



SURFACE COATING OF THE STEEL PARTS



ZINC COATING : Electroplated coating of pure zinc

In order to respect the requirements, 2 types of passivation have been selected according to their use :

- 1) Iron Zinc + passivation without Chromium IV with or without varnish = finishing stage 1
- 2) Iron Zinc + black passivation + varnish = finishing stage 2

The average thickness of the zinc is 10 microns.

A finish is obtained through the conversion coating by chromating the zinc coated. This finishing coat is designed to protect the zinc coating from corrosion.

Resistance to salt pray : all salt pray tests are carried out according to French standard NF ISO 9227.

FINISHING	WITH RUST	RED RUST
1	120 h	400 h
2	96 h	360 h

SHINY CHROMIUM-PLATED NICKEL

The average thickness is 15 microns. 1 coat of copper + coat of nickel 7 µm.

This coating is used for apparent interior parts that require a particular aesthetic. Resistance to ultraviolet rays according to French standard NF ISO 9227 : 24 hours.

POWDERED PAINTS

The coating of 60 microns minimum thickness is intended for decoration and anti-corrosion purposes. It is made in various standards colourings.

List of the principal colourings RAL used :

- White RAL 9010
- Brown RAL 8017 et 8019
- Cream RAL 9001
- Sand RAL 7016
- Grey RAL 7035
- Beige RAL 1015
- Black RAL 9005

Preparation of the steel before powder coating : iron zinc + passivation CHROMIUM III or thick phosphatation Zn8.

Resistance to salt pray according to French standard NF ISO 9227 : > 240 h.

Resistance to ultraviolet rays according to French standard NF T 30036 : > 300 h.



SURFACE COATING OF THE ALUMINIUM PIECES



ANODIC OXIDATION

This surface coating is carried out by Class 10 anodisation (10 to 15 µm).

POWDERED PAINTS

The coating of 60 microns minimum thickness is intended for decoration and anti-corrosion purposes.

It is made in various colourings :

White	RAL 9010
Brown	RAL 8017 and 8019
Cream	RAL 9001
Sand	RAL 7016
Grey	RAL 7035
Beige	RAL 1015
Black	RAL 9005

Preparation of the aluminium before painting : conversion/passivation with Chromium III. Resistance to salt pray according to French standard NF ISO 9227 > 240 h.

Resistance to ultraviolet rays according to French standard NF T30036 > 300 h.

SURFACE COATING FOR PLASTIC PIECES



LIQUID PAINTS

Polyurethane basis

Coating used on plastic pieces for small or occasional needs in a particular colour.

List of the principal colourings RAL used :

White	RAL 9001, 9010 and 9016
Brown	RAL 8017
Grey	RAL 7035 and 7016
Beige	RAL 8015
Golden Oak	RAL 8003