

Work instruction			Version: 6	steinemann
AN094_Instruction_Varnishing_Machine parts_BG			Applicability: STCH	
Last author: Zarko Mitrovic	Responsible: Zarko Mitrovic	Released by: Zarko Mitrovic	Release date: 28.05.2019	

Aim and purpose

Ensuring that quality meets customer requirements and satisfies the quality standards of Steinemann Technology AG.

Area of application

Steinemann Technology AG

Generally applicable for coatings:

- All parts are normally coated (excepting certain rotating parts such as rollers/drums).
- Standard colour is KABE 4M5082 (approx. RAL 1001)
(excepting Satos plus, spare parts and optional, customer-specific machine parts).
- Standard colours are not selectable colours and are filed under surface treatment master data (MM, PsiPenta in article master and order proposal).
- Selectable machine part colour (see machine specification). If colours other than the standard are selected, this must be defined in the purchasing text according to the machine specification.
- On the drawings, it is only noted where the coating must be applied and where needs to be covered.
- Spare parts are coated according to the specified coating layer in the [FO625 Montageformular Ersatzteilaufträge](#) form

Quality responsibility

Responsibility for quality is assigned first and foremost to the supplier and internal quality control (SC-QC). The original sample templates with article number 7025112 must be supplied as test equipment for internal QC and the supplier (from stock).

The quality standard/original sample are based on the prescribed colour mixture from KABE (www.kabe-farben.ch).

Prescribed coating specifications

KABE 4M5082, approx. RAL 1001

- Powder coat art. 11993 POLYFLEX PES 135 – smooth coating Tribo/Corona silk matt 135
- Industrial coating – art. 14300 KABEDUR silk matt enamel – ΔE 2.0

KABE A5M1764, approx. RAL 5003

- Powder coat art. 11993 POLYFLEX PES 135 – smooth coating Tribo/Corona silk matt 35
- Industrial coating – art. 14300 KABEDUR silk matt enamel – ΔE 2.0

KABE 2M3049, approx. RAL 7035

- Powder coat art. 11993 POLYFLEX PES 135 – smooth coating Tribo/Corona silk matt 35
- Industrial coating – art. 14300 KABEDUR silk matt enamel – ΔE 1.0

KABE 2M3674, approx. RAL 7037

- Powder coat art. 11993 POLYFLEX PES 135 – smooth coating Tribo/Corona silk matt 35
- Industrial coating – art. 14300 KABEDUR silk matt enamel – ΔE 1.4

KABE 4M8920, approx. RAL 9005

- Powder coat art. 11993 POLYFLEX PES 135 – smooth coating Tribo/Corona silk matt 35
- Industrial coating – art. 14300 KABEDUR silk matt enamel – ΔE 1.4

Primer, approx. RAL 7035

- Industrial coating – art. 13264 REAKTIONSGRUND light grey, approx. RAL 7035

Explanatory notes on parts of specification:

- Tribo/Corona --> coating method

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- KABEDUR enamel --> 2C PU coating designation (internal product name from KABE)

- ΔE 2.0 --> pronounced 'delta E', indicates the maximum permitted total colour difference according to the CIE Lab formula (colorimeter) according to the specification for facade powder coatings

Sanding product group

Pre-treatment:		<p>All process steps necessary for a flawless top coat must be completed (pre-cleaning).</p> <p>Weld seams and free ends must be buffed to a clean finish.</p> <p>Threaded holes must be covered before coating work.</p> <p>Fit edges must be covered to ensure no coating residues remain in the fit.</p>	
Priming as required	Coat thickness	min. 30 µm	max. 60 µm
Top coat general		Smooth silk matt coating Gloss level according to colour collection (original sample)	Solvent resistance of the top coat must be assured for standard cleaning agents (such as white spirit, isopropanol)
Top coat industrial coating	Coat thickness	min. 60 µm	max. 100 µm
Top coat powder coating	Coat thickness	min. 80 µm	max. 120 µm

Surface, colour coating

Prescribed measurement	Test element	Measuring equipment to use
Coat thickness measurement according to EN ISO 2178	</= Gt2	Non-destructive coat thickness measurement
Paint/varnish adhesion according to DIN EN ISO 2409		Cross-cut test unit Colour sample