

Title:

GENERAL COATING SPECIFICATION

1. This document relates to Kinetrol components made from aluminium alloy or zinc alloy which are coated prior to assembly. Ferrous components (e.g. shafts, couplings etc) are outside of the scope of this document.
2. Surface preparation of components prior to coating is by either by an abrasive process, or washing in a hot water and detergent solution, or a combination of both, regardless of the type of coating to be applied.
3. Kinetrol's standard finish⁽¹⁾ is a single epoxy powder coating generally applied by electrostatic spraying plant and oven cured.
Coating thickness⁽²⁾: 0.025 to 0.125mm
Adhesion chip test in accordance with BS AU 148-5:1969
⁽¹⁾ Except for internal faces of actuator model 15 and larger; See paragraph 4.
⁽²⁾ internal faces of actuators are coated to a maximum thickness of 0.04mm.
4. Internal surfaces of actuator model 15 and larger are coated with a PTFE based coating and oven cured.
5. For applications where high corrosion or chemical resistance is required, e.g. greater than 1000 hours salt spray, Kinetrol offers the option of anodising aluminium alloy components or chromate passivating zinc alloy components prior to coating.
6. For applications within the food processing industry, where required, Kinetrol offers the option of anodising aluminium alloy components or chromate passivating zinc alloy components prior to coating with "food grade" coatings, which meet the requirements of German BfR L1 and FDA 21 CR 175.300. See Kinetrol document TD194 for details.
7. Other coatings available on request.
8. The policy of KINETROL is one of continuous improvement; We reserve the right to alter the processes as described without notice.

Issue	Signed	Date	KINETROL Trading Estate Farnham Surrey England	Doc.No. TD 200
A	T.L.	04/07/18		Page 1 of 1