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Rocna and Vulcan Galvanized Steel Anchor Care: Re-Galvanizing

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GLANCHORCARE V1

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Thank you for your support of Rocna! Your Rocna or Vulcan anchor is designed with a durable hot-dip galvanized finish, which is intended to provide years of protection for your anchor.

We do, however, consider this a sacrificial finish, and one which eventually may wear to the point where it needs to be replaced. It is difficult to predict the expected lifetime of the galvanizing finish, since it depends strongly on both days of use as well as bottom composition. If you have any questions in this regard, please contact us at support@rocna.com

If you wish to re-galvanize your anchor, please follow these instructions carefully. Improper processing, particularly in the stripping process, can weaken the high-tensile shank.

To start the re-galvanizing process, the old finish needs to be stripped before the new one can be applied. Most galvanizing plants will do this by “stripping” the anchor with an extended dip in the “pickling” or acid wash. In the case of Rocna, however, the shank is high-tensile steel, and extended dips in an acid bath can negatively affect the shank steel. If the galvanizer knows what they are doing, it is possible to acid strip the anchor without affecting the shank but this requires a knowledgeable operator. Typically, they refer to this as a “flash pickle”.

Rather than chemical stripping, however, what we recommend is to have the anchor sandblasted to mechanically strip the old galvanizing down to bare steel, then re-galvanize.

It is still important that the galvanizing operator be informed about the high tensile shank, however, so that he does not “over-pickle” the anchor in the pre-galvanizing acid wash.

The main steps in the process are:

1. Remove all labels, stickers, and dirt.
 2. Make sure to also clean dirt from inside the roll-bar. A stiff bottle brush or pipe cleaner with a flexible handle can be used. A suitable amount of Scotch Bright wrapped around the end of a garden hose and tied on with a cable tie will also work well. The hose can be pulled in and out while running to thoroughly clean and scour the pipe inside.
 3. Sandblast the anchor to remove all zinc coating down to bare steel.
 4. Provide the anchor to the galvanizing plant, with the following instructions:
 - a. The shank is high tensile steel, so do not “over-pickle”;
 - b. Hang the anchor for dipping in such a way that the breather hole in the roll bar is facing up, so air bubbles can escape and the zinc can penetrate inside the roll bar;
 - c. Drips can be removed while the zinc is molten, however, once solidified care must be taken not to knock them off thereby exposing steel. For example, the anchors must not be dragged across concrete but handled carefully.
 5. Clean up any drips or sharp edges in the galvanizing with a hand file, taking care not to remove too much zinc. Take care not to “break” any drip of zinc – this will expose steel. If this is a concern, better to leave a drip and have it wear off over time with use.
 6. Contact us at support@rocna.com and we will be happy to supply new labels for the anchor. When applying new labels, clean the surface before preparation with vinegar, scotch bright and acetone to ensure the best bonding of the new labels.
- If you have any questions, please contact us at: support@rocna.com