

Subject :

Drying

Proposal

ADAL

The last part of section 3.2.2 should be moved to 3.4, giving more precise instructions for drying

QUALICOAT resolution:

Meeting on 29.06.06
(ratified on 22.11.06)

Date of application:

1st January 2007

Amendments to the Specifications:

Sections 3.2.2 and 3.4

3.2.2 Chromate pre-treatment

This chromate or chromate-phosphate pre-treatment must be carried out according to **DIN 50939**.

[..]

~~The parts must be dried at the following temperatures: :~~

[..]

~~The products must be dried thoroughly before the coating is applied, irrespective of the production method (continuous/ discontinuous).~~

3.4. Drying

After pre-treatment and before the application of coating, the parts must be dried thoroughly in an oven. For this purpose, a drying oven must be installed in each plant.

The parts must be dried at the following temperatures: :

chromate treatment (yellow) : maximum 65°C

chromate-phosphate treatment (green) : maximum 85°C

The maximum drying temperature allowed for continuous treatment is 100°C. The specified temperatures apply to the temperature of the metallic parts and not to the air temperature. The products must be dried thoroughly before the coating is applied, irrespective of the production method (continuous/discontinuous).

For anodic pre-treatment, the drying temperature should be less than 80°C to prevent the anodic film from being sealed.

Alternative pre-treatment systems should be dried following the suppliers' instructions.