

# LACQUERING



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We can paint the plastic enclosures and tuning knobs in the color you require, either to enhance the look and feel of your product or to protect it from electrostatic discharge. We do not use any special masks, meaning that some paint mist may settle on the inner surface.

## SYSTEM AND RANGE OF PAINTS AND COLORS

### SYSTEM

Paint booth, hand-held spray gun, paint mixing unit, drying oven.

### RANGE OF PAINTS:

#### STANDARD PAINT

UV-resistant 2-component paints by Mankiewicz are used in accordance with quality standard 461-73. These constitute a weather-resistant top-coat system with maximum gloss and colour stability in industrial paint quality.

#### COLORS

The color should be defined according to RAL Classic.  
The metallic color RAL 9006 (white aluminum) can be applied as standard.  
Other metallic colors, as well as Pantone colors (see Form Guide), are available upon request.  
We can mix your paint from 20 available basic colours, using our own paint mixing system.  
This guarantees consistently high quality and short delivery times.  
A colour deviation of up to  $\Delta E = 2.5$  is possible.

#### SURFACE FINISH

Besides the color, the gloss level plays a decisive role in the appearance.  
We can apply the standard paint in different degrees of gloss, namely: dull matt, matt, satin matt, semi-gloss, and gloss.  
If no gloss level is specified, the finish will be effected in satin matt (standard).

#### SOFT-TOUCH PAINT (OPTIONAL ON REQUEST)

For this we use the translucent paint Alexit 401-75 by Mankiewicz.  
This is painted over the part that has already been painted with standard colored paint.  
The soft-touch paint gives your products a velvety, leather-like feel.

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## SYSTEM AND RANGE OF PAINTS AND COLORS

### ESD PAINT (OPTIONAL ON REQUEST)

Our plastic materials are generally antistatic.

For the additional coating, we use ALEXIT top coat 412-11 with the following properties: surface resistance  $< 1 \times 10^6$  ohms (measured in accordance with DIN 53482 / VDE 0303, Part 3, electrode configuration A, with a dry film thickness of 50  $\mu\text{m}$ ). Available only in color RAL 9239.

## METHOD

The parts are pre-treated (primed) to ensure good paint adhesion.

In the paint booth, the parts are usually first painted on the inner edges and then completely on the outer surfaces with the colored paint; deviations are possible in special cases. Drying takes place in the drying room.

## ADDITIONAL COSTS

### ADDITIONAL COSTS APPLY

For special paint finishes (on request).

Color adjustment costs will apply for metallic paints or colors that deviate from RAL Classic colors.

## TESTS

Each part undergoes a 100% visual inspection.

Adhesion is tested in accordance with DIN EN ISO 2409 on a random sample basis.

Test	Measurement method	Test equipment	Test equipment manufacturer
Adhesion DIN EN ISO 2409	Tape Test	Lattice cut GT2	Byk Gardner, USA

## PAINT PROPERTIES

Industrial paint quality suitable for indoor and outdoor use, with

- high weather resistance
- high impact and shock resistance
- high abrasion and scratch resistance
- high resistance to cleaning agents
- high gloss and color stability

## WHAT INFORMATION DO WE REQUIRE AT THE INQUIRY STAGE?

How many parts are to be painted and in what colors?

Which special colors differ from RAL Classic?

## WHAT INFORMATION DO WE REQUIRE AT THE ORDER STAGE?

Precise details of which parts are to be painted and in which colors.

Color specifications in accordance with RAL Classic; other color specifications to be checked for feasibility at the inquiry stage.

