

VODEC

Industrial Communications Ltd



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Design, manufacture and supply communication systems world wide for use in the petrochemical industry.

KB038 Rittal Painting Technique

This data sheet details the Paint/ precipitation applied to Rittal 19 inch racks and panels as used by Vodec.

Standard Paint

- By the spray method at approx 60°C
- Cleaning and passivating of the surface
- Coating with nanoceramic (coat thickness approx 1 µm)

Electrophoretic Dipcoat Priming

- Anodic dipcoat priming with water-suspended enamel
- Raw material: polyester resins, free from heavy metals, chromate and silicon
- Can be readily overpainted
- Colour RAL 7035
- Complete cavity sealing
- Coat thickness 20 - 25 µm

Textured Power Coating

- Electrostatic coating
- Raw material: polyester resins, free from heavy metals, chromate and silicon
- Can be readily overpainted
- Colour RAL 7035
- Can be decontaminated
- High mechanical strength
- Good resistance to chemicals and UV rays
- Coat thickness approx 80 µm

Please Note: All outer surfaces have textured powder coating. The inner and internal surfaces are coated with electrophoretic dipcoat primer.

Corrosion Resistance to DIN EN 62 208 section 9.12

144 hours damp heat test at 40°C and 95% relative air humidity

48 hours salt spray test at 35°C and 5% salty solution

Summary: No signs of rust, suitable for harsh industrial surroundings (indoor siting)

Tropical Coating

For regions such as:

Southeast Asia, America, Saudi Arabia, Coastal Areas, Mountains (> 2000 m above mean sea level).

Paint

Electrophoretic dipcoat primer covered with a standard powder coat having a thickness of 90 µm on all internal and external parts to be painted.

Please Note: If the enclosure is located out of doors a rain canopy must be provided in order to protect the sealing against permanent humidity and UV radiation. IP protection categories do not necessarily imply that enclosures are suitable for outdoor applications.

Chemical Paint

Applications

When

- Environments are polluted by aggressive substances
- Enclosure can be covered or contaminated by these substances
- People working in these environments have to be protected by special measures

Paint

The enclosures are power-coated as with standard painting for outdoor locations and are additionally overpainted with 2k polyurethane paint.

Resistance

The standard coat is resistant to:

- Mineral oils
- Lubricants
- Machining emulsions
- Solvents (briefly, such as during cleaning processes)
- Weak acids and alkaline

Overpainting

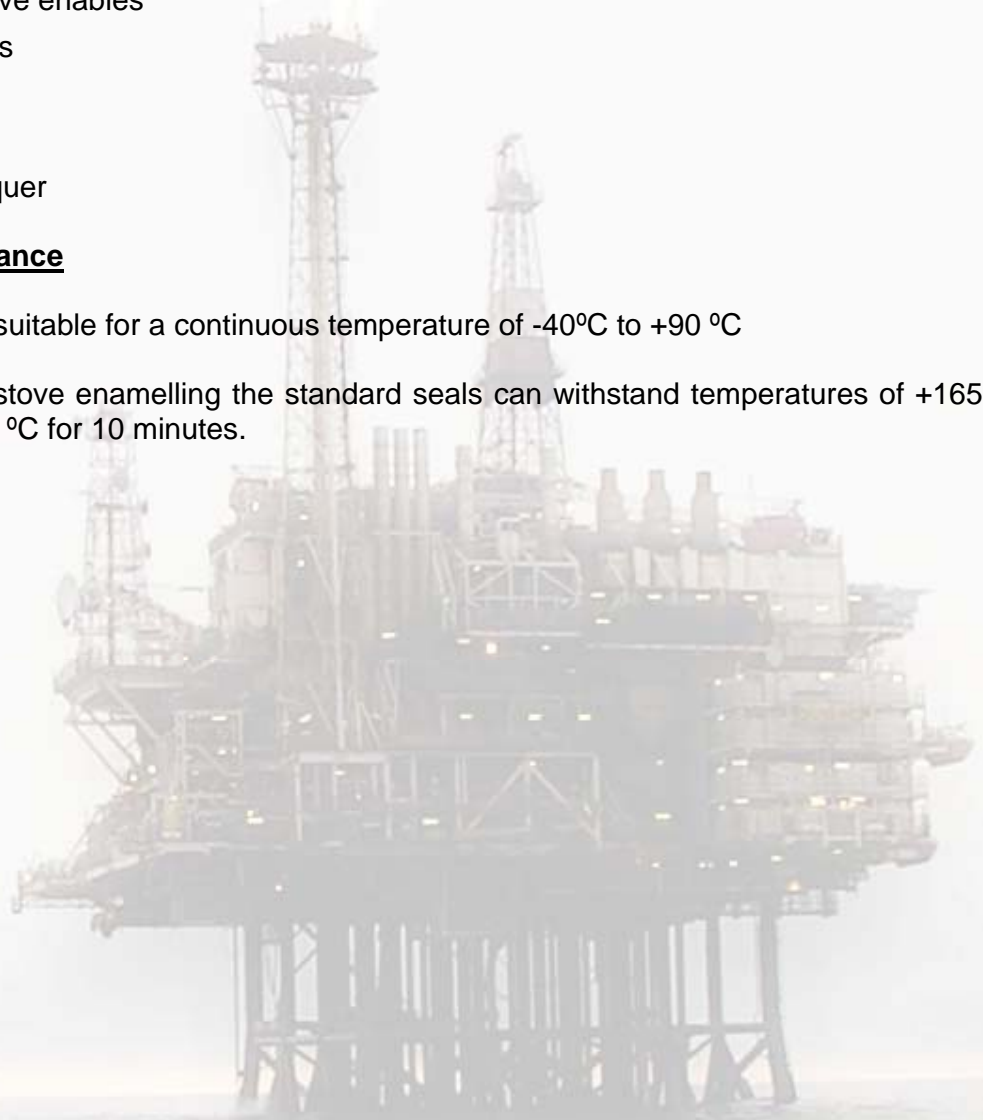
After careful cleaning and perhaps slight roughening of the surface, the standard coating can be overpainted with:

- DD gloss paints
- 2-component gloss paints (acrylate enamels)
- 1-component stove enables
- Automobile paints
- Powder coating
- Water enamels
- Nitrocellulose laquer

Temperature Resistance

The standard seal is suitable for a continuous temperature of -40°C to $+90^{\circ}\text{C}$

For the purposes of stove enamelling the standard seals can withstand temperatures of $+165^{\circ}\text{C}$ for 20 minutes or 180°C for 10 minutes.



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