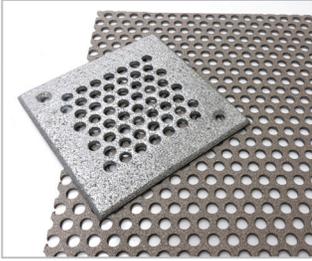


FABRICATING SUGGESTIONS FOR SLIPNOT® MATERIAL

Fabrication is best performed prior to SlipNOT® surface application. SlipNOT® does not recommend any fabrication of products after galvanizing. SlipNOT® products can however be treated similar to their smooth plate counterparts when fabricating. Material can generally be sheared, flame/torch cut, laser cut, water-jetted, plasma cut or welded, either directly or from the opposite side, without adversely effecting the SlipNOT® surface. The SlipNOT® surface bonds at over 4,000 psi and results in a hardened surface between 55 – 63 on the Rockwell “C” Scale.

The following is intended as a general informational guideline and may not account for all types of fabrication or installations. Please contact a SlipNOT® representative for additional information.



DRILLING

SlipNOT® material can be drilled and countersunk in most situations. Generally, due to the resulting surface hardness, pre-drilling material prior to the SlipNOT® application is recommended. Pre-drilled holes, countersinks, and counter bores are protected from the SlipNOT® process so screws/bolts will sit flush. Due to the surface hardness, if fabrication is done after SlipNOT® application, additional time and tooling costs should be figured into estimating and labor costs.



SHEARING

Due to the unique random stacked hatch matrix of the SlipNOT® surface, plates can usually be sheared. It is recommended that SlipNOT® material be flame, plasma, laser, or water-jet cut to save wear and tear on tooling. Plates can also be sheared from the non-slip side to help minimize dulling of the shear blades, however, the roughened, hardened SlipNOT® surface can scratch shear tables.



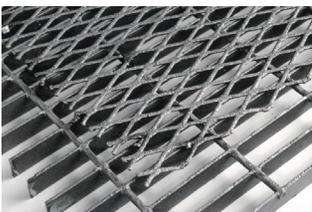
FLAME/PLASMA

The unique SlipNOT® surface is bonded to substrates at over 4,000 psi and cutting with flame / plasma is no different than with smooth plates. This is the preferred method for fabricating SlipNOT® material with proper execution. The random matrix surface will not flake or delaminate along burn lines and will not be harmed by any standard burning operation.



LASER CUT

The random stacked hatch matrix surface of the SlipNOT® will add approximately 0.020” – 0.030” to any given substrate. These materials will not harm the optics of laser cutters so SlipNOT® materials can most often be treated exactly the same as non-SlipNOT® treated pieces. The laser will not harm the SlipNOT® surface in any way and the SlipNOT® surface will not damage any laser equipment.



WELDING

SlipNOT® is an all-metal, grit-free surface. Welding is generally performed exactly the same as required for the non-SlipNOT® treated counterparts. In most cases, no special requirements are needed. Heat distortions and discolorations from any welding will be transmitted through the SlipNOT® surface and should be taken into account if aesthetics are critical to your project. Mounting angles or other such material can be pre-welded to materials and used as weld points during the installation process; minimizing the chances of surface blemishes. SlipNOT® does not recommend welding galvanized products.



SURFACE MASKING / DETAILING

SlipNOT® is a molten metal plasma stream deposition and areas can be masked / protected from surface coating. In cases of stair treads, risers and nosings are masked and only the tread surface itself receives the SlipNOT® application. Logos, words, or patterns can also be created within the SlipNOT® surface application however, there can be additional costs associated with these procedures. For welded installations, small borders can be masked for easier metal working.