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METHOD FOR THERMAL BARRIER COATING AND A LINER MADE USING SAID METHOD



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ABSTRACT

A method of applying a thermal barrier coating system (58) to a metal piece (10) having cooling holes (42) angled in a first direction (44) and cooling holes (46) angled in a second direction (48). The method includes spraying a bond coat (110) on a first surface (38) of the piece (10) at angles with respect to the first and second directions (44, 48) and to a thickness (114) selected in combination with the angles to prevent the bond coat (110) from entirely filling any of the holes (42, 46). A thermal barrier coating (120) is sprayed on the bond coat (110) at angles with respect to the first and second directions (44, 48) and to a thickness (124) selected in combination with the angles to prevent the thermal barrier coating (120) from entirely filling any of the holes. The method also includes spraying a high pressure fluid jet from a nozzle assembly (94) through each hole generally parallel to the respective cooling hole.

Fig. 1