

## **Procedure for surface treatment**

### **Applicable for:**

- Hydraulic motors in black steel
- Gear boxes in black steel
- Other smaller components in black steel placed in wet processing areas

### **Procedure:**

1. Unpack carefully
2. Remove identification sign plate and make sure it is returned to same component
3. Degrease as necessary
4. Protect stainless steel parts (shaft, gasket ring, and equal)
5. Shotblast to SA 2,5
6. Clean as necessary
7. Metallize by hot zinc spray - 80-100 microns
8. Airless spray-paint – epoxy sealer aluminum- 15-25 microns
9. Airless spray-paint Acrylic Polyurethane topcoat 100 microns  
Colour RAL code 7001 – Light Grey
10. Drying 9 hours at +25 degC
11. Fix same sign plate by high quality glue
12. Pack in same packing as received

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