



## TH520 Aluminum Bronze

### DESCRIPTION

TH520 or Aluminum Bronze produces extremely well-bonded coatings with excellent Machine-ability. TH520 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:

- Bond Strength 7000 psi
- Typical Hardness HRB 67
- Deposit Rate 18-65 lbs. per hr.
- Deposit Efficiency 60-70%
- Wire Coverage 4 sq. ft. per lbs. at 8-10 mils thick
- Surface Finish Textured

### 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. \*Thermion recommends a 3.5 mil minimum anchor tooth profile.

### Applications:

- Aluminum Bronze Components
- Bond Coat
- Bearing Areas

### NOMINAL CHEMICAL COMPOSITION (wt. %):

Al	Fe	Cu
9.22	.86	Bal

### RECOMMENDED SPRAY PARAMETERS:

Diameter	Air Pressure	Voltage	Amperage	Standoff
1/16" (1.6mm)	80-100 psi	28-32	100-300	4-7" (10-17cm)

Parameters are typical and may vary depending on equipment used.

### STANDARD SIZES & PACKAGING:

Diameter	Packaging
1/16" (1.6mm)	25#