



Applicable documents for the offer (version: 13.09.2024)

Commercial Notes - General and Purpose of this Document

We provide all of this guidance so that our customers can identify and avoid many errors that may be hidden in the design or component execution as early as the prototype phase.

It is assumed by us that the customer goods delivered to us meet the coating requirements, because the scope of our incoming goods inspection cannot cover a check of all reference points.

The present, applicable documents to the offer provide the binding information of Reisinger GmbH to its customers. They are binding as an integral part of the contract.

You can find more information about "Ordering correctly" [here](#).

For this reason, it is necessary that our customers observe this document and comply with the requirements contained therein.

The purpose of this document is to explain to the customer the standard procedure with the present orders. For a professional execution of the coating, we recommend an **initial sampling** to avoid hidden trouble spots.

Coating properties result from the technical data sheets based on the supplier information for the coating material used. They are for information purposes only and do not constitute any legal assurance of specific properties of the products or their suitability for a specific application. Mechanical damage prior to coating is the responsibility of the customer. Other quality assurance specifications must be agreed separately in writing.

1. Offer

Our price refers exclusively to the painting of the delivered parts. Additional customer requirements must be notified in writing and remunerated accordingly by the customer.

2. Quality inspections during series production

The tests included in the price are all standard tests according to QIB and AQL, General Test Level 2.

3. Initial sample inspection report

Initial sample inspection scopes must be defined by the customer in writing and ordered for a fee. The preparation of an initial sample inspection report is carried out according to VDA Volume 2.



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4. Acceptance test certificate

An acceptance test certificate is issued at the written request of the customer. The costs for this must be borne by the customer.

5. FMEA

The process FMEA of Reisinger GmbH can be viewed on site. Publication does not take place.

6. Product Steering Plan (PLP) & Requalification

All tests, except those mentioned in point 3, are to be defined by the customer and must be ordered for a fee. A requalification (only for all components that have already been sampled by the customer, insofar as the customer has given a series release for this and these products are still being coated) must be defined by the customer and ordered for a fee. The customer is responsible for the annual availability of the components to be tested by the end of February of the current year.

The customer's SQM can actively participate in the development of the desired PLP.

7. Audit

The customer can order audits based on IATF 16949 and VDA 6.3 or 6.5 from Reisinger GmbH. The prices for this depend on the duration of the audit. An independent 3rd auditor with current approval for the selected standard is accepted as the customer's auditor. Access to some of our production sites can be denied to him in this case.

8. Potential analysis

A potential analysis according to VDA 6.3 can be prepared by Reisinger GmbH for a fee.

9. IMDS

The creation of IMDS is subject to a fee for the customer.

10. Corrosion test

Corrosion tests must be defined and ordered in writing by the customer. Internal tests are carried out on the basis of templates provided by the QMB. External tests can be arranged by Reisinger GmbH. The costs for this are borne exclusively by the customer.

11. Certification status

The current status of all acquired certificates can be found on the website of Reisinger GmbH (<https://www.reisinger-gruppe.com/#Zertifikate>).

12. Risk analysis, liability, reject rate

In the event of damage to parts, we are liable up to a maximum of the cost of the coating price. Higher



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costs can only be charged after prior agreement. For this purpose, the customer's raw part prices must be available before the quotation is prepared in order to be able to carry out a risk analysis.

A reject rate of up to 2% is to be expected during painting. We reserve the right to a work-related scrap rate or shortfall of up to 2% without compensation. Any deviating scrap and shortfall quantities must be agreed in writing prior to the processing of parts.

13. Supplier self-disclosure

Reisinger GmbH issues a supplier self-disclosure in its own form.

14. Access to the production facilities

Access to our production facilities can only be granted by prior approval of Reisinger GmbH. In exceptional cases, this can also be denied. A joint execution of Run & Rate is not intended.

15. Change notice

Reisinger GmbH must be informed immediately of any change that occurs at the customer's with regard to the raw parts to be coated. Drawings and other required documents must also be provided to Reisinger GmbH immediately.

16. SPC

SPC does not apply to painting processes and is not managed.

17. Complaints and warranty

8D reports are not created for prototype parts.

For series parts, the processing of complaints takes place in 8D form. Please submit your complaints immediately and in writing no later than the third day after receipt of the goods, but in any case, before they have been assembled, modified or further processed. We will rework the defects caused by us within a reasonable period of time, either on the spot or after returning the goods, free of charge.

Liability for consequential harm caused by a defect is limited to the amount of the order sum. The liability for compensation according to the product liability law is excluded.

Manufacturing properties of the coating (color tone, gloss) cannot be influenced by us.

We reserve the right to charge you for complaint costs (internal and external laboratory tests) if the defects complained about by you are not the responsibility of us or our suppliers. A warranty on our part is excluded if the defects have arisen for the reasons listed in these notes.

The warranty is 2 years.

Please be considerate of the goods you are complaining about and pack the return properly so that it is not damaged on the return transport and is therefore not liable for damages.



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18. Consulting

The technical advice provided by us cannot replace an investigation to be carried out by the customer with regard to the suitability of the product for a specific application. Download materials courtesy of [QIB](#) and Axalta.

19. Definition of the standards to be met, fulfillment of OEM specifications

If you already have defined requirements for the coating in the form of a standard, please send them to us with the coating request. For more information on the fulfillment of some OEM specifications of the material used by us, please click [here](#). The standard listed in the offer is contractually binding.

All information and data exchanged with our business partners are subject to protection class "internal" (V2) assigned. Highly sensitive information of the protection classes "confidential" (V3) and "strictly confidential" (V4) must be classified as such by you, scheduled and indicated to us with the request.

20. Delivery

Please note the following information on the order:

- the designation of the parts (name, number)
- The number of pieces
- Process (cathodic dip coating, powder coating or wet painting)
- exact color definition - if a coating system is ordered (parts with different color shades must be marked and delivered separately)
- the surface structure (for coating system - see Technical Specification Powder Coating).

21. Definition color and surface texture

KTL: The electrophoretic coating we use has a black color (similar to RAL 9005) and can be applied to conductive substrates in three layer thicknesses. You can find more information about the paint [here](#).

POWDER: Please define which color you want your component to have, its surface texture (coarse or smooth), its gloss level (matt, satin, glossy). You can find more information about colors and the gloss level [here](#).

22. Technical notes - General and purpose of this document

We ask you to observe the following instructions for preparing the workpieces so that the quality of our coating will be to your complete satisfaction. The purchaser is hereby informed in detail about the measures he has to take to ensure that the goods delivered by him



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- meets the requirements for the base material
- is constructed and conserved in a manner suitable for coating
- is in a coatable condition
- is suitable for coating after matching material properties and technology

23. Dimensions of the components

Please note that our KTL process can coat the components with max. length 2500 mm, max. width 1000 mm, max. height 1500 mm and max. load of 300 kg

Please note that our powder process can coat components with max. length 7000 mm, max. depth 1600 mm and max. height 2000 mm and max. load of 450 kg

24. Corrosion resistance

Please define the requirement for durability against corrosion on your components according to your application. The corrosion resistance of our paint system results from the information given in the technical data sheet of the paint manufacturer. The technical data sheet for the KTL paint can be found

Please check the defined requirement for durability against corrosion on your components according to your application. Take into account the intended installation site, the area of use (seaside or inland, outdoor or indoor) and possible contact with aggressive substances (acids, alkalis, oils, gasoline, solvents, graffiti). Please apply a surface preparation degree corresponding to the corrosivity category. Further information on the individual degrees of preparation can be found [here](#).

If a cathodic dip coating alone is not sufficient to meet your corrosion requirements, then we recommend an additional top coat according to the required corrosivity category. You can find an overview of the corrosivity categories [here](#).

Without information on the requirements for corrosion protection, we coat with powder the workpieces made of steel and aluminum with chemical pre-treatment in a layer structure. The corresponding stress group can be found [here](#) in the current appendix to the QIB award certificate.

25. Types of paint according to the type of resin (concerns only powder coating)

Epoxy resin coatings have high chemical resistance, good adhesion and corrosion properties. Weather resistance is low. They are only suitable to a limited extent for optical exterior applications.

Polyester coatings are characterized by good weather resistance and good adhesion and corrosion properties. Chemical resistance is often low.

Polyurethane coatings generally have good chemical resistance, as well as high weather resistance. Whether the mechanical properties meet the requirements must be checked in advance.



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Polyacrylates are weather resistant but have rather low chemical resistance and often poor mechanical properties. They are often incompatible with other types of coating. A test coating is therefore strongly recommended.

26. Requirements for the optical appearance of KTL coating

Please note that KTL is a functional coating, which focuses on the corrosion protection of a component, and not a visible coating. The KTL coating is not suitable for direct UV irradiation and for this reason should not be used outdoors.

27. Requirements for the visual appearance in powder coating: Definition of decorative surfaces (visible surfaces)

Depending on whether your part is a functional or decorative coating, different criteria (QIB optics levels) can be applied when evaluating the coating (Non-Visible Area, Secondary Visible Area, Main Visible Area, Exceptional, High, Standard, Low).

Please define these based on what the end customer sees of the coated component in the mounting position. An overview of the QIB optics levels with the associated viewing conditions can be found [here](#).

If the customer does not have a definition of the requirement for the appearance of his components, then the coating of his products is considered according to QIB requirement level Standard Level II.

28. Intended use

Please name the subsequent processes (e.g. bonding) the installation location and position as well as the intended use and maintenance of the parts to be coated for the purpose of fully determining the possible product requirements.

29. Chemical resistance for KTL coating

The chemical resistance of our coating system results from the information given in the technical data sheet of the coating manufacturer. You can find the technical data sheet for the coating [here](#).

The required chemical resistance of a coating must be clarified on the basis of the supplier's coating material specifications even before application. Please check the defined chemical resistance requirement for compliance with the information provided in the technical data sheet.

30. Chemical resistance, food fastness, dissipative properties with powder coating

The required chemical resistance of a coating must be clarified on the basis of the supplier's coating material specifications even before application.

If your products will come into contact with foodstuffs, please inform us so that they can be coated by us with food-grade powder coatings.



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If a non-electrically chargeable coating is required, please inform us before so that a dissipative powder can be selected.

31. Bonding, adhesion of sealants and adhesives

For bonded parts, the compatibility (temperature, contamination, chemicals) of the adhesive with the pretreatment and coating process must be clarified. If your parts are subsequently bonded, we request information about this. In addition, we request a validation of the bonding with regard to the adhesion of this application.

32. Suspension holes / contacting

All parts are coated hanging, so we need holes or eyelets for their suspension. For tubes there is a possibility of plugged suspension. The parts to be coated must be submersible and free of drilling and sawdust. A reduced coating thickness of up to 1 cm² or a bare spot must be expected at the contact point. Further information

"Designing for Coating" can be found [here](#).

In the case of powder coating, from 3 to 7m component length, deformation can occur due to the dead weight as well as the static inherent stability during the baking process of the powder coating at 200°C. In this case, several suspension holes are required.

33. Water drain holes / vents

Components which are to receive a coating in a dipping process require an inlet and vent hole of at least 10 mm in diameter to allow the medium to drain off again. This is necessary to prevent steam escaping during the baking process and destroying the coating layer.

Vent holes must be drilled in the cavities to be coated to prevent the formation of air bubbles in this interior area. Closed hollow components must be absolutely tight. Further information can be found [here](#).

If water penetrates the hollow structures due to the pretreatment, the drill holes (at least 3 mm) are made at the deepest point of these parts to allow the water to drain off again. You can find more information on the topic of "Coating-compliant design" [here](#).

34. Requirements for the material at delivery

Please only supply us with goods that are free of machining residues, damage, soiling, old coatings, adhesive residues, silicone residues and surface defects. Further information on the topic: "Requirements for the base material" can be found [here](#).

Mechanically machined surfaces (e.g. turning or milling) often have a very low roughness, especially within the turning depths of less than 1 µm. On such surfaces, adhesion is impaired for some coating buildups because the coating material cannot anchor sufficiently mechanically in the substrate. If such surfaces are to be painted on the components, adhesion must also be tested on these surfaces. To improve adhesion, the surfaces can be roughened mechanically.



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Labels and adhesive tapes must be removed from the workpieces without leaving any residue. Necessary stickers should be placed on non-visible sides of the parts.

Please remove all markings applied with non-washable pens before delivery. Do not place necessary markings on the visible surfaces.

35. Masking and masking work

Masking work is not carried out as standard but must be requested separately at the time of inquiry. They are necessary to prevent sealing surfaces, bores, threads, etc. from being coated unintentionally. For this purpose, it is essential to use covering and masking materials that are heat-resistant (200°C for KTL, and 250°C for powder coating).

The KTL traces of wear and tear that can arise when covering a thread due to residues of oil in the thread, play in the screw connection or gaps between the cover and the core diameter of the thread cannot be avoided and cannot be complained about. In the manual covering process, infiltration of the cover (plugs in holes, adhesive tape on surfaces) cannot be ruled out and is not a reason for complaint. When removing the covers, burrs and traces of paint are unavoidable.

Please clearly mark the paint-free areas with dimensions on the delivery bill.

36. Scratches, burrs, sharp edges

Harmoniously rounded edges are considered to be the geometrically ideal edge characteristics in terms of maximum corrosion protection performance. During crosslinking, the paint retreats over the sharp edges and ridges and no longer forms a closed layer at the edge, so any kind of sharp edges and ridges should be avoided at all costs.

The standards for supporting structures prescribe an edge radius of 2 mm, while the standards for industrial plants and turbines prescribe an edge radius of 3 mm.

A chamfered edge should have a width of at least 0.5 mm. Edges on holes should be rounded off with a taper countersink. Further notes on the subject of edges can be found [here](#) and [here](#).

37. Rust / Oxide

Please supply rust-free parts. Rust formation on the metal causes a lack of adhesion of the coating. You can avoid this by proper storage, use of silicone-free anti-corrosion oils and application of gloves.

Existing rust layers can be removed by blasting or grinding. Poorly ventilated crevices can lead to constant wetting and rust formation due to hygroscopic deposits.

For parts with quality requirements, rolling skin and scale layers must be removed before coating by means of sandblasting, grinding, brushing. Further instructions can be found [here](#) and [here](#).

38. Grease and oil contamination at internal points

Grease and oil contamination at internal points often only becomes apparent after the firing process. Grease and oil deposits liquefy at the firing temperature and flow out, especially in the case of hollow



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constructions from leaking welds to the outside. This makes it impossible for paint to adhere to the leaking areas.

Please ensure that you use coolants and lubricants that are compatible with the coating process and can be removed without residue using aqueous cleaner (VDA-approved). Preservative oils must not gum up or crack, even during prolonged storage.

39. Silicone is prohibited!!!

Always avoid using silicone and materials containing silicone. Before coating, it is impossible to tell whether a surface has been in contact with silicone or not. Only after the baking process can it be seen whether there are silicone residues on the workpiece.

40. Laser cutting, laser welding, welding, hot straightening

After processes such as laser flame cutting, laser welding and resistance welding in an oxygen atmosphere (without inert gas) as well as welding and hot straightening, in which thermally induced surface impurities (oxidation layers, martensitic edge structure and tarnish) are formed, mechanical cleaning of the components to a depth of at least 0.3 mm must be carried out by the person responsible for the heat process, as otherwise oxide layers will form there which will make adhesion to these areas impossible. Further information can be found [here](#).

41. Welds

An insulating silicate layer (brown spots, also called vitrification) is formed on the weld seams during welding, on which the cathodic dip painting and powder coating cannot deposit. If this glazing is undesirable for optical reasons, it can be removed by brushing, grinding or blasting before coating, or partially overpainted with repair paint after cathodic dip coating. From a functional and cost point of view, this action would be negligible.

Glazing on weld seams of components with optical requirements, which are to be powder-coated after cathodic dip coating, must be removed mechanically (brushing, grinding, brushing) before cathodic dip coating. In such cases, the use of KTL repair paint is not recommended. Heat-affected zones occur on the other side of a weld seam, where oxide layers can form. These should be removed subsequently. Further information can be found [here](#).

42. Soldering

During brazing, glass-hard residues of a flux used for clean flow remain on the part. In addition, the brazing flame burns off the oil on the component and forms oil carbon, soot and oxide. These undesirable by-products must be removed without leaving any residue. We do not recommend soft soldering because the KTL furnace temperature is above the melting point of soft solder and can cause "desoldering".



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43. Inserted bolts and sheet metal doublings

It is essential to ensure that bushings, bolts, threads, doublings, etc. are only inserted free of grease and tightly so that no oil residues escape and make paint adhesion impossible. If a tight sheet metal doubling cannot be realized, then please ensure a gap of at least 2 mm. For more information click [here](#).

44. Bimetallic corrosion (contact corrosion)

Contact corrosion can be formed by two different (more noble and less noble) metals if they have an electron conducting connection (in direct contact) and different corrosion potentials and are connected by a moisture film (electrolyte). The ratio of the more noble material to the less noble material should be kept very small at the point of contact, or the different materials should be separated by an insulating layer. Further information can be found [here](#).

45. Castings, outgassing and demolding lubricants

All types of castings gas out and form bubbles under the paint or even in the material. The high temperatures in the furnace favor stronger spreading of the blowholes. Please note, if vibratory grinding technique is used for reworking, that the grinding residues, are removed by means of blasting. A mold that is particularly intensively lubricated with release agents during the casting process has a negative effect on paint adhesion.

46. Passivation

Hot-dip galvanized and strip galvanized components are often sealed with temporary corrosion protection (S) or chemically passivated (C) to prevent the formation of corrosion products.

The applied temporary corrosion protection can only be determined with difficulty by the piece coater. Temporary corrosion protection layers cannot be removed reliably in the pretreatment process, which can lead to considerable adhesion problems during subsequent piece coating.

In the case of piece coating, the components must therefore be delivered without passivation or the coater must be informed in advance about the type of passivation applied.

47. Stainless steel parts

Due to low roughness of the stainless steel parts, lower adhesion of the coating can be expected. For heavily stressed surfaces, blasting with ferrite-free materials is recommended. Thin sheet metal parts should first be primed with a cathodic dip coating to improve adhesion. We do not give any warranty for the coating of stainless steel parts.

Due to the weak and also strongly fluctuating magnetizability of stainless steel, the coating thickness cannot be measured at all or not reliably with magnetic inductive or eddy current probes.



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48. Galvanized parts / Duplex

Unevenness in piece-galvanized parts cannot be avoided. Depending on the steel quality, outgassing occurs during the baking of the cathodic dip coating. Due to the large number of possible influences, it is hardly possible to describe the subsequent coating quality.

Please inform your galvanizing company in advance that the parts will be KTL coated. Please note the following points:

- Keep workpieces free of white rust
- do not have a high zinc coating applied
- Do not expose parts to the weather
- Let the parts sweep 12 hours before coating at the earliest

Further information on the subject of "Coating of hot-dip galvanized workpieces" can be found [here](#).

49. Extraneous blasted parts

Parts blasted with corundum or steel shot lead to a considerable risk of corrosion and can also cause roughness and air inclusions under the paint layer. Workpieces processed with blasting balls, glass beads are not problematic, but this method does not increase the surface area to improve paint adhesion. Further information can be found [here](#).

The blasted parts should have a roughness Rz (maximum profile height) not exceeding 30% of the dry film thickness (recommended for the coating to be applied).

50. Rework

If your parts need to be touched up for any reason described above, we ask that you actively assist us in determining the best touch-up option.

51. Overcoating

We cannot give any warranty on parts that have already been externally coated (if the customer wishes to overcoat them). In this case, we recommend carrying out a coating test.

52. Filler

Filling media based on polyester or epoxy resins must not be used, because they are neither electrically conductive nor thermally stable. Filling over a wide area always favors outgassing or paint peeling, which leads to different powder runs between filled and unfilled areas. Please inform yourself before carrying out spatula work on the parts to be coated.

53. Aluminum

For aluminum, use only high-quality material alloys and avoid production-related deposits such as press fleas and graphite residues, as well as a surface roughness of more than 9µm Rmax. These have a negative effect on the coating appearance.



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54. Packing, storage and transport

For the packaging, transport, quality assurance and storage of series materials, series parts and series products, customers should provide suitable stackable reusable packaging, containers and load carrier systems which protect their contents against transport damage and mechanical and climatic stresses.

If we do not have any packaging instructions, we will pack the goods appropriately to the best of our knowledge and belief. The packaging materials used by us (bubble wrap, cardboard boxes, etc.) are not suitable as permanent packaging, but are to be understood exclusively as transport protection. Remove the packaging immediately after receipt and never expose to sun, heat, moisture or high temperatures.

Our shipping packaging and filling materials are not licensed for shipping with parcel carriers (DHL, DPD, Hermes, UPS, etc.) and therefore not insured for transport. If, at the customer's request, Reisinger delivers the ordered item by parcel post, the risk shall pass to the customer as soon as Reisinger has delivered the item to the forwarding agent, the carrier or any other person or institution designated to carry out the shipment.

Finished goods which are not collected within 3 weeks shall be stored by us at the expense of the customer or sent to him at his expense for a maximum period of 3 months from the beginning of the default in acceptance. After the expiry of 3 months, we shall be entitled to dispose of the goods.

Further information on the storage and transport of coating materials can be found [here](#).

55. Subsequent mechanical processing

In the case of subsequent mechanical processing, the following points must be observed:

- Clamping the components for mechanical processing can lead to impressions and scratch marks at the clamping point
- Bending: the suitability of the KTL coating with regard to the planned bending (bending radius) is not defined in the technical data sheet of the KTL coating manufacturer. If the coated parts are subsequently deformed by bending, then their suitability must still be checked before series production by tests after coating on original parts
- When milling and drilling, always use sharp-edged tools and constantly take care against local overheating by sufficient cooling.
- Compatibility and resistance of the coating with the cooling lubricants used must be clarified in advance

56. Cleaning and care after coating

For maintenance cleaning, use only pure, lukewarm water with small additional quantities of a pH-neutral cleaning agent. Remove grease, oil and sticker residues with petroleum ether or isopropyl alcohol. Do not use solvents for cleaning. Treat parts with soft cloths or cleaning cotton.

You can find more information on the topic of "Care of coated surfaces" [here](#).



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57. Technical specification of Reisinger GmbH KTL coating

If the customer has not provided a special specification of his requirements for the cathodic dip coating, the following standard is used at Reisinger:

58a. Tint and gloss

Color black similar to RAL 9005, gloss not defined, not UV resistant.

58b. Pretreatment

Degreasing and zinc phosphating.

58c. Film thickness

> 15 µm.

A meaningful measurement of the coating thickness for blasted goods only results if the coating thickness to be measured is greater than or equal to two times the Rz roughness of the substrate (coating target $\geq 2 \times$ substrate actual Rz)

58d. Mechanical properties on Gardobond 24 T OC sample sheet

Cross cut according to DIN EN ISO 2409: $Gt \leq 1$.

Cupping test according to DIN EN ISO 1520: 4mm.

58e. Corrosion resistance

Salt spray test according to DIN EN ISO 9227 NSS: 500 h. infiltration $d < 1.0$ mm Salt spray

test according to DIN EN ISO 9227 NSS: 1000 h. infiltration $d < 1.5$ mm Condensation water

constant climate test according to DIN EN ISO 6270-2: 500 h. without change.

58f. Incoming goods inspection

Visual inspection of the number and external integrity of the delivered packaging units.

58g. Process monitoring on sample sheets

According to QIB regulations.

58h. Finished product control

According to QIB regulations. Visual inspection of the closed surface.



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58i. Rework

Paint spray Würth 0893 349 005, RAL 9005 deep black, silk gloss, cannot be overcoated.

58j. Transport packaging

As delivered by the customer - sized in delivery containers with intermediate layer.

58. Technical specification of Reisinger GmbH Powder coating

If the customer has not provided a special specification of his requirements for the powder coating, the following standard is applied at Reisinger.

59a. Shade, surface texture and gloss

Standard is color tone according to RAL, smooth, glossy 80%.

59b. Pretreatment

Pickling and oxsilane on substrate aluminum and substrate galvanized steel.

Degreasing and iron phosphating on substrate steel.

59c. Film thickness

> 50 µm for single-layer system

> 110 µm for two-layer system (base and top powder)

A meaningful measurement of the coating thickness for blasted goods only results if the coating thickness to be measured is greater than or equal to two times the Rz roughness of the substrate (coating target $\geq 2 \times$ substrate actual Rz)

59d. Mechanical properties on QIB sample sheet

At least QIB stress group 1 (C1-H).

59e. Corrosion resistance

At least QIB stress group 1 (C1-H).

59f. Incoming goods inspection

Visual inspection of the number and external integrity of the delivered packaging units.



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59g. Process monitoring on sample sheets

According to QIB regulations.

59h. Finished product control

According to QIB regulations

Visual inspection according to QIB, optics level 2.

59i. Rework

Overcoating with the same powder coating.

59j. Transport packaging

As delivered by the customer - sized in delivery containers with intermediate layer.

59. Technical specification of Reisinger GmbH KTL and powder coating

If the customer has not provided any special specification of his requirements for the cathodic dip and powder coating, the following standard is applied at Reisinger.

60a. Shade, surface texture and gloss

Standard is color tone according to RAL, smooth, glossy 80%.

60b. Pretreatment

Degreasing and zinc phosphating.

60c. Film thickness

> 15 µm KTL

> 65 µm for two-layer system (KTL and powder)

> 125 µm for three-layer system (KTL, base and top powder)

A meaningful measurement of the coating thickness for blasted goods only results if the coating thickness to be measured is greater than or equal to two times the Rz roughness of the substrate (coating target $\geq 2 \times$ substrate actual Rz)

60d. Mechanical properties on QIB sample sheet

At least QIB stress group 1 (C1-H)



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60e. Corrosion resistance

At least QIB stress group 1 (C1-H).

60f. Incoming goods inspection

Visual inspection of the number and external integrity of the delivered packaging units.

60g. Process monitoring on sample sheets

According to QIB regulations.

60h. Finished product control

According to QIB regulations

Visual inspection according to QIB, optics level 2.

60i. Rework

Overcoating with the same powder coating.

60j. transport packing

As delivered by the customer - sized in delivery containers with intermediate layer.