

SURFACE TREATMENT

14

Steel parts

Preliminary treatment: Steel parts are shot blasted all over with steel particles. All rust and foreign particles are removed and the blast dust is cleaned away. If necessary the surface of thin steel plates is ground to guarantee paint adhesion.

Primary paint: - Primary painting is done by spray painting. Painting, drying time and temperature is chosen according to paint manufactures instructions.
- MONO-COMPONENT REACTIF PRIMER PAINT, one layer, 30um.

Finishing paint: - Finishing painting is done by spray painting. Painting, drying time and temperature is chosen according to paint manufactures instructions.
- ACRYLIQUE POLYURETHANE, one layer 50 um color Black RAL 9004 (cover and cubicle are yellow RAL1021, equivalent yellow Sherwin-Williams F77Y32698-1242)

Total paint thickness: 80 um

Hoisting and traveling motors

The aluminum frame is anodized to black

Hoisting and traveling gear boxes

The gearboxes are painted Black Gray RAL 7021.