

## Coating instruction

The following instructions are relevant for various surface treatments.

In the lower right corner ("coating") of Weweler parts drawings, the following terms can be mentioned:

S  
S+S  
S+S< number>  
S+P  
KTL  
Zn

Explanation:

**S** The first S stands for sandblasting, minimal by the standard SA 2 1/2 (\*1). By sandblasting all (external) surfaces have to be free of grease, rust and clean. At the same time the sharp edges have to be worked on to obtain a good adherence of the coating.

**S+S** The second S stands for applying a shopprimer: (according to Interplate epoxy shopprimer: NEA408/NEA409 (\*1).) The shopprimer serves as a temporary protection of steel during fabrication and assembly for a period of 6-9 months.

The most important demands of this primer are:

- \* It has to be able to endure the endcoatings.
- \* The typical layerthickness: 25 micron dry corresponding with 104 micron wet.
- \* color: red (red-brown)

Weweler parts are being subjected periodically to a welding test. The primer is not allowed to give out an excessive smell both during and after the welding. Round the weld the primer can only be converted into powder and is not allowed to form blisters.

**S+S< number>** S+S is being provided with a RAL-number, in case the product has to be sprayed in a color after the primer (or a groundlayer). A primer is redundant if the paint shows qualities in accordance with the shopprimer described in "S+S".

**S+P< number>** P stands for Powdering (of Sigma powdercoating WPE 48 (\*1).) S+P is being provided with a RAL-number. Powdered parts are not being welded.

**KTL** KTL stands for Katodisch Tauch Lackierung (cathodic immersion coating)  
The pre-treatment has to be zinc phosphated  
The layerthickness has to be minimal 30 µm. Colour: black

**Zn** Zn stands for zinc plating  
The hot zinc dipping has to comply with standard EN ISO 1461  
The electro-zincing has to comply with standard DIN ISO 4042  
The sherardising has to comply with standard NEN EN 13811

Demands:

Adherence:

Adherence of the paint coat:

S+S ; S+S+< number> :	by DIN 53 151-B	GT 1
S+P< number> :	by DIN 53 151-B	GT 0
KTL:	by DIN 53 151-B	GT 0-1

Check:

In case of deviation or doubt, the division of quality control is able to block the concerning parts pending further assessment according IM-065

At the same time all parts are being visual assessed. The parts are not allowed to hold local excessive coating thickness or drops.