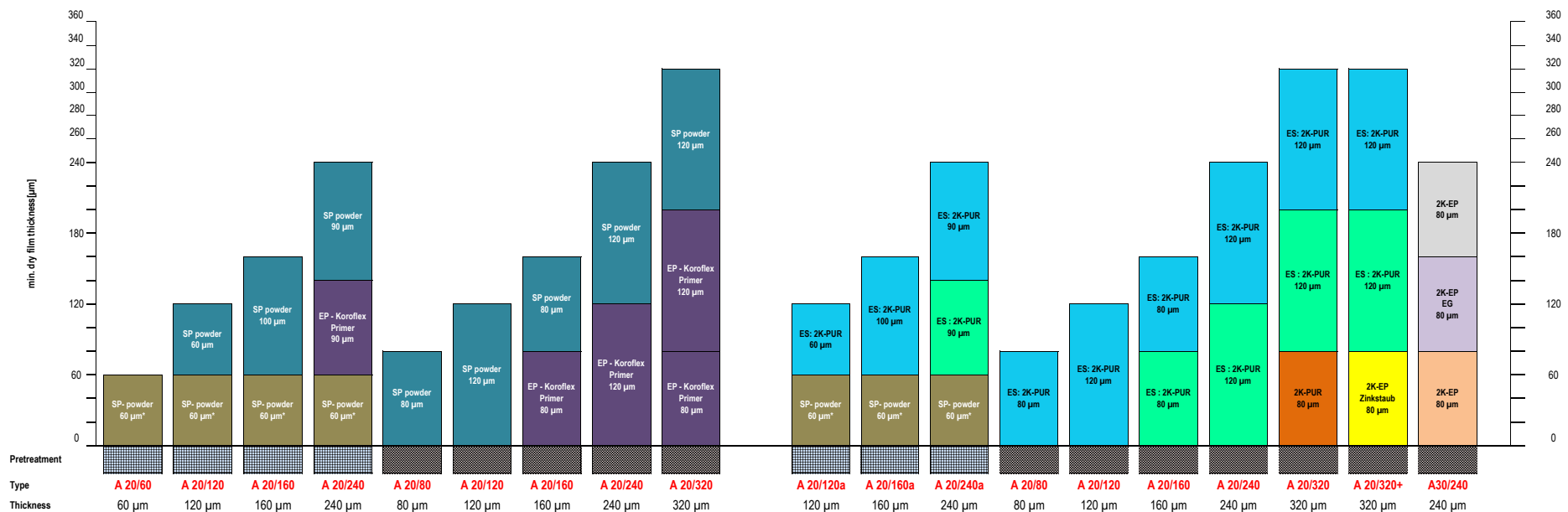


Coating design

	C2	C2	C3	C4 high	C2	C2 high	C3	C4 high	C5-I/M high		C2	C3	C4 high	C2	C2 high	C3	C4 high	C5-I/M high	C5-I/M high	C4 high
ISO 12944-5 medium	Powder coating										Wet paint coating									



Pretreatment	
	Degrease & iron phosphating
	Blasting SA 2,5 - 3

GB = Primer	
	SP - Powder (Saturated Polyester)
	EP - Koroflex Primer Powder (Epoxid)
	2K-EP Zinc dust primer (Epoxid)
	2K-EP (Epoxid)
	2K-PUR (Polyurethan)

ZB = Intermediate coat	
	2K-EP EG micaceous iron oxide (Epoxid)
	ES: 2-K - PUR (Single-layer coating, Polyurethan)

DB = Top coat	
	SP - Powder (Saturated Polyester)
	ES: 2-K - PUR (Single-layer coating, Polyurethan)
	2K-EP (Epoxid)

	Coating	Manufacturer	Article description
GB	SP - Powder (Saturated Polyester)*	KABE	POLYFLEX PES-135 Seidenmatt
	EP - Koroflex Primer Powder (Epoxid)	KABE	POLYFLEX EP-20 Koroflex Primer Seidenmatt
	2K-EP Zinc dust primer (Epoxid)	Gehölit & Wiemer	GEHOPON-E87-Zink, Stoff Nr. 687.03
	2K-EP (Epoxid)	Gehölit & Wiemer	GEHOPON-E87-Metallgrund, Stoff Nr. 687.06
ZB	2K-EP (Epoxid)	Gehölit & Wiemer	GEHOPON-E87-Metallgrund, Stoff Nr. 687.06
	2K-PUR (Polyurethan)	Gehölit & Wiemer	WIERGEEN-M162R-Metallgrund
DB	2K-EP EG micaceous iron oxide (Epoxid)	Gehölit & Wiemer	GEHOPON-E87-ZB
	ES: 2-K - PUR (Single-layer coating, Polyurethan)	Gehölit & Wiemer	WIERGEEN-M162R RAL1003
	SP - Powder (Saturated Polyester)	KABE	POLYFLEX PES-135 Seidenmatt
DB	ES: 2-K - PUR (Single-layer coating, Polyurethan)	Gehölit & Wiemer	WIERGEEN-M162R
	2K-EP (Epoxid)	Gehölit & Wiemer	GEHOPON E8

Attention:
Gearmotors, panel boxes (PVC),
bottom hook block are not available in powder-coated!

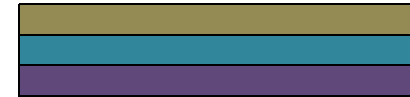
* The primer of vendor parts could be another manufacturer as KABE, but the characteristics of the powder are the same as by KABE.

Type	Structure of the coating		Minimum dry film thickness [µm]		Area of application		Corrosivity categories*
			per layer	total	Indoors	Outdoors	
							medium
A 20/60	Powder coating	SP- powder (Saturated Polyester) GB	60	60	Production areas with low humidity, e.g. storage rooms, factory buildings. Relative humidity < 90%	Not suitable as a rule	C2
A 20/120	Powder coating	SP- powder (Saturated Polyester) DB SP- powder (Saturated Polyester) GB	60 60	120	Production areas with low humidity, e.g. storage rooms, factory buildings. Relative humidity < 90%	Atmospheres with slight pollution and dry climate	C2 high
A 20/160	Powder coating	SP- powder (Saturated Polyester) DB SP- powder (Saturated Polyester) GB	60 100	160	Production areas with high humidity <= 100% and some air pollution	Urban and industrial atmospheres, coastal regions with low level of saline pollution	C3
A 20/240	Powder coating	SP- powder (Saturated Polyester) DB EP - Koroflex Primer Powder GB SP- powder (Saturated Polyester) GB	90 90 60	240	Chemical plants, sewage plants, cement works, areas with practically constant condensation and with high air pollution, buildings in direct proximity to seawater	Industrial areas with high humidity and aggressive atmosphere, coastal regions with moderate level of saline pollution	C4 high
A 20/80	Powder coating	SP- powder (Saturated Polyester) DB	80	80	Production areas with low humidity, e.g. storage rooms, factory buildings. Relative humidity < 90%	Only with roofing, otherwise not suitable as a rule	C2
A 20/120	Powder coating	SP- powder (Saturated Polyester) DB	120	120	Production areas with low humidity, e.g. storage rooms, factory buildings. Relative humidity < 90%	Atmospheres with slight pollution and dry climate	C2 high
A 20/160	Powder coating	SP- powder (Saturated Polyester) DB EP - Koroflex Primer Pulverlack GB	80 80	160	Production areas with high humidity <= 100% and some air pollution	Urban and industrial atmospheres, coastal regions with low level of saline pollution	C3
A 20/240	Powder coating	SP- powder (Saturated Polyester) DB EP - Koroflex Primer Powder GB	120 120	240	Chemical plants, sewage plants, cement works, areas with practically constant condensation and with high air pollution, buildings in direct proximity to seawater	Industrial areas with high humidity and aggressive atmosphere, coastal regions with moderate level of saline pollution	C4-high
A 20/320	Powder coating	SP- powder (Saturated Polyester) DB EP - Koroflex Primer Powder GB EP - Koroflex Primer Powder GB	120 120 80	320	Chemical plants, sewage plants, cement works, areas with practically constant condensation and with high air pollution, buildings in direct proximity to seawater	Industrial areas with high humidity and aggressive atmosphere, coastal and offshore regions with high level of saline pollution	C5- I/M high

























The corrosivity categories can only be achieved if the pretreatment according to our specification! See page 10.

SP- powder (Saturated Polyester) GB
 SP- powder (Saturated Polyester) DB
 EP - Koroflex Primer Pulverlack GB



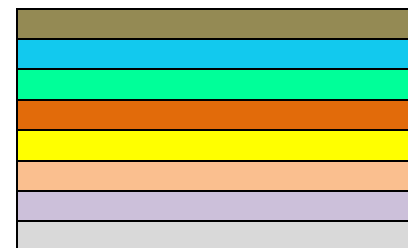
*Corrosivity categories in compliance with ISO 12944 can only be ensured if any mechanical damage sustained by the finish and extending to the substrate is immediately touched up with a suitable liquid paint system.

Type	Structure of the coating		Minimum dry film thickness [µm]		Area of application		Corrosivity categories*
			per layer	total	Indoors	Outdoors	
							medium
A 20/120a	Wet paint coating	 ES: 2K - PUR (Single-layer coating, Polyurethan) DB	60	120	Production areas with low humidity, e.g. storage rooms, factory buildings. Relative humidity < 90%	Atmospheres with slight pollution and dry climate	C2 high
	Powder coating	 SP: powder (Saturated Polyester) GB	60				
A 20/160a	Wet paint coating	 ES: 2K - PUR (Single-layer coating, Polyurethan) DB	100	160	Production areas with high humidity <= 100% and some air pollution	Urban and industrial atmospheres, coastal regions with low level of saline pollution	C3
	Powder coating	 SP: powder (Saturated Polyester) GB	60				
A 20/240a	Wet paint coating	 ES: 2K - PUR (Single-layer coating, Polyurethan) DB	90	240	Chemical plants, sewage plants, cement works, areas with practically constant condensation and with high air pollution, buildings in direct proximity to seawater	Industrial areas with high humidity and aggressive atmosphere, coastal regions with moderate level of saline pollution	C4 high
	Wet paint coating	 ES: 2K - PUR (Single-layer coating, Polyurethan) DB	120				
	Powder coating	 SP: powder (Saturated Polyester) GB	60				
A 20/80	Wet paint coating	 ES: 2K - PUR (Single-layer coating, Polyurethan) DB	80	80	Production areas with low humidity, e.g. storage rooms, factory buildings. Relative humidity < 90%	Only with roofing, otherwise not suitable as a rule	C2
A 20/120	Wet paint coating	 ES: 2K - PUR (Single-layer coating, Polyurethan) DB	120	120	Production areas with low humidity, e.g. storage rooms, factory buildings. Relative humidity < 90%	Atmospheres with slight pollution and dry climate	C2 high
A 20/160	Wet paint coating	 ES: 2K - PUR (Single-layer coating, Polyurethan) DB	80	160	Production areas with high humidity <= 100% and some air pollution	Urban and industrial atmospheres, coastal regions with low level of saline pollution	C3
		 ES: 2K - PUR (Single-layer coating, Polyurethan) DB	80				
A 20/240	Wet paint coating	 ES: 2K - PUR (Single-layer coating, Polyurethan) DB	120	240	Chemical plants, sewage plants, cement works, areas with practically constant condensation and with high air pollution, buildings in direct proximity to seawater	Industrial areas with high humidity and aggressive atmosphere, coastal regions with moderate level of saline pollution	C4-high
		 ES: 2K - PUR (Single-layer coating, Polyurethan) DB	120				
A 20/320	Wet paint coating	 ES: 2K - PUR (Single-layer coating, Polyurethan) DB	120	320	Chemical plants, sewage plants, cement works, areas with practically constant condensation and with high air pollution, buildings in direct proximity to seawater	Industrial areas with high humidity and aggressive atmosphere, coastal and offshore regions with high level of saline pollution	C5- I/M high
		 ES: 2K - PUR (Single-layer coating, Polyurethan) DB	120				
		 2K-PUR (Polyurethan) GB	80				
A 20/320+	Wet paint coating	 ES: 2K - PUR (Single-layer coating, Polyurethan) DB	120	320	Chemical plants, sewage plants, cement works, areas with practically constant condensation and with high air pollution, buildings in direct proximity to seawater	Industrial areas with high humidity and aggressive atmosphere, coastal and offshore regions with high level of saline pollution	C5- I/M high
		 ES: 2K - PUR (Single-layer coating, Polyurethan) DB	120				
		 2K-EP Zinc dust primer (Epoxid) GB	80				
A 30/240	Wet paint coating	 2K-EP (Epoxid) DB	80	240	Chemical plants, sewage plants, cement factories, foundries, buildings in proximity to the sea	Not colour and gloss stable. Not UV-resistant.	C4 high
		 2K-EP EG micaceous iron oxide (Epoxid) ZB	80				
		 2K-EP (Epoxid) GB	80				



The corrosivity categories can only be achieved if the pretreatment according to our specification! See page 10.

SP- powder (Saturated Polyester) GB
ES: 2K - PUR (Single-layer coating, Polyurethan) DB
ES: 2K - PUR (Single-layer coating, Polyurethan) DB
2K-PUR (Polyurethan) GB
2K-EP Zinc dust primer (Epoxid) GB
2K-EP (Epoxid) GB
2K-EP EG micaceous iron oxide (Epoxid) ZB
2K-EP (Epoxid) DB



*Corrosivity categories in compliance with ISO 12944 can only be ensured if any mechanical damage sustained by the finish and extending to the substrate is immediately touched up with a suitable liquid paint system.

Additional information about the coating systems

coating type	A20/60	A20/80	A20/120a	A20/120	A20/160a	A20/160	A20/240a	A20/240	A30/240	A20/320	A20/320+
corrosive category ISO 12944-2 medium	C2	C2	C2	C2 high	C3	C3	C4 high	C4 high	C4 high	C5-I/M high	C5-I/M high
min. layer thickness (µm)	60	80	120	120	160	160	240	240	240	320	320
Condensation test ISO 6270	48 h	48 h	48 h	120 h	120 h	120 h	480 h	480 h	480 h	720 h	720 h
salt spray test ISO 7253	-	--	120 h	120 h	240 h	240 h	720 h	720 h	720 h	1440 h	1440 h
Resistance acc. To ISO 2812											
mineral oil	+	+	+	+	+	+	+	+	+	+	+
grease	+	+	+	+	+	+	+	+	+	+	+
aliphatic solvent	0	0	0	0	0	0	+	+	+	+	+
sulfuric acid 10%	+	+	+	+	+	+	+	+	+	+	+
sulfuric acid 50%	0	0	0	0	0	0	0	0	+	0	0
hydrochloric acid 37%	--	--	--	--	--	--	-	-	0	-	-
sodium hydroxide 10%	+	+	+	+	+	+	+	+	+	+	0
sodium hydroxide 25 %	0	0	0	0	0	0	0	0	+	+	0
-- = not consistent 0 = shortly consistent + = consistent											

Please note: the primer coat for some components are different to the previously show	
	Standard primer coat
Wheel block	KTL (cataphoretic painting RAL 7021) 20 µm
Endcarriages Connecting plate	Wiergen M162R-Metallgrund RAL 7035 (Geholit&Wiemer) not painted
Endcarriages HL/HT Connecting plate	Polyurethan RAL 7038 60µm (not weldable) Epoxid RAL 3009 20µm (weldable)
Endcarriages LE/LT/LS Connecting plate	2K Epoxid RAL 3009 20µm (weldable)
	The a.m. primer coats are very good applicable for additional coats and will be top coated acc. to the Hoist or Crane specifications.