

HOW TO FABRICATE SlipNOT®

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SlipNOT® Metal Safety Flooring products can be treated just like their smooth plate counterparts. Material can be sheared, flame/torch cut, laser cut, water-jetted, plasma cut or welded, either directly or from the opposite side, without harming the SlipNOT® surface. SlipNOT® can also be punched, drilled, countersunk and formed. However, the SlipNOT® process does harden the surface to over 55 on the Rockwell "C" Scale which will require hardened tooling such as carbide bits.

DRILLING/ PUNCHING - SlipNOT® material can be drilled, punched and countersunk. The SlipNOT® surface is hardened and will require carbide or tungsten hardened bits. Because of the surface hardness, additional time and tooling costs should be figured into estimating labor costs. The material can also be counter bored, however, the same conditions apply.

Generally, pre-drilling material prior to the SlipNOT® application is recommended. Holes, countersinks and counter bores are protected from the SlipNOT® process and surface so screws/bolts will sit flush.

SHEARING - Because of the unique random stacked hatch matrix of the SlipNOT® surface, plates can be sheared without harming the anti-slip surface. SlipNOT® will not flake off or delaminate, however, the surface is hardened to over 55 on the Rockwell "C" Scale and can be dulling to shear blades. Because of this, 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-SlipNOT® side to help minimize dulling of the shear blades, however, the roughened, hardened SlipNOT® surface can scratch shear tables/benches.

WELDING - Because SlipNOT® is an all metal, grit-free surface, welding is performed exactly as required for the smooth plate counterpart. No special requirements are needed. Since the surface is bonded at over 4,000 psi, the SlipNOT® will not flake, delaminate or distort from welding either directly to or from the opposite side. Heat distortions from any welding will be transmitted through the SlipNOT® surface as well and should be taken into account if aesthetics are critical to your project.

FLAME/PLASMA CUT - The unique SlipNOT® surface is bonded to substrates at over 4,000 psi and is Flame/Plasma cut no differently from smooth plates and grating. Since there is no blade or tooling dulling, this is the preferred method for fabricating SlipNOT® material. The random matrix surface will not flake or delaminate along burn lines and will not be harmed by any burning procedure.

LASER CUT - The random stacked hatch matrix surface of SlipNOT® will add approximately 0.020" - 0.030" to any given substrate. These materials will not harm the optics of laser cutters and can be treated exactly the same as regular plate and grating material. The laser will not harm the SlipNOT® surface in any way and the SlipNOT® surface will not damage any laser equipment.

FORMING - All SlipNOT® material can be formed, however, SlipNOT® generally recommends this procedure be performed prior to the surface application. Because of the surface hardness of over 55 on the Rockwell "C" Scale, SlipNOT® material can crack during a tight radius bend. While this is fairly rare, it should be noted. Also, because of the

SlipNOT®
Metal Safety Flooring

DIVISION OF THE W.S. MOLNAR COMPANY

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SlipNOT® Metal Safety Flooring Products are manufactured under U.S. Patents 4,961,973, & 5,077,137 and Canadian Patent 1,311,161

softer nature of Aluminum alloys, the SlipNOT® surface can be scarred where the Aluminum SlipNOT® contacts with the press dies.

As with drilling and shearing, the hardened SlipNOT® surface can be damaging to press brake dies. SlipNOT® recommends placing a thin gauge material between the press and surface to prevent damage.

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 nosing 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 significant costs associated with these procedures.

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