In order for a workpiece to be optimally coated with corrosion or chemical protection, certain requirements must be met. Here are some aspects that you can can take into account during design and production in order to save effort and costs later on:

1. SURFACE AND STRENGTH

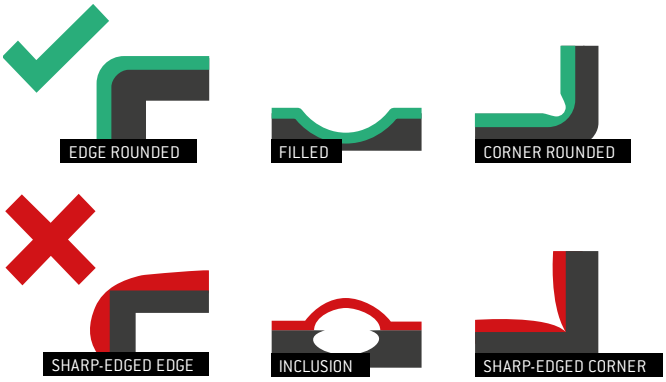
The surface should be tight and even. Cutting burrs and welding beads must be removed, unevenness must be sanded out. The parts to be coated must be inherently rigid and withstand the stress caused by the sintering or curing temperature.

2. VENTING HOLES

Components to be coated should not contain any closed hollow bodies. Alternatively, if a hollow body is present, it must be provided with a vent hole. Additionally, all areas must be easily accessible to both the eyes and hands.

3. PREPARATION

The workpieces are typically sandblasted before coating to enhance coating adhesion.
The prerequisite for this is that the components can withstand the blasting process without distortion.
If this cannot be guaranteed, we can offer you alternative pre-treatment options.



4. EDGES, GROOVES, CORNERS

Edges, grooves and corners must be rounded off cleanly and smoothly. For powder coatings, ensure minimum radii of 2 mm on edges and 3 mm in fillets, and 3/6 mm for spray coatings.

5. WELDING JOINT

No spot welding. Seams tight and continuous, smooth, sanded, free of slag and build-up, no penetration marks.

6. SOCKETS, FLANGES, MANHOLES

Connection possible by inserting, fitting and collaring. Welding on the coating side. Smooth out corners by welding with large radii. Edges and weld seams rounded and ground. Manholes at least 600mm ⌀. No internal thread. Spigot length ≤ nominal size + 100.? Depending on component size, coating material and/or coating thickness, these values may deviate upwards or downwards?

7. CONTAINER PARTITION WALLS

Connect the dished end exterior (convex side) to the cylinder section with an angle profile ring or similar. The resulting cavity must be secured with dense weld seams. Weld the concave side with a large rounded seam.

8. PIPES AND PIPE CONNECTIONS

Straight pipes min. NS 80 mm, max. length 4000 mm. Pipe fittings must be accessible from all sides. Nozzle length ≤ NPS + 100. Bends > 90° must be devided. Connections only possible with flanges. For welding, see 3.

9. INSTALLATIONS IN CONTAINERS AND APPARATUS

Profiles, even if they are only used for reinforcement, must be joined with continuous weld seams. The evenness and consistency of a coating depends on the quality of the surface before coating. coating. Pores and cracks are neither covered, leveled nor smoothed out by the coating. Unevenness, scratches, grooves and structural defects are covered to a certain extent, but not equalized.

10. NOTES ON INQUIRIES AND ORDERS

- Mark the following areas on drawings or sketches, pictures / photos.

  Green: must be coated (alternatively ·····)
  Yellow: may be coated (alternatively ----)
  Red: must not be coated (alternatively ....)

- Tolerate dimension, position and shape.
- Specify the workpieces by material number or material composition.
- Please let us know the surface condition of the area to be coated or the degree of processing on delivery.
- If possible, mark the mounting points with position and dimensions.

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