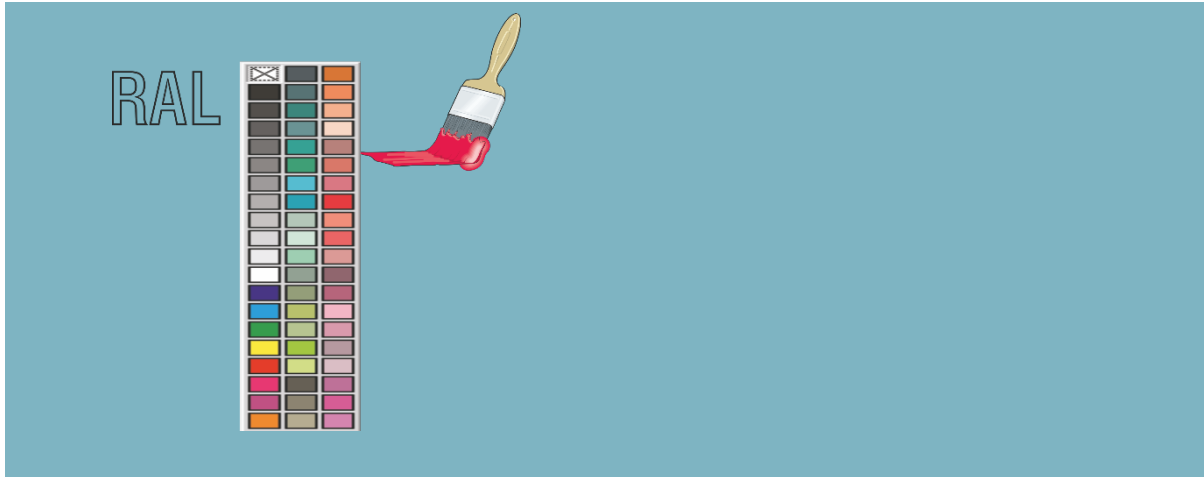


# Painting Specification

Painting of Mechanical Equipment for Mounting Outdoors or in Aggressive Industrial Atmospheres



## Painting

Color hue DB 703 / RAL 7015 or deviation thereof as per order specification.

### Durability of the deck coating

Against moist vapors, salts, gasses, diluted sulfuric and hydrochloric acid compounds, oils, fuels, high abrasion resistance, high hardness and impact strength.

- Corrosivity category as per DIN EN ISO 12944-2: C5-I
- Protection duration as per DIN EN ISO 12944-1: M (5 years to 15 years)

### Temperature resistant against:

- Dry heat: heat: up to approx. +120 °C
- Short-term (few minutes only): up to +150 °C
- Moist heat and Water: up to +60 °C
- Oils: up to +120 °C

## Pretreatment

### Thick plates and rolled steel

Plastered or naturally smooth and blasted as per:

- the standard grade of cleanliness Sa 2 1/2 of DIN 55 928 part 4, or per
- SIS 05 59 00 Sa 2 1/2 (Swedish specification), or per
- BS 4232 second quality (British specification) or per
- SSPC-VIS near white Sp10 (USA specification).

### Weld seams

Includes assembly weld seams cleaned as per standard grade of cleanliness St3; however, weld seams on weigh hopper inner surfaces are always hand derusted, no grinding is allowed!!

## Wet paint

As per DIN EN ISO 12944 Total coat thickness: approx. 240 µm (triple coating).

### Priming coat

Epoxy-zinc powder paint, air-drying

- Primary product: Two component epoxy resin
- Color hue: Gray
- Coat thickness: approx. 80 µm

### Intermediate coating

Epoxy mica-iron paint, air-drying

- Primary product: Two component epoxy resin
- Color hue: DB 702
- Coat thickness: approx. 80 µm

### Deck coating

Epoxy mica-iron paint, air-drying

- Primary product: Two component epoxy resin
- Hardener: Isocyanate
- Color hue: DB 703
- Coat thickness: approx. 80 µm

## Powder coating

As per DIN 55633 Total coat thickness: approx. 180 µm (primer and deck coating)

### Priming coat

Powder on EP basis (epoxy resin binder)

- Color hue: RAL 7035
- Coat thickness: approx. 100 µm

### Deck coating

- EP/SP-based powder (epoxy/polyester resin) or
  - SP-based powder (polyester resin) or
  - PUR-based powder (polyurethane)
- Color hue: RAL 7015
- Coat thickness: approx. 80 µm

## Contact Inner Surfaces

Hoppers, feed hoppers, etc. derusted by hand and corrosion protected

by a 2-component epoxy resin prime coat, film thickness approx 30 µm.

## Bought-In Items

E.g. drives, painted and shaded as supplied to Schenck Process. Bright surfaces, e.g. shaft ends preserved with the use of TECTYL 506. Stainless steel parts not painted.