

## Painting cycle

The painting procedure is carried out on a fully automatic plant, which performs:

- cleaning and degreasing by means of an iron-phosphate degreaser at a temperature of 55°.
- water washing and degreasing by means of passivating products in two phases, in order to completely clean the surfaces and prepare them for painting.
- oven drying at 120°.
- painting by electrostatic application in automatic cabin (ensuring uniform layer of paint) with epoxypolyester powder coating paint.
- polymerization in oven at 190° for 18 minutes.
- thickness of paint layer 70/80 micron.

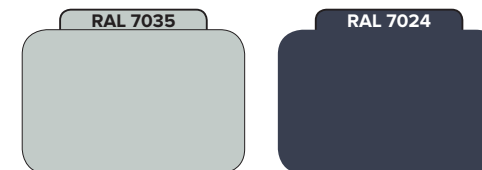
### MATERIALS CHARACTERISTICS:

- DESCRIPTION: grained semigloss epoxypolyester
- SPECIFIC WEIGHT: 1,62 +/- 0,05 Kg/dm cube
- CROSS LINKS: 160 °C x 20,00' (time and temperature of treatment applied on the item)
- THEORETICAL YIELD: 10,4 mq/Kg with paint layer of average thickness 70 micron
- GRAIN SIZE: standard below 100 micron

GENERAL NOTES ON THE FILM			
	TEST	VALUE	U.M. NORMS
MECHANICAL PROPERTIES	Test thickness	65 ±5	micron ISO 2360
	Aderence	GT0	ISO 2409
	Hardness	H-2H	ASTM D3363-74
	Impact resistance	>2,5	Nm ECCA T5
	Drawing	>5	mm ISO 1520
	Bending	5	mm ISO 1519
RESISTANCE TO CORROSION	Kesternich	100 cycles	no variation ISO 3231
	Saline mist	200 h	1 mm penetration on cross ASTM B117
	Deminerlized water	500 h	no variation ASTB D870
RESISTANCE TO SOLVENT. After 100 applications on the film of solvent, the average results are the following:	RESULT		
	Ethylalcohol - Butylalcohol	no softening	
	Benzene-toluene - xylene	llight softening	
	Cloroform -pecloroethane	strong softening	
	Methylethyketone-acetone	strong softening	
	Petrol	no softening	
RESISTANCE TO ACIDS AND BASES. After immersion for a month in diluted acids and bases of sheets of painted metal, the tests give the following results:	Diluted mineral acid (hydrochloric, sulphuric, phosphoric 10%)	no softening	
	Acetic acid 10% - lactic acid 10%	no softening	
	Sodium hydrate 10% - Potassium hydrate 10%	dissolution of film	
	Ammonia - ammonia hydrate 10%	dissolution of film	
	Citric acid 10%	no softening	

## Paint available

**STANDARD PAINTS:** All Quadritalia standard products are painted with epoxy-polyester powder coating paints. Monoblock structures, doors and external panels are painted RAL 7035 (glight grey) textured finish, plinths and lifting beams are painted RAL 7024 (grigio).



**SPECIAL COLOURS:** All RAL paints shown are always available on stock and quoted on request. Other RAL paints are available on request, as well as non-painted products or bi-colour products.

