

# NapGard® Process Overview

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## 1. Flowchart of the Coating Process



## 2. Customer Part received

- 2.1. Inspect all parts upon receipt for mechanical damage (e.g. Threads) and advise customer if any observed.
- 2.2. Part is compared to Customer's Order Entry Form to ensure proper quantity, part description and part material.
- 2.3. NapGard® version, thickness and colour are confirmed (standard thickness and colour given in brackets)
  - 2.3.1. NG65 – 7-0014 (**Thickness:** 3.0 to 10 mils, **Colour(s):** Red or Green)

## 3. Cleaning and Inspection

- 3.1. Verify areas that require NapGard® applied. Areas requiring NapGard® must be free of slag or scale. Surface finish of 125µin or better is recommended to ensure proper coating of part.
- 3.2. Part must be cleaned and dried prior to NapGard® process. All areas subjected to NapGard® process must be cleaned using Burn off oven, pressure washer, and/or bead blaster.

## 4. Preparation

- 4.1. Specific areas that do not require coating are masked off. This is accomplished using platers tape, plugs or other masking agents.
- 4.2. The parts are hung using appropriate hanging methods depending on the geometry of the parts, ensuring minimal contact on the parts causing improper coating coverage.

## 5. Plating Procedure

- 5.1. Parts are placed on rack and preheated to appropriate coating temperature
- 5.2. NapGard® coating is applied hot, and to desired thickness

## 6. Inspection

- 6.1. A 100% visual inspection of part is performed to make sure there is no pits, cracks, spalling or blistering in the coating; this includes areas that required and did not require plating as well as any mechanical damage that may have occurred. If parts fail to meet criteria, then part is stripped and re-processed.

## 7. Final sign off

- 7.1. All NapGard® paperwork is to be completed at this time, if final process step, parts are then marked complete