

Surface finish

The processing steps for the wet lacquering and the powder coating are described below. Regardless of the final coating, the point of fine sandblasting applies to all steel parts delivered unpainted.

However, the powder coating may only be carried out after prior explicit approval.

Fine sand blasting

The parts are fine blasted acc. to DIN EN ISO 12944-4 before machining to remove any rust, slag and other impurities and to ensure good adhesion of the paint. This also refers to semi-finished and finished parts manufactured by means of thermal processes which are no longer machined.

Components with mill scale/scale/slag (e.g. unalloyed structural steels) or weld seams must generally be cleaned and must also be fine sandblasted in accordance with DIN EN ISO 12944-4.

The degree of purity acc. to DIN EN ISO 12944-4 must be Sa 2.5 and the grain size is between 212-250 µm.

After fine sandblasting, all cavities must be removed from blasting material and other residues.

Primer coat

Residue of drilling emulsions or cutting oils must be removed after machining. Chips must be removed from hollows.

The parts must be grease-free before priming.

wet coating:

The priming is done on the basis of two-component lacquer.

AkzoNobel (in the past BASF Coatings GmbH)

RELEST® Protect 312 2K-PUR-Primer light grey

RAL 7035

Hardener: RELEST® Hardener PUR 150 or RELEST® Hardener PUR 778

103-0132 PUR-thinner (RELEST® Thinner PUR)

Layer thickness basic priming layer: min: 60 µm

max: 80 µm

Design specification for painted surfaces

Observe proprietary note acc. to DIN 16016

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signed: 11.06.20 Jens Burmester

checked: 12.06.20 Carsten Grebien



KROENERT GmbH & Co. KG
Schützenstraße 105, 22761 Hamburg

Replacement for:

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powder coating:

Epoxy primer with 60-80 µm layer thickness.
The corrosivity category C3 protection H must be acc. to DIN EN 12944-2.

Final lacquer coating

wet coating:


Lacquer coating (spray paint) with two-component lacquer.
AkzoNobel (in the past BASF Coatings GmbH)
RELEST® Protect 316 2K-PUR-Topcoat (gloss)
RAL as specified
Hardener: RELEST® Hardener PUR 150 or RELEST® Hardener PUR 160
103-0132 PUR-thinner (RELEST® Thinner PUR)
Layer thickness cover layer: min: 40 µm
max: 50 µm

powder coating:

Epoxy surface coating with approximately 80 µm layer thickness.
The gloss level (according to DIN 67530) is smooth- glossy (measuring angle 60°; 80-90E).
The surface coating must be solvent resistant and should be tested as follows:
Solvent resistance is to be investigated with nitrodilution. To do this, wipe with a damp cloth over the coated part for 3 seconds, during which the coating must not become dull, frosted or softened.

Deviations from this are permissible for rollers. Only the paints specified in the article or drawing should be used. The processing instructions of the manufacturer must be followed. The degree of gloss must always be glossy.

After lacquer coating, the functional surfaces must be covered with protection against corrosion.

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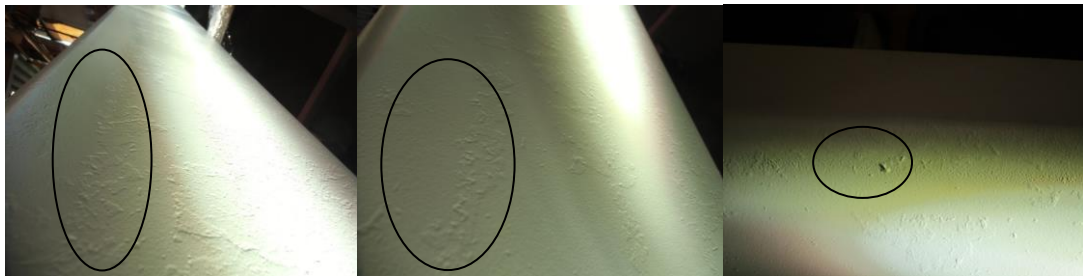
Surfaces of hot-rolled steel

The surfaces must not have any optical beads, recesses or linear grooves. Should this be the case, such errors must be removed prior to applying the varnish using suitable measures (filling the profiles is not permitted). Hollow steel profiles with irregular surface structures comprising rises and recesses are not tolerated.

Good surface in varnished state (optically even surface structure):



Bad surface in varnished state (not accepted at delivery):



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Colour-free surfaces

- The thread and fitted holes as well as all functional surfaces (according to drawing, e.g. running surfaces of crane rails) must be kept free from paint.
- All surfaces with a surface tolerance Rz 16 or better must be kept free from paint
- Faces of crossbars are only primed
- Joining surfaces type A: These joining surfaces must not be lacquer-coated but must be primed (without runners and edge structure).
- The lacquering must be without runners/edge structure.

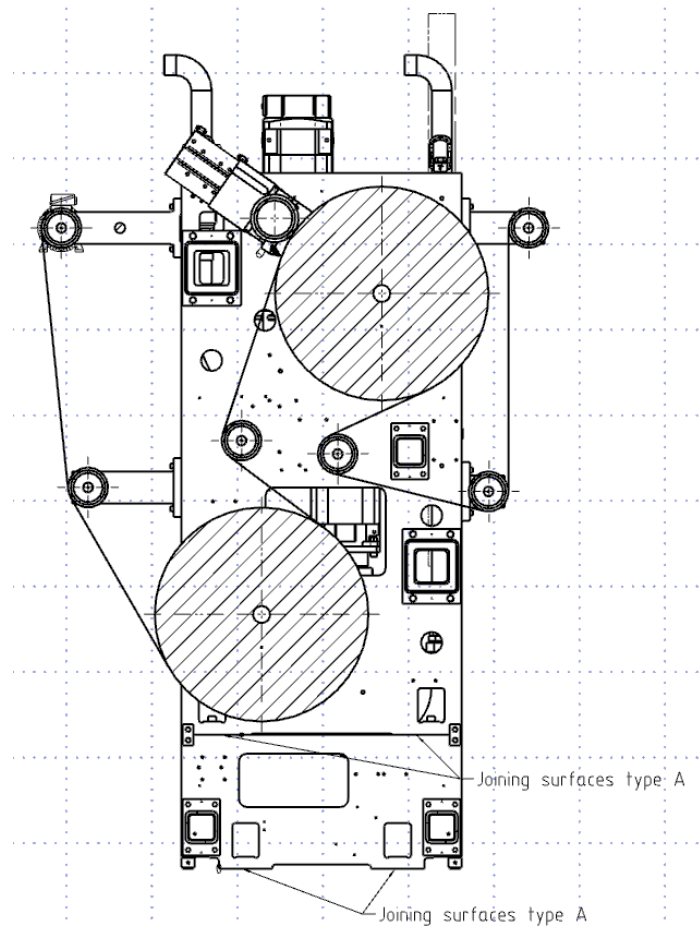


Figure 3 example

Design specification for painted surfaces

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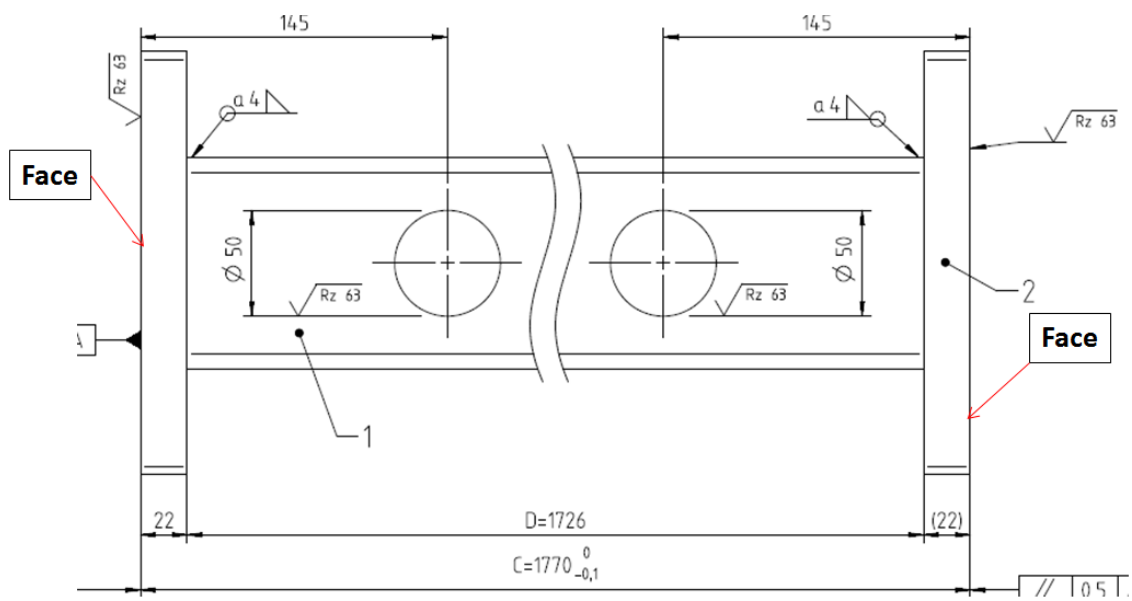
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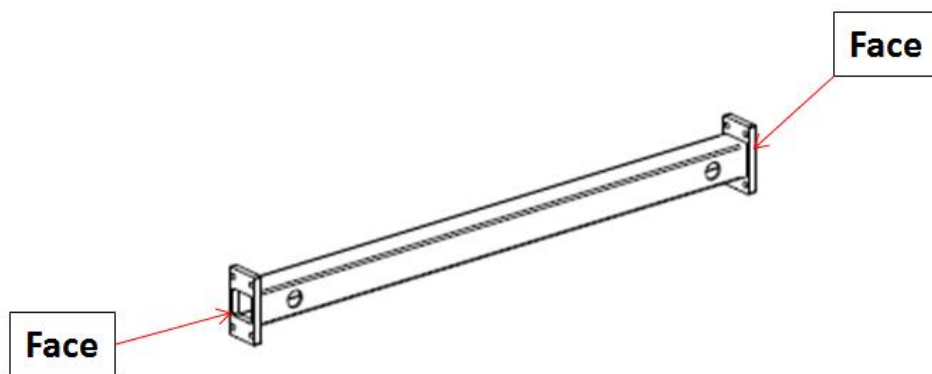
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Example faces crossbars 1



Example faces crossbars 2

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Colour key

- Machine frame
- Assembly group frame
- Screen/panelling 1
- Screen/panelling 2
- Hand rail
- Motors
- Switch cabinets
- Operator panels
- Safety installations

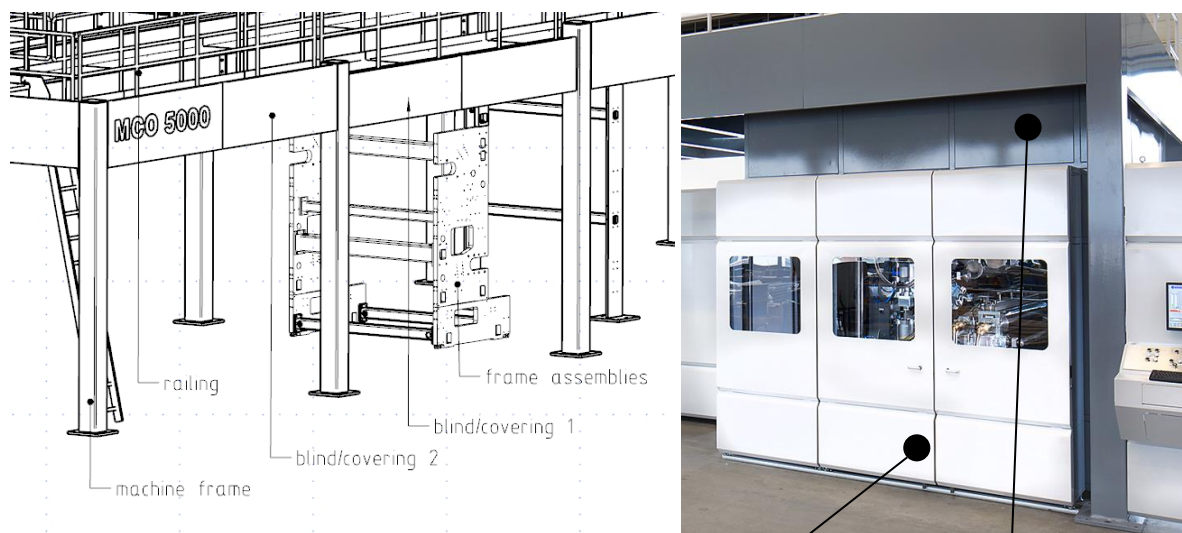


Figure 4 example

blind/covering 1

blind/covering 2

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