

rotork® Controls

Standard paint finish IQ mk3, IQ mk2 – sizes 1-3, Q, IQT and CVA – all sizes

Preparation

After machining, all castings are cleaned by dipping into an acid etch solution and then subsequently rinsed in a cold water rinse & de-ionised water rinse. Aluminium castings are then dipped in Gardobond® X4707 to provide all surfaces with a high corrosion resistance combined with excellent paint bonding properties. Cast Iron and steel components are immersed into a zinc phosphate solution for approximately 10 minutes and then cold water rinsed. All castings are then preheated to 100 °C for approximately 10 to 15 minutes to remove all moisture prior to powder coating. The polyester powder coating is applied by electrostatic means to a nominal thickness of 100 microns. All castings are then cured at 200 °C (Core temperature) for approximately 20 minutes.

Standard paint finish IQ mk2 – sizes 4 and 5 A-Range – all sizes

Preparation

- 1 Iron castings are fettled to present a smooth surface after which they are dipped, before machining, in a synthetic red oxide primer to seal all surfaces.
- 2 Aluminium castings are treated, after machining, by dipping in Gardobond® X4707. This process gives all surfaces high corrosion resistance combined with excellent paint bonding properties.
- 3 Assembled actuators are then suitably masked and passed on a conveyor through an aqueous de-greasing plant operating at 70 °C to the spraying stage.

Paint application

Preheated paint is applied as follows:

Undercoat

Manufacturer: International
Type: High build alkyd primer
Ref no: 'Interprime 306'
Min Film Thickness: 50.80 microns / 2.00 mills
Application: Air assisted airless electrostatic system

Top coat

Manufacturer: Cromadex
Type: Fast air drying alkyd
Ref no: '222 Top coat'
Min Film Thickness: 25.4 microns / 1.00 mills
Application: Air assisted airless electrostatic system

Total Dry Film Thickness: 76.2 microns / 3 mills
Total Drying Time: 12 hours



Standard Paint Finish

Standard paint finish for gearboxes – all sizes

Assembled gearboxes are de-greased with a phosphoric wash that provides improved paint adhesion and increases the corrosion protection of the total paint system.

The gearboxes are suitably masked prior to painting.

Paint application

Paint is applied as follows using a plural component mixing system and air assisted airless/electrostatic spray equipment.

Undercoat

Manufacturer: International
Type: 2 pack epoxy
Ref no: Intercure 200
Min Film Thickness: 75 - 300 microns
Application: Air assisted airless system

Top coat

Manufacturer: International
Type: 2 pack Polyurethane full gloss
Ref no: Interthane 990
Min Film Thickness: 50 - 150 microns
Application: Air assisted airless electrostatic system

Total Dry Film Thickness: 125 - 450 microns
Total Drying Time: 90 minutes at 80 °C

Keeping the World Flowing

Paint products and standard colours

Range	Paint manufacturer	Type	Colour/Finish
Q-range	Interpon	D36	RAL5005 Blue – gloss
A-range	International/Cromadex	306/222	RAL7011 Dark Grey – gloss
Gearboxes	International	Intercure 200 Interthane 990	As per actuator unless otherwise specified
IQ mk1	Interpon	610	BS4800 00-A-13 Dark Grey – satin
IQ mk3, IQ mk2, 1-3 & IQT	Interpon	D1036	BS4800 00-A-05 Light Grey – gloss
IQ mk2, 4-5	International/Cromadex	306/222	BS4800 00-A-05 Light Grey – gloss
IQ mk2, mk3 – H/Auto & H/Wheel	Interpon	D1036	RAL9005 Black – satin
CVA	Interpon	D1036	RAL5010 Blue – matt

For customer specific colours, please contact Rotork.

For certain light colours, a double coat may be required. Contact Rotork for more information.

A full listing of the Rotork sales and service network is available on our website.

www.rotork.com

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