GTV MINI SPRAY JET

**Lowering costs - Saving materials -
Protecting surfaces**

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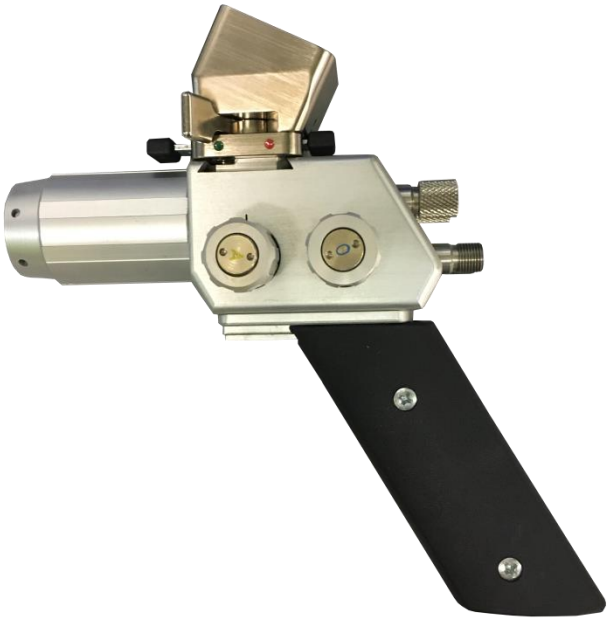
Approved torch concept for universal use in wear and corrosion protection as well as repair.

Metal powder coating
for thermal spraying with self-fluxing, metallic and ceramic oxide powders

Corrosion protection coating
on the basis of low melting metal flame spray powders, e.g. zinc and aluminium

Plastic coating
using various thermoplastics (PA, PP, PE)

The equipment is delivered in a heavy duty aluminium box containing the necessary accessories for the various fields of application. Due to the modular design the basic equipment can be retrofitted for all applications. Surface protection against wear and corrosion can be ensured using GTV powders for various applications.



Benefits	
✓	integrated powder feed system
✓	safe function and operation using an approved gas mixing system prohibiting flame and ignition flash backs
✓	over-head position using a removable powder module connection head revolved by 180°
✓	free choice of inert gas feed due to an integrated switch
✓	operating gases: acetylene, propane, oxygen, hydrogen, ethene
✓	cooling gas: compressed air

We would be glad to provide you with an offer adapted to your application and look forward to your request.

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Technical data

Gas supply

Main supply:

▪ Oxygen			2,5 bar - 1,5 m^3/h
▪ Acetylene			0,5 bar - 1,1 m^3/h
▪ Hydrogen			0,8 bar – 1,2 m^3/h

Internal powder feed gas

▪ Pressure nozzle N	0,45 mm	oxygen	2,5 bar – 0,3 m^3/h
▪ Pressure nozzle S	0,30 mm	oxygen	2,5 bar – 0,1 m^3/h

Optionally: external powder feed gas (non-flammable gases)
Inert gas, active gases, compressed air etc. 0,5 bar - 5,0 bar

Fuel gas-Oxygen-Mixture

Injector principle (gas-mixing spray and heating nozzle)

Hose fittings

Fuel gases and internal powder gas

▪ Fuel gases (acetylene, propane or hydrogen)	G1/8“ LH
▪ Oxygen	G1/8“ RH

Optionally:
Accessory gases (non-flammable gases)

▪ Inert gas (Ar, N2), active gases, compressed air	G1/8“ RH

Optionally:
External powder feed gas (non-flammable gases)

▪ Inert gas (Ar, N2), active gases, compressed air	G1/8“ RH

Spray rate

Depending on powder material type, system setup and spray nozzle as well as on installed pressure nozzle in the powder feed system: 1,0 - 12,0 kg/h

Spray distance

Depending on spray powder (see spraying tables): 100 - 200 mm

Surface speed

(For cylindrical or rotationally symmetrical workpieces) depending on powder material type and layer thickness per pass: 15 –50 m/min

Feed per rotation

▪ Bondcoat 20.50.2 (NiAl)	4,0 - 6,0 mm/rev
▪ for all other self-bonding powders and metal powders	4,0 - 8,0 mm/rev
▪ for metal oxide powders (ceramics) depending on single layer or multi layer	0,02 - 0,5 mm/rev

Layers growth per pass

▪ Bondcoat 20.50.2 (NiAl)	ca. 0,15 mm/pass
▪ top coat using other self-bonding powders n	ca. 0,2 mm/pass
▪ metal powder	ca. 0,2 - 0,3 mm/pass
▪ metal oxide powder	ca. 0,05 - 0,2 mm/pass