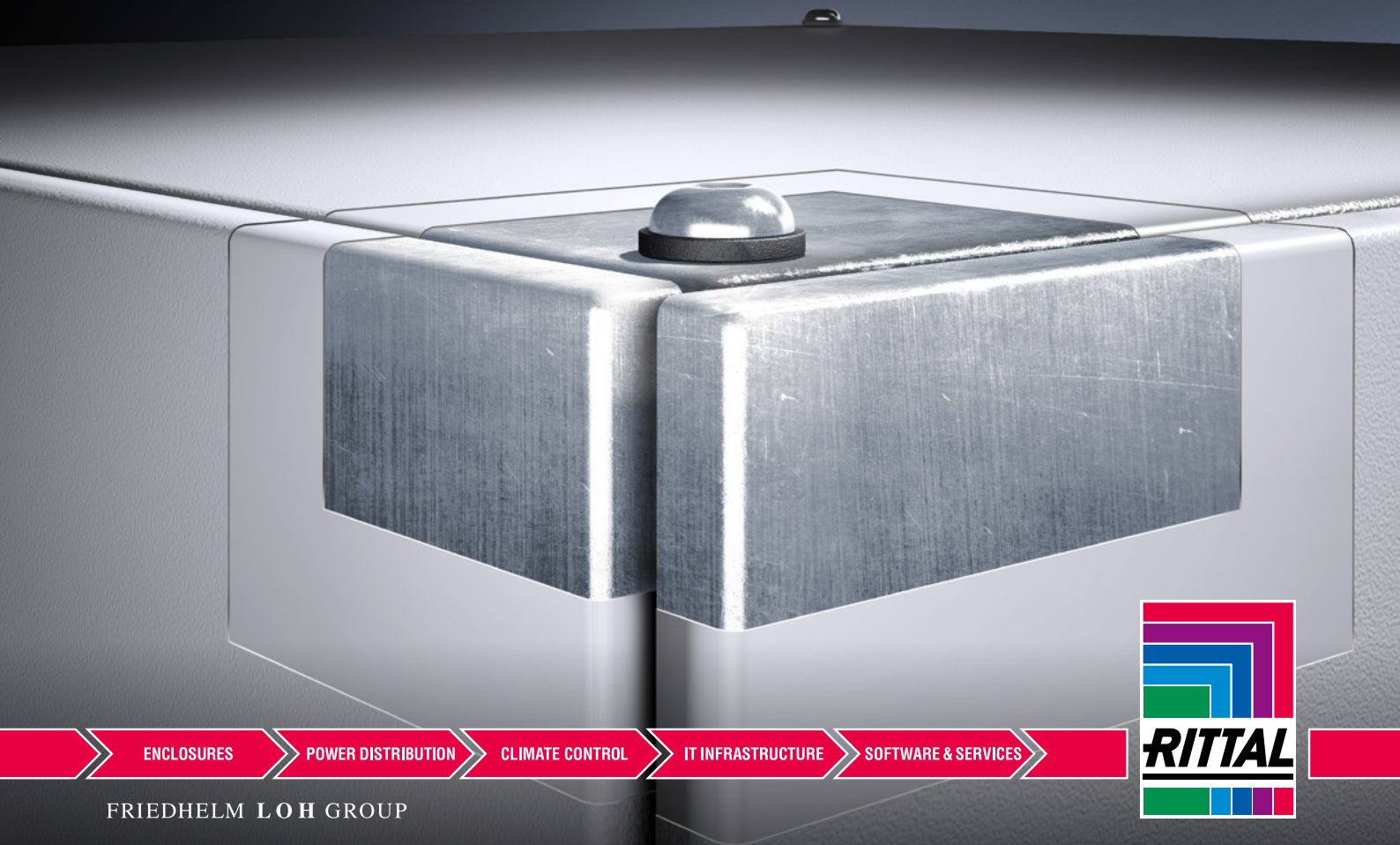


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Optimum surface protection

Our expertise – your benefit.



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The three-phase coating procedure

The three-phase surface finish provides optimum corrosion protection and is resistant to mineral oils, lubricants, machining emulsions and solvents such as those used in cleaning. Rittal offers a paint finish as standard that is also used in the automotive industry. And this quality is also guaranteed by way of continuous process monitoring.

The result: a durable, long-lasting, and visually appealing powder coating – ideal for the most demanding industrial applications.

Textured powder coating

Erichsen cupping test to DIN EN ISO 1520	≥ 3.5 mm
Buchholz hardness to DIN EN ISO 2815	≥ 85
Cross cutting to DIN EN ISO 2409	GT 0-1
Salt spray test to DIN EN ISO 9227 NSS	Test period: 168 hours
Condensate test to DIN EN ISO 6270-2 CH	Test period: 480 hours

Finishing paint:

**Powder coating min. 50 – 80 µm,
polyester-epoxy resin-based
(textured paint)**

Primer:

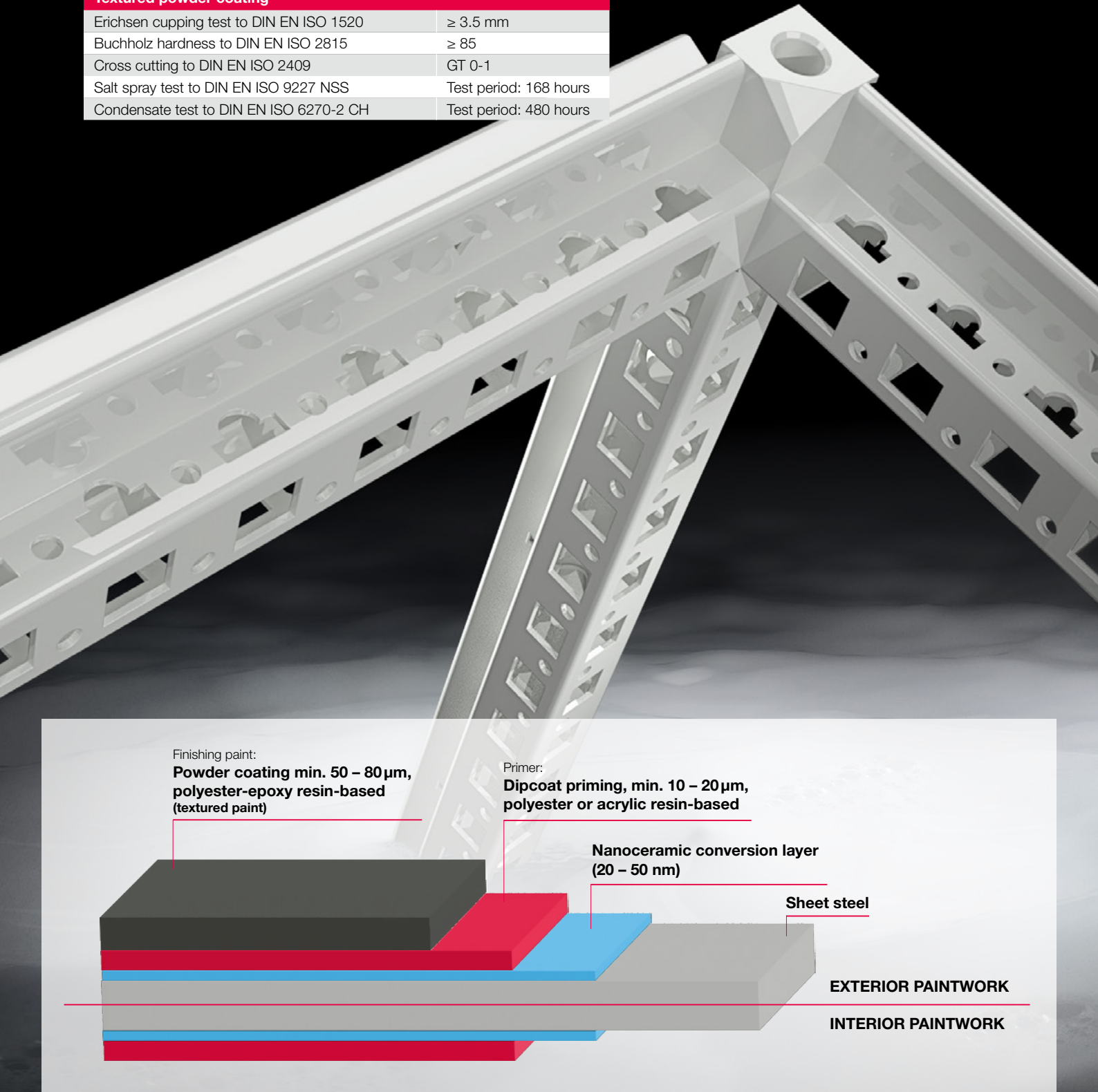
**Dipcoat priming, min. 10 – 20 µm,
polyester or acrylic resin-based**

**Nanoceramic conversion layer
(20 – 50 nm)**

Sheet steel

EXTERIOR PAINTWORK

INTERIOR PAINTWORK



1st phase: Degreasing and nanoceramic coating

Pretreatment

- Degreasing of the raw material
- Nanoceramic conversion layer
- Eco-friendly



2nd phase: Primer

Electrophoretic dipcoat priming

- Water-based polyester or acrylic resins free of heavy metals, chromates, and silicones
- Creates even layer structures on the surfaces, edges and hollow spaces, thereby ensuring a complete seal
- Layer thickness approx. 10 – 20 µm
- Curing by stove-enamelling



3rd phase: Textured powder coating

Textured powder coating

- Eco-friendly, heavy metal-, chromate- and silicone-free powder-coating on an epoxy-polyester resin basis with excellent mechanical resistance
- Decontaminatable
- Layer thickness approx. 50 – 80 µm
- Stove enamelling



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