



9 Surface Treatment

9.1 Standard Painting System

	Wet painting		Alternative: Powder coating	
Product group	Steel parts, Load carrying parts	Steel parts, outfitting parts as covers, Aluminium parts	Steel parts, Load carrying parts	Steel parts, outfitting parts as covers, Aluminium parts
Parts and components	End plates Support beam Support of wedge locking Pulley support Hook block Hookd side plate Trolley	Covers Etc.	End plates Support beam Support of wedge locking Pulley support Hook block Hookd side plate Trolley	Covers Etc.
Class	C2M		C2M	
Standard/ Painting system	ISO 12944-5 S2.15 EP120/2-FeSa2½	EP80/1-FeSa2½	ISO 12944 EP/PE 120/1- [color code]	ISO 12944 EP/PE 100/1- [color code]
Steel work	05 (SFS 8145)	05 (SFS 8145)	05 (SFS 8145)	05 (SFS 8145)
Preliminary treatment	Wash, removal of grease Shot blasting Sa2½	Wash, removal of grease Shot blasting Sa2½	Wash, removal of grease Zinc- or ironphosphate	Wash, removal of grease Zinc- or ironphosphate
Priming paint	Epoxy priming paint 1x60 µm			
Finishing paint	Epoxy finishing paint 1x60 µm	Epoxy finishing paint 1x80 µm	Epoxy polyester powder coating 1x100 µm	Epoxy polyester powder coating 1x100 µm
Total paint thickness	120 µm	80 µm	100 µm	100 µm



9.2 Color Codes

Part	Color code
Hoisting unit	
Hoist frame	RAL 7021
Frame cover	RAL 1021
Hoist motor (frame)	Aluminum
Hoist motor (fan cover)	RAL 7021
Hoist gear (frame)	RAL 7021
Junction box	RAL 7021
Rope reeving	
Hook forging	RAL 7021
Cross bar	RAL 7021
Hook sheave cover plate	RAL 1021
Locking plate	RAL 7021
Sheave	RAL 7021
Sheave support	RAL 7021
Rope guide	Yellow passivated ¹⁾
Control enclosure	
Enclosure	RAL 7021
Enclosure support (Low headroom)	RAL 7021
Back plate (Low headroom)	RAL 7021
Counterweight	RAL 7021
Trolley	
Trolley, Double girder	RAL 7021
Trolley (others)	RAL 7021
Traveling machinery	
Travel motor (frame)	Anodised (black)
Travel gear (frame)	
Travel wheel	RAL 7021

EPOXY paint	Color
RAL 7021	Black gray
RAL 9006	Silver
RAL 1021	Cadmium yellow
RAL 1028	Melon yellow

¹⁾ Fe/Zn 12 cC ISO R 2081

²⁾ DIN 50961- Fe/Zn 12 A (Colorless)