



工程指示 / 要求簡箋(E.I.)

工程指示編號：EI / 5136 / 22 修改版次：-
 工程編號 : J - 858 工程名稱 : 將軍澳日出康城 11
 工程項目 : 幕牆 / 趟門 鐵件 鉛水厚度指示
 收件人 : Maggie / 王良 發件人 : Ant Yeung 日期 : 22/09/2022

要求提供 / 確認 事項 :

- | | | |
|------------------------------------|-------------------------------------|-------------------------------|
| <input type="checkbox"/> 初步鋁料 B.M. | <input type="checkbox"/> 加工拆圖，然後生產 | <input type="checkbox"/> 尺寸表 |
| <input type="checkbox"/> 正式鋁料 B.M. | <input type="checkbox"/> 技術上資料 / 指示 | <input type="checkbox"/> 報價 |
| <input type="checkbox"/> 配件 B.M. | <input type="checkbox"/> 樣辦或貨品說明書 | <input type="checkbox"/> 分判合約 |

內容 :

因應 Tender 顧問標準要求。現時本地盆的其他分判商，因被鉛水厚度不足，被要求執修和更換。請按要求，鉛水厚度為 100 um。

由即就日起，本工程所有未浸鉛水的，需附合此標準的要求。

已浸的，不返手。

少於 3mm 的厚度的鐵件，可以豁免此要求。

請在 2022.09.23 前完成上列要求。

附：1 頁

以上項目為:

- 原合約工程包 原合約工程加 / 減賬 新工程報價

原因：-

分發東莞各部門：

- | | | | |
|--|---|--|--|
| <input type="checkbox"/> 生產技術總監 <input type="checkbox"/> 連附件 | <input type="checkbox"/> 技術部 <input type="checkbox"/> 連附件 | <input type="checkbox"/> 生產部 <input type="checkbox"/> 連附件 | <input type="checkbox"/> 機械設計部 <input type="checkbox"/> 連附件 |
| <input type="checkbox"/> 採購部 <input type="checkbox"/> 連附件 | <input type="checkbox"/> 生產統籌部 <input type="checkbox"/> 連附件 | <input type="checkbox"/> 小羅&清 <input type="checkbox"/> 連附件 | |
| <input type="checkbox"/> 質檢部 <input type="checkbox"/> 連附件 | <input type="checkbox"/> 會計部 <input type="checkbox"/> 連附件 | <input type="checkbox"/> 報關組 <input type="checkbox"/> 連附件 | <input type="checkbox"/> 其他 _____ <input type="checkbox"/> 連附件 |

分發其他分判：

- 水洪 連附件

分發香港各部門：

- | | | | |
|---|--|---|--|
| <input type="checkbox"/> 行政部 <input type="checkbox"/> 連附件 | <input type="checkbox"/> 會計部 <input type="checkbox"/> 連附件 | <input type="checkbox"/> 統籌部 <input type="checkbox"/> 連附件 | <input type="checkbox"/> 工程部地盤科文 <input type="checkbox"/> 連附件 |
| <input type="checkbox"/> 採購部 <input type="checkbox"/> 連附件 | <input type="checkbox"/> QS 部 <input type="checkbox"/> 連附件 | <input type="checkbox"/> 維修部 <input type="checkbox"/> 連附件 | <input type="checkbox"/> 其他 _____ <input type="checkbox"/> 連附件 |

傳遞編號：

HK 1648 / 22

發件人簽署：

項目經理簽署：

- #1
2. Aluminium surface to which structural silicone will be adhered shall have a finish which demonstrates by test the ability to satisfy specified requirements. Subject to demonstrated effectiveness by satisfactory testing, acceptable finishes are as follows.
- a) A Kynar 500 paint conforming to AAMA 2605.2.
- b) Alodine conversion coating. The product used to form the alodine chemical conversion coating on aluminium extrusions or paneling shall conform with ASTM D1730, Type B, method 5 (amorphous chromium phosphate treatment) or method 7 (amorphous chromate treatment). Coating weight of chemical conversion coating shall conform with that specified in ASTM B449, section 6, class 1. Processing shall conform with that specified in ASTM B449, section 5.
- c) Architectural Class I anodizing conforming to AAMA 607.1 or 606.1
- △45°
鋼門塗料

E. Protective Coatings for Metals

1. For Carbon Steel

a) CONCEALED STEELWORK IN DRY ZONE

Concealed steelwork in dry zone is to be Hot Dip Galvanised with a minimum dry film thickness of 70 microns to BS EN ISO 1461.

b) EXPOSED STEELWORK IN DRY ZONE

- (00 um)
- i) The coating system is to be by Dulux, Taubmans, Coultards, or the Architect Approved equivalent suitable for internal surfaces and wear from impact and traffic as necessary.
- ii) The coating system shall comply with the following minimum requirements:
- Surface preparation - Blast Cleaned to Sa 2.5 in accordance with BS 7079 Part A1.
 - Primer: 2-pack zinc rich primer with 75-micron minimum dry film thickness.
 - Barrier Coat - Two pack epoxy Micaceous Iron Oxide (MIO), 100-micron minimum dry film thickness, conventionally sprayed.
 - Finish Coat - 2-pack recoatable polyurethane coats finishing coat, applied in 2 coats with minimum dry film thickness = 100 micron. Colour and finish to match adjacent Footbridge and subject to Architects approval.
- iii) Paint samples, technical catalogues and Manufacturer's Application Procedures are to be submitted for Approval before commencement of paint application.

c) CONCEALED STEELWORK IN WET ZONE

i) Concealed steelwork in wet zone is to be Hot Dip Galvanised with a minimum dry film thickness of 100 microns to BS EN ISO 1461.

d) EXPOSED STEELWORK IN WET ZONE

The coating system is to be by Dulux, Taubmans, Coultards, or the Lead Consultant Approved equivalent suitable for external surfaces and wear from UV, pollution (including acid rain), impact and traffic as necessary.

The coating system shall comply with the following minimum requirements:

- Surface preparation - Blast Cleaned to Sa 2.5 in accordance with BS 7079 Part A1.
 - Primer: 2-pack zinc rich primer with 75-micron minimum dry film thickness.
 - Barrier Coat - Two pack epoxy Micaceous Iron Oxide (MIO), 100-micron minimum dry film thickness, conventionally sprayed.
- △

6.3 Renovation

The total uncoated areas for renovation by the galvanizer shall not exceed 0,5 % of the total surface area of the component. Each uncoated area for renovation shall not exceed 10 cm². If uncoated areas are larger, the article containing such areas shall be regalvanized, unless otherwise agreed between the purchaser and the galvanizer.

Renovation shall be by thermal zinc spraying (for example ISO 2063 [2]) or by a suitable zinc-rich paint where the zinc dust pigment conforms to ISO 3549 within the practical limits of such systems, or by suitable zinc-flake or zinc-paste products. The use of a zinc alloy stick is also possible (see Annex C).

Where the purchaser advises a special requirement (e.g. a paint coating is to be applied subsequently), the proposed renovation procedure shall be advised in advance to the purchaser by the galvanizer.

The treatment shall include the removal of any scale, cleaning and any necessary pretreatment to ensure adhesion.

The coating thickness on the renovated areas shall be a minimum of 100 µm unless the purchaser advises the galvanizer otherwise, for example, when the galvanized surface is to be over-coated and the thickness for renovated areas is to be the same as for the hot dip galvanized coating. The coating on the renovated areas shall be capable of giving sacrificial protection to the steel to which it is applied.

NOTE See also Annex C for advice on repair of damaged areas.

6.4 Adhesion

No suitable International Standards currently exist for testing the adhesion of hot dip galvanized coatings on fabricated iron and steel articles.

Adhesion between zinc and basis metal does not generally need to be tested as adequate bonding is characteristic of the galvanizing process and the coated work should be able to withstand, without peeling or flaking, handling consistent with the nature and thickness of the coating and the normal use of the article. In general, thicker coatings require more careful handling than thinner coatings. Bending or forming after hot dip galvanizing are not considered to be normal handling.

Where adhesion tests are required by the purchaser, any such test should be agreed by the galvanizer and the purchaser prior to the work being galvanized. Should it be necessary to test the adhesion, for example, in the case of workpieces that are to be subject to high mechanical stresses, any test shall only be on significant surfaces, i.e. in areas in which good adhesion is important for the proposed application.

A cross-hatch test (e.g. according to ISO 16276-2 [9]) will give some guidance on the mechanical properties of the coating but, in some cases, may be more demanding than the application requires. Other impingement tests and cutting tests may also be developed for hot dip galvanized coatings and will be further considered for possible eventual issue as a separate document.

6.5 Acceptance criteria

When tested in accordance with 6.2.2 for the appropriate number of reference areas given in 6.2.3, the coating thickness shall be not less than the values given in Table 3 or Table 4, as appropriate. Except in the case of dispute, the non-destructive test shall be used unless the purchaser specifically accepts that his articles may be cut for mass loss determinations. Where articles include a number of different thicknesses of steel, each thickness range shall be regarded as a separate article and the relevant values in Tables 3 and 4, as appropriate, shall apply.

If the thickness of coating on a control sample does not conform to these requirements, twice the original number of articles (or all the articles if that is the lesser number) shall be taken from the lot and tested. If this larger control sample passes, the whole inspection lot shall be accepted. If the larger control sample does not pass, the articles that do not conform to the requirements shall either be discarded or the purchaser may authorize them to be regalvanized.

以往原銀同標準



製作記錄

BS EN ISO 1461: 2009 中對非離心式浸鋅工件之鋅層標準：
Minimum Coating Masses (Related To Thickness) On Samples That Are Not Centrifuged.

工件及厚度 Article and its thickness	局部鋅層最低要求 Local coating (minimum)		平均鋅層最低要求 Mean coating (minimum)	
	g/m ²	μm	g/m ²	μm
鋼材厚度 (Steel's Thickness) < 1.5mm	250	35	325	45
1.5 mm ≤ 鋼材厚度 (Steel's Thickness) ≤ 3 mm	325	45	395	55
3 mm < 鋼材厚度 (Steel's Thickness) ≤ 6mm	395	55	505	70 → 100
鋼材厚度 (Steel's Thickness) > 6mm	505	70	610	85 → 100
生鐵鑄件厚度 (Casting's Thickness) < 6mm	430	60	505	70
生鐵鑄件厚度 (Casting's Thickness) ≥ 6mm	505	70	575	80

按合約顧問執行

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BS EN ISO 1461: 2009 中對離心式浸鋅工件之鋅層標準：
Minimum Coating Masses (Related To Thickness) On Samples That Are Centrifuged. ★

工件及尺寸 Article and its thickness	局部鋅層最低要求 Local coating (minimum)		平均鋅層最低要求 Mean coating (minimum)	
	g/m ²	μm	g/m ²	μm
螺紋工件： Articles with threads				
直徑 (Diameter) ≤ 6mm	145	20	180	25
直徑 (Diameter) > 6mm	285	40	360	50
其它離心式工件及生鐵鑄件： Other articles including castings				
< 3mm	250	35	325	45
≥ 3mm	325	45	395	55