

PRODUCT OVERVIEW

PMET 590 is specifically designed for spraying in arc spray or flame spray systems. It produces extremely well-bonded coatings with excellent machinability. PMET 590 has good corrosion resistance, along with good resistance to mechanical and thermal shock. It is particularly applicable to bond coats and machine element restoration work.

TYPICAL DEPOSIT CHARACTERISTICS:

⇒ Corrosion Resistance:	Good
⇒ Typical Hardness:	HRB 67
⇒ Bond Strength:	7000 psi
⇒ Deposit Rate:	10 lbs/hr/100A
⇒ Deposit Efficiency	75%
⇒ Wire Coverage:	0.9 oz/ft ² / mil
⇒ Surface Texture	*Variable
⇒ Machinability	Good

* Depends on air pressure used

SURFACE PREPARATION

Surface should be clean, white metal, with no oxides (rust), dirt, grease, or oil on the surface to be coated. **Note:** It is best not to handle surfaces after cleaning.

Recommended method of preparation is to grit blast with 24 mesh aluminum oxide, rough grind, or rough machine in a lathe.

APPLICATION

- ⇒ Aluminum Bronze Components
- ⇒ Bond Coat
- ⇒ Bearing Areas

NOMINAL CHEMICAL COMPOSITION (wt%)

Al	Fe	Cu
9.0	1.5 max	Bal

RECOMMENDED SPRAY PARAMETERS:

Diameter	Air Pressure	Voltage	Amperage	Standoff
1/16" (1.6mm)	*50-60 psi	*29-31	*100-200	*3-6 in (8-15 cm)

Parameters are typical for most arc spray systems. Contact the equipment manufacturer for specific system parameters

STANDARD SIZES & PACKAGING:

Diameter	Packaging	Part Number
1/16" (1.6mm)	25 lb LWS	590062LWS01
1/8 " (3.2mm)	25 lb COIL	590125COIL01