

Standard paint finish

Standard paint finish IQ mk3, IQ mk2 Sizes 1-3, Q, IQT and CVA all sizes

Preparation

After machining, all castings are cleaned by dipping into an acid etch solution and then subsequently rinsed in a cold water rinse & de-ionised water rinse. Aluminium castings are then dipped in Gardobond® X4707 to provide all surfaces with a high corrosion resistance combined with excellent paint bonding properties. Cast Iron and steel components are immersed into a zinc phosphate solution for approximately 10 minutes and then cold water rinsed. All castings are then preheated to 100°C for approximately 10 to 15 minutes to remove all moisture prior to powder coating. The polyester powder coating is applied by electrostatic means to a nominal thickness of 75 microns. All castings are then cured at 200°C (Core temperature) for approximately 20 minutes.

Standard paint finish IQ mk2 sizes 4 and 5, A-Range, all sizes

Preparation

- 1 Iron castings are fettled to present a smooth surface after which they are dipped, before machining, in a synthetic red oxide primer to seal all surfaces.
- 2 Aluminium castings are treated, after machining, by dipping in Gardobond® X4707. This process gives all surfaces high corrosion resistance combined with excellent paint bonding properties.
- 3 Assembled actuators are then suitably masked and passed on a conveyor through an aqueous de-greasing plant operating at 70°C to the spraying stage.

Paint application

Preheated paint is applied as follows:

Undercoat

Manufacturer: International
Type: High build alkyd primer
Ref no: 'Interprime 306'
Min Film Thickness: 50.80 microns / 2.00 mills
Application: Air assisted airless electrostatic system

Top coat

Manufacturer: Cromadex
Type: Fast air drying alkyd
Ref no: '222 Top coat'
Min Film Thickness: 25.4 microns / 1.00 mills
Application: Air assisted airless electrostatic system

Total Dry Film Thickness: 76.2 microns / 3 mills
Total Drying Time: 12 hours

Standard paint finish for gearboxes all sizes

Preparation

- 1 Iron castings are treated with a phosphate solution. This process gives all surfaces high corrosion resistance combined with excellent paint bonding properties.
- 2 Assembled gearboxes are then suitably masked and passed on a conveyor through an aqueous de-greasing plant operating at 70°C to the spraying stage.

Paint application

Preheated paint is applied as follows:

Undercoat

Manufacturer: Manor coating systems
Type: Phenolic epoxy with rust inhibiting pigments
Ref no: 'PE3 Pennine primer'
Min Film Thickness: 25.4 microns / 1.00 mills
Application: Air assisted airless electrostatic system

Top coat

Manufacturer: Cromadex
Type: Fast air drying alkyd
Ref no: '222 Top coat'
Min Film Thickness: 25.4 microns / 1.00 mills
Application: Air assisted airless electrostatic system

Total Dry Film Thickness: 50.8 microns / 2.00 mills
Total Drying Time: 12 hours

Paint products and standard colours

Range	Paint manufacturer	Type	Colour/Finish
Q-range	Interpon	D36	RAL5005 Blue - Gloss
A-range	International/Cromadex	306/222	RAL7011 Dark Grey – gloss
Gearboxes	Manor coatings/ Cromadex	PE3/222	To match attached actuator
IQ mk1	Interpon	610	BS4800 00-A-13 Dark Grey - satin
IQ mk3, IQ mk2, 1-3 & IQT	Interpon	D1036	BS4800 00-A-05 Light Grey – gloss
IQ mk2, 4-5	International/Cromadex	306/222	BS4800 00-A-05 Light Grey – gloss
IQ mk2, mk3 - H/Auto & H/Wheel	Interpon	610	RAL9005 Black - satin
CVA	Interpon	610	RAL5010 Blue – matt

For customer specific colours, please contact Rotork.



UK head office
Rotork Controls Limited
tel Bath 01225 733200
fax 01225 333467
email: mail@rotork.co.uk

USA head office
Rotork Controls Inc.
tel Rochester 585 247 2304
fax 585 247 2308
email: info@rotork.com

As part of on-going product development, Rotork reserves the right to change specification without prior notice.
Published data may be subject to change For the latest version release visit our web site at www.rotork.com The name Rotork is a registered trade mark.
Rotork recognises all registered trademarks.