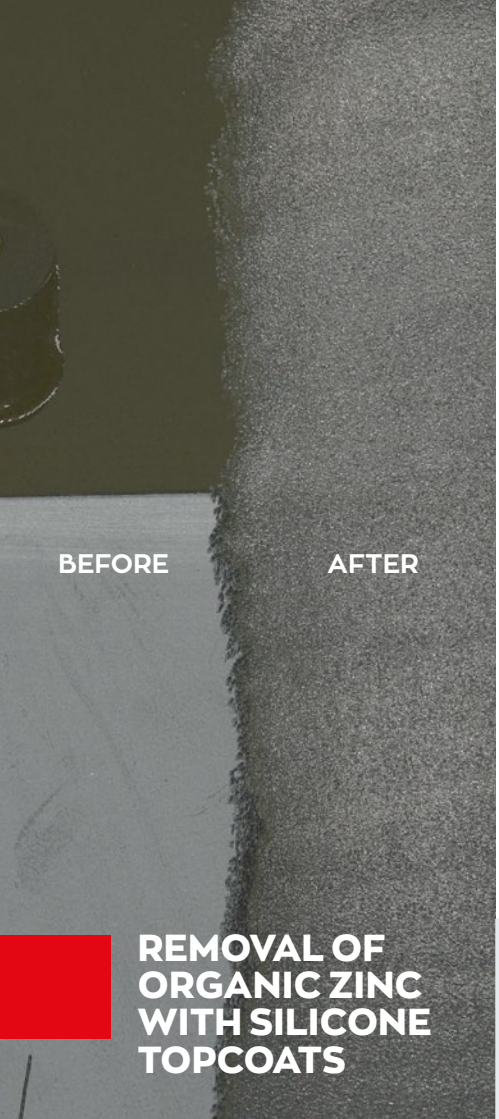


Roughness/Primary/Waviness profile



Measurement date and time: 24/01/2023 16:16:23

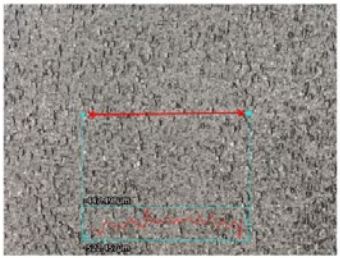
Measurement conditions: 12x Auto



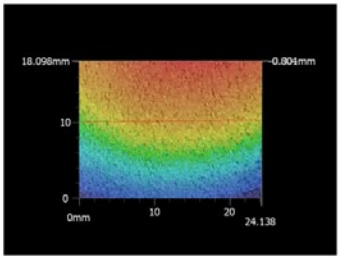
REMOVAL OF ORGANIC ZINC WITH SILICONE TOPCOATS

Line roughness measurement 9. organic zinc silicon top bb-033 KEYENCE VR-5000 series

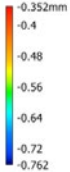
Main image



3D image



Height color



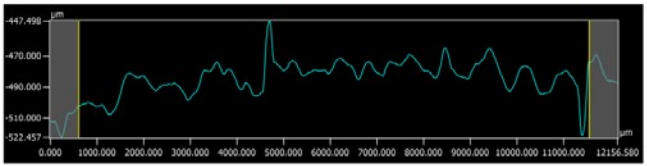
Analysis condition

Correct tilt	None
Measurement type	Roughness
Cutoff	λs =None λc =None
End effect correction	Enabled
Double gaussian	OFF
No. of sampling lengths	1

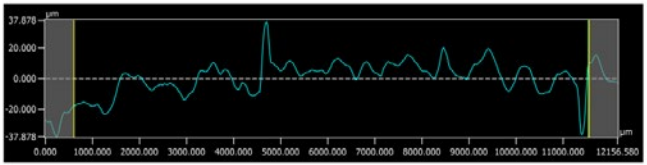
Measurement result

No.	Measurement name	Measured value	Unit
1	Ra	8.161	μm
2	Rz	73.530	μm

Total profile



Roughness/Primary/Waviness profile



Measurement date and time: 24/01/2023 16:18:34

Measurement conditions: 12x Auto

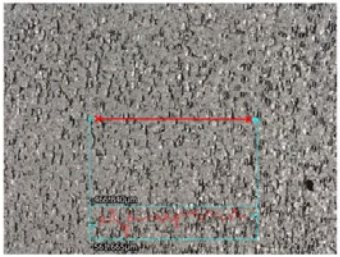
BEFORE

AFTER

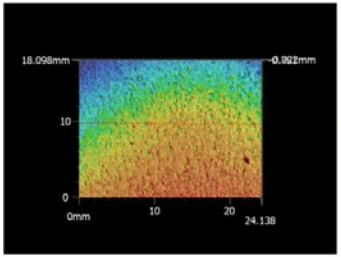
REMOVAL OF NORSOK 2 LAYER

Line roughness measurement 10. NORSOK 2layer BB-033 KEYENCE VR-5000 series

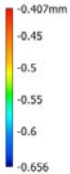
Main image



3D image



Height color



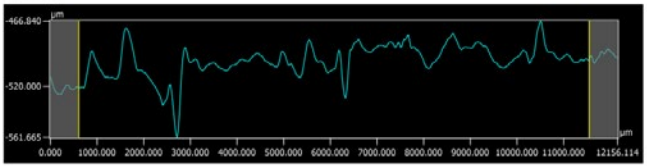
Analysis condition

Correct tilt	None
Measurement type	Roughness
Cutoff	λs =None λc =None
End effect correction	Enabled
Double gaussian	OFF
No. of sampling lengths	1

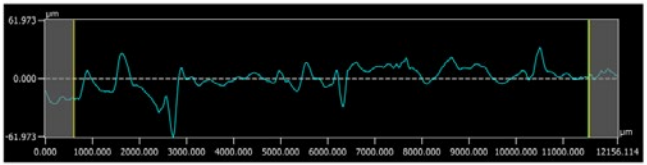
Measurement result

No.	Measurement name	Measured value	Unit
1	Ra	9.626	μm
2	Rz	94.825	μm

Total profile



Roughness/Primary/Waviness profile



Measurement date and time: 24/01/2023 16:23:30

Measurement conditions: 12x Auto

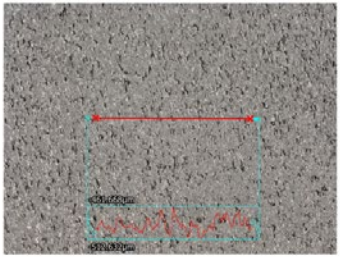
BEFORE

AFTER

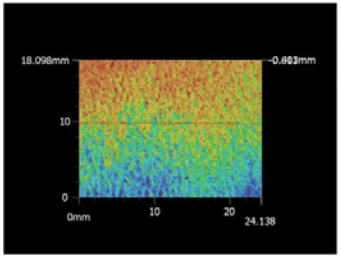
REMOVAL OF MILLSCALE RUSTGRADE A

Line roughness measurement 11. Millscale Rustgrade A BB-033 KEYENCE VR-5000 series

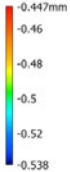
Main image



3D image



Height color



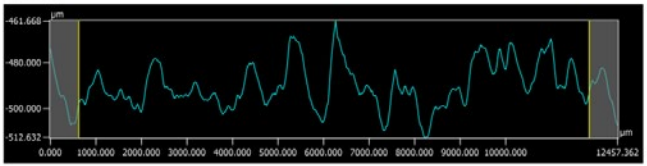
Analysis condition

Correct tilt	None
Measurement type	Roughness
Cutoff	λs =None λc =None
End effect correction	Enabled
Double gaussian	OFF
No. of sampling lengths	1

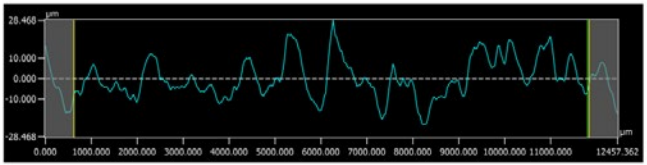
Measurement result

No.	Measurement name	Measured value	Unit
1	Ra	7.682	μm
2	Rz	50.965	μm

Total profile



Roughness/Primary/Waviness profile



Measurement date and time: 24/01/2023 16:25:42

Measurement conditions: 12x Auto

BEFORE

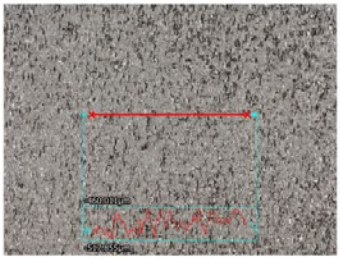
AFTER

REMOVAL OF MILLSCALE RUSTGRADE B

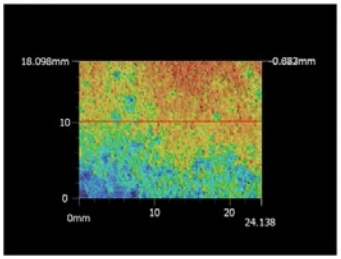
Line roughness measurement 12. Millscale Rustgrade B - BB-033

KEYENCE VR-5000 series

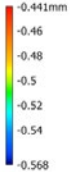
Main image



3D image



Height color



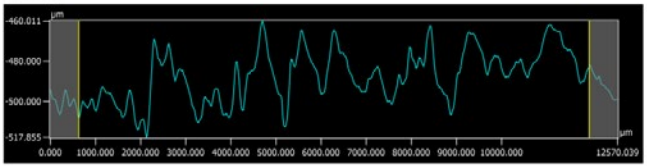
Analysis condition

Correct tilt	None
Measurement type	Roughness
Cutoff	λs =None λc =None
End effect correction	Enabled
Double gaussian	OFF
No. of sampling lengths	1

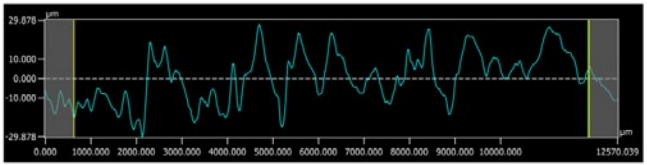
Measurement result

No.	Measurement name	Measured value	Unit
1	Ra	10.727	μm
2	Rz	57.844	μm

Total profile



Roughness/Primary/Waviness profile



Measurement date and time: 24/01/2023 16:27:38

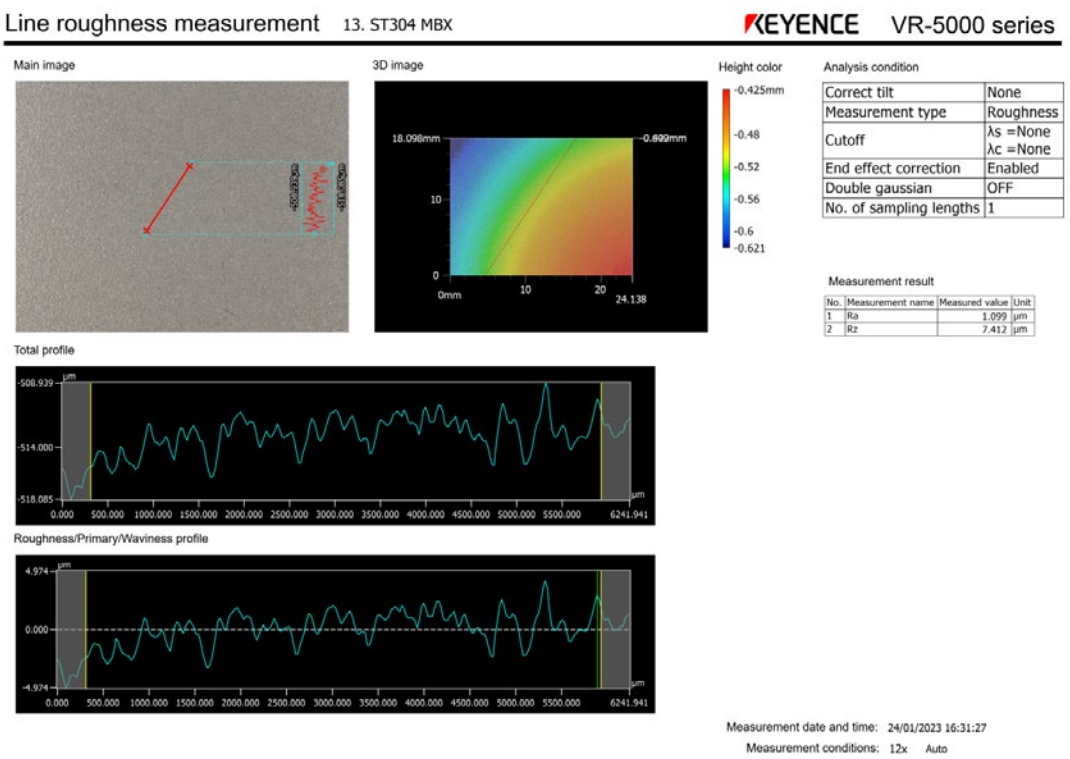
Measurement conditions: 12x Auto



BEFORE

AFTER

REMOVAL OF ST304



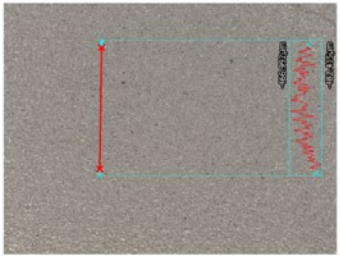


BEFORE AFTER

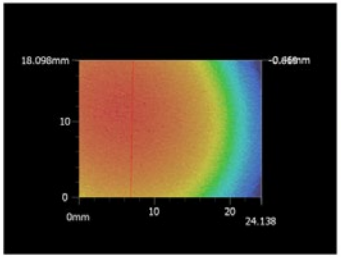
REMOVAL OF STAINLESS 304

Line roughness measurement 14. Stainless 304 BB-102 KEYENCE VR-5000 series

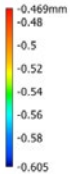
Main image



3D image



Height color



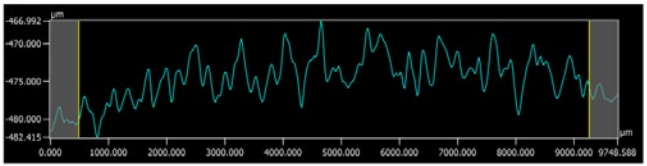
Analysis condition

Correct tilt	None
Measurement type	Roughness
Cutoff	λs =None λc =None
End effect correction	Enabled
Double gaussian	OFF
No. of sampling lengths	1

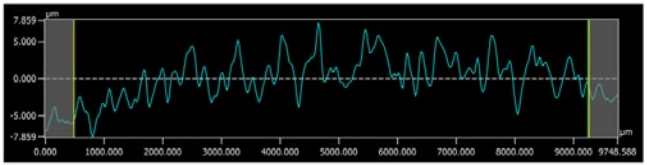
Measurement result

No.	Measurement name	Measured value	Unit
1	Ra	2.243	μm
2	Rz	15.422	μm

Total profile



Roughness/Primary/Waviness profile



Measurement date and time: 24/01/2023 17:11:57

Measurement conditions: 12x Auto

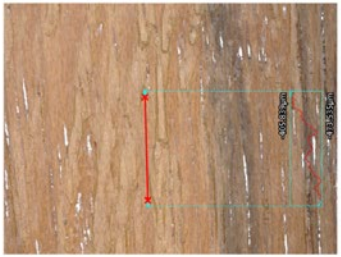


WOOD CLEANING AND ROUGHENING

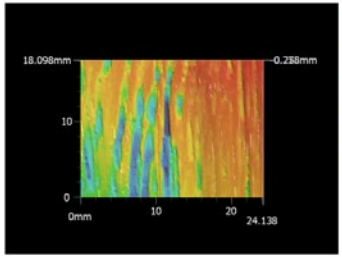
Line roughness measurement 16. Wood

KEYENCE VR-5000 series

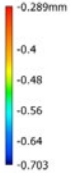
Main image



3D image



Height color



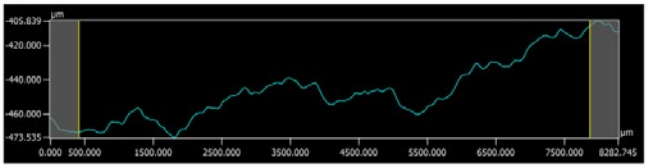
Analysis condition

Correct tilt	None
Measurement type	Roughness
Cutoff	λs =None λc =None
End effect correction	Enabled
Double gaussian	OFF
No. of sampling lengths	1

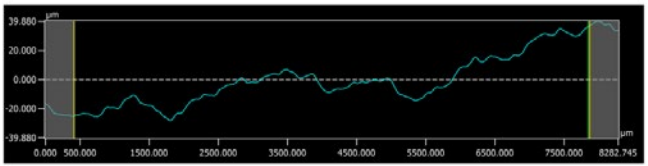
Measurement result

No.	Measurement name	Measured value	Unit
1	Ra	12.980	μm
2	Rz	63.699	μm

Total profile



Roughness/Primary/Waviness profile



Measurement date and time: 24/01/2023 17:22:40

Measurement conditions: 12x Auto

BEFORE

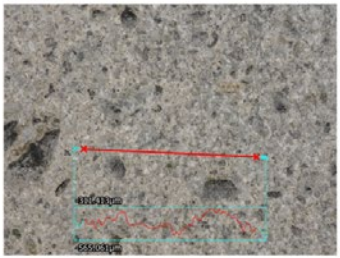
AFTER

REMOVAL OF CONCRETE

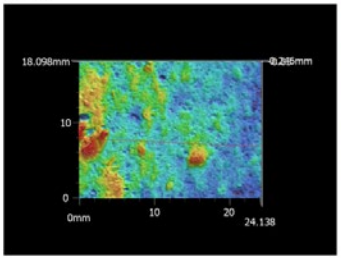
Line roughness measurement 17. concrete BB033

KEYENCE VR-5000 series

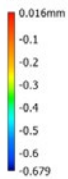
Main image



3D image



Height color



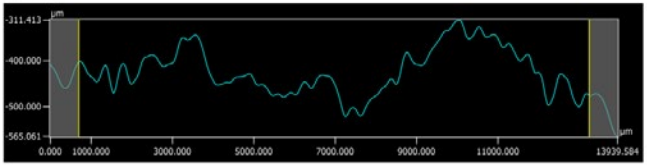
Analysis condition

Correct tilt	None
Measurement type	Roughness
Cutoff	λs =None λc =None
End effect correction	Enabled
Double gaussian	OFF
No. of sampling lengths	1

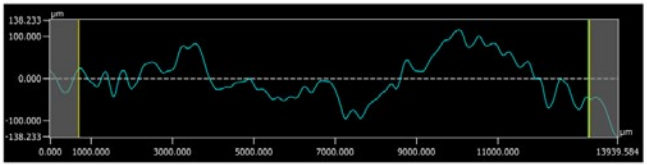
Measurement result

No.	Measurement name	Measured value	Unit
1	Ra	40.885	μm
2	Rz	210.208	μm

Total profile

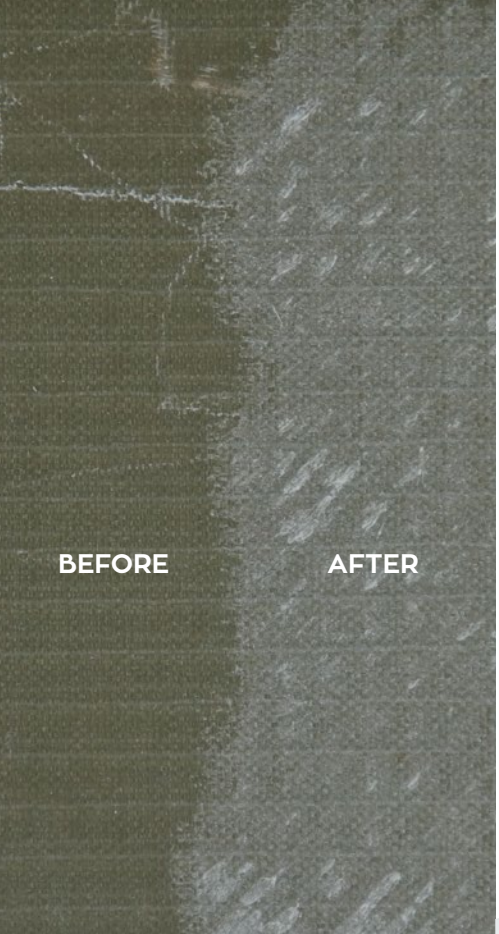


Roughness/Primary/Waviness profile



Measurement date and time: 24/01/2023 17:25:56

Measurement conditions: 12x Auto



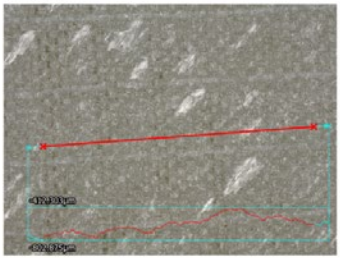
BEFORE AFTER

REMOVAL OF COMPOSITE

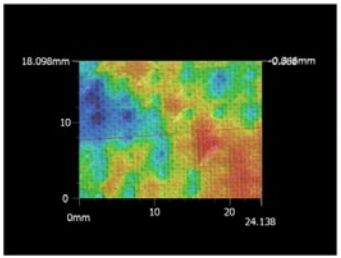
Line roughness measurement 18. Composite

KEYENCE VR-5000 series

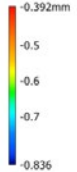
Main image



3D image



Height color



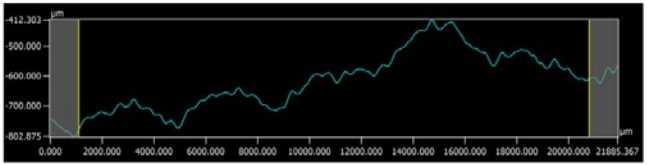
Analysis condition

Correct tilt	None
Measurement type	Roughness
Cutoff	λs =None λc =None
End effect correction	Enabled
Double gaussian	OFF
No. of sampling lengths	1

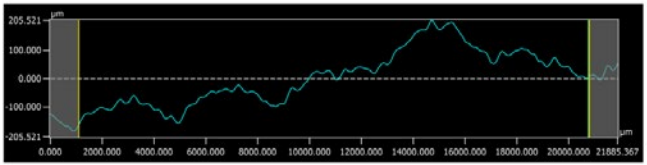
Measurement result

No.	Measurement name	Measured value	Unit
1	Ra	81.473	μm
2	Rz	365.527	μm

Total profile



Roughness/Primary/Waviness profile



Measurement date and time: 24/01/2023 17:29:09

Measurement conditions: 12x Auto

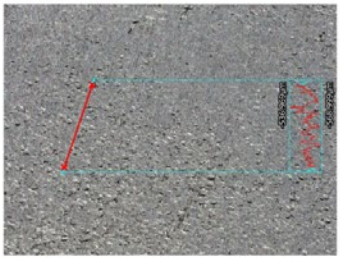


REMOVAL OF ZINC REMAINS

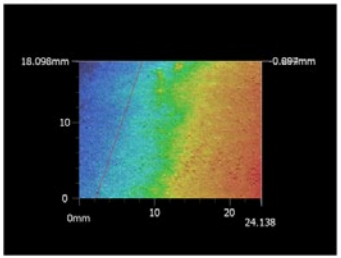
Line roughness measurement 19. Zinc MBX (zinc remains)

KEYENCE VR-5000 series

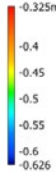
Main image



3D image



Height color



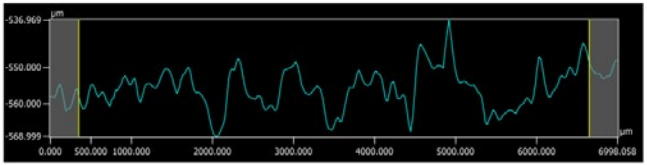
Analysis condition

Correct tilt	None
Measurement type	Roughness
Cutoff	λs =None λc =None
End effect correction	Enabled
Double gaussian	OFF
No. of sampling lengths	1

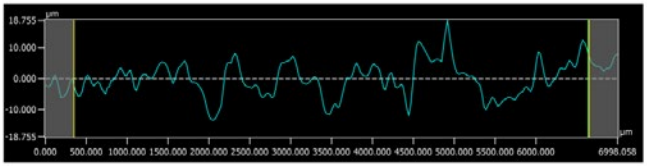
Measurement result

No.	Measurement name	Measured value	Unit
1	Ra	4.401	μm
2	Rz	32.030	μm

Total profile



Roughness/Primary/Waviness profile



Measurement date and time: 24/01/2023 17:32:45

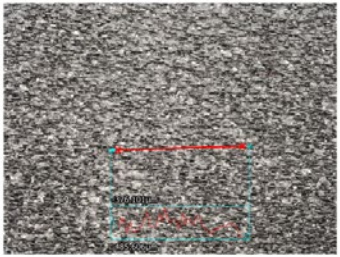
Measurement conditions: 12x Auto



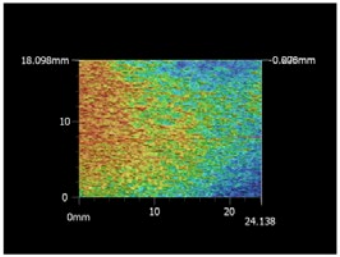
REMOVAL OF INORGANIC ZINC

Line roughness measurement 20. Zinc BB033 (zinc removal) KEYENCE VR-5000 series

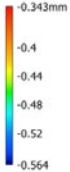
Main image



3D image



Height color



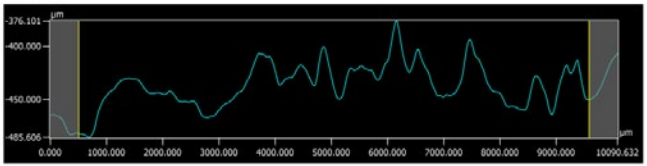
Analysis condition

Correct tilt	None
Measurement type	Roughness
Cutoff	λs =None λc =None
End effect correction	Enabled
Double gaussian	OFF
No. of sampling lengths	1

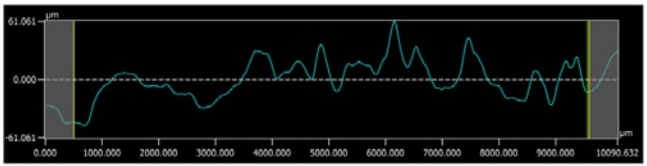
Measurement result

No.	Measurement name	Measured value	Unit
1	Ra	15.958	μm
2	Rz	109.505	μm

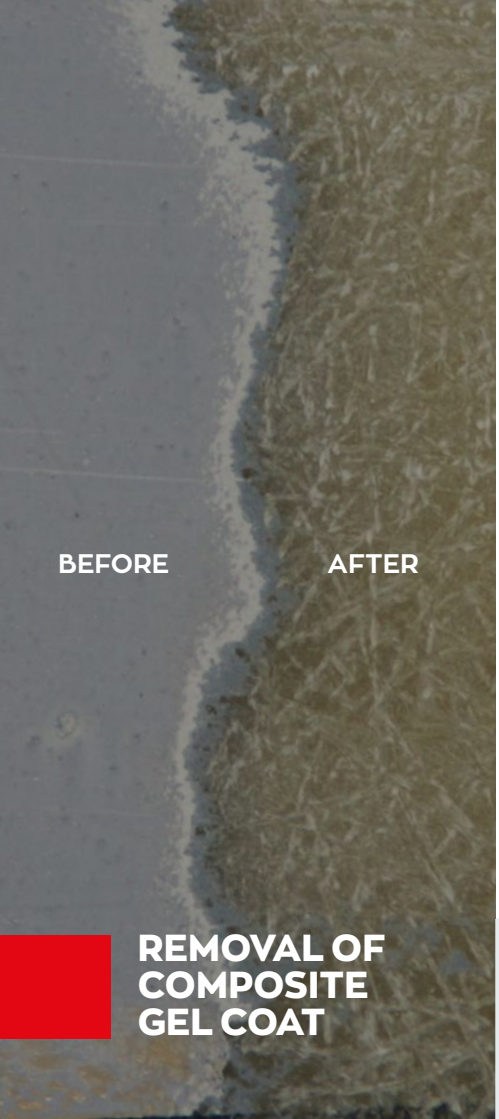
Total profile



Roughness/Primary/Waviness profile



Measurement date and time: 24/01/2023 17:35:56
Measurement conditions: 12x Auto

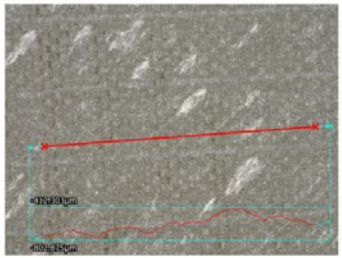


REMOVAL OF COMPOSITE GEL COAT

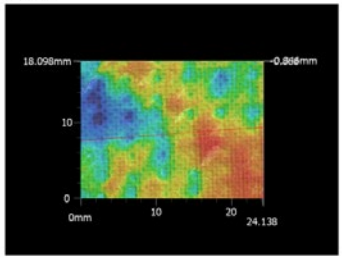
Line roughness measurement 18. Composite

KEYENCE VR-5000 series

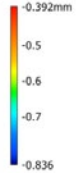
Main image



3D image



Height color



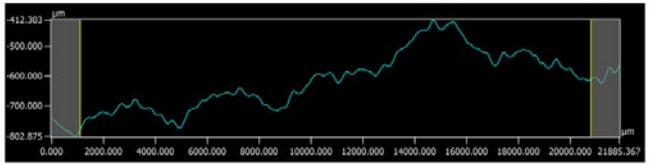
Analysis condition

Correct tilt	None
Measurement type	Roughness
Cutoff	λs =None λc =None
End effect correction	Enabled
Double gaussian	OFF
No. of sampling lengths	1

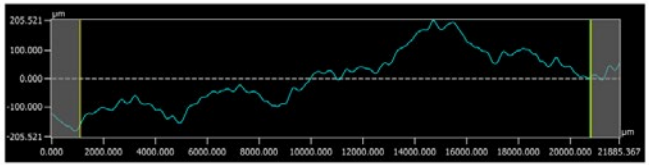
Measurement result

No.	Measurement name	Measured value	Unit
1	Ra	81.473	μm
2	Rz	365.527	μm

Total profile



Roughness/Primary/Waviness profile



Measurement date and time: 24/01/2023 17:29:09

Measurement conditions: 12x Auto

PREPARATION FROM SCRATCH

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