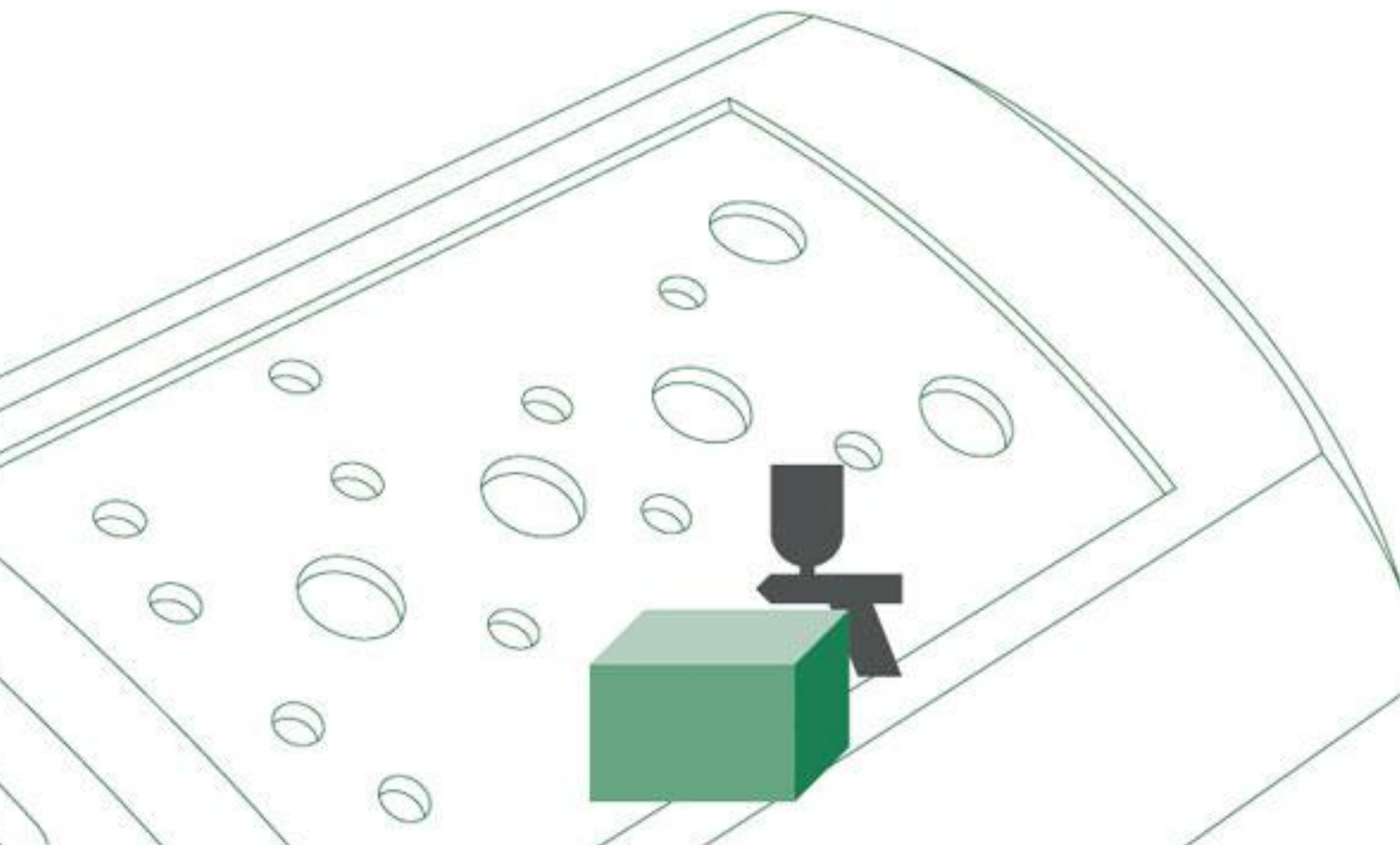


LACQUERING



SERVICES

On demand, we can paint your enclosures at a reasonable cost using high-quality acrylic and 2-component lacquers. Individual finishing increases the value of your products, for example

Soft-Touch

imitation leather-type coating to improve the appearance and “feel“ of your product

Metallic-colours

with especially good mechanical qualities

UV lacquer

to protect the case from UV radiation

Standard lacquers are matt, adjustable in all brilliant degrees with especially good mechanical qualities.

Incomplete information makes the working process complicated and time-consuming. We should therefore like to inform you in the following of the specifications required to ensure smooth implementation, from the formulation of the requirements through the inquiry to the order.

We would be delighted to advise you on our most favourable, technological approaches.

DESIGN EXAMPLES



GENERAL INFORMATION

- Part-No. Of the standard enclosure of tuning knob
- Repeat order with/without modification
- Quantity
The number of pieces delivered may vary by +10% from the order quantity.
For order quantities that are not to be undershot, please give us specific notification.
- Intended price
- Required delivery period
- Part-No. and designation of the additional parts
If orders are placed, additional parts are given an OKW Part-No. The delivery of these parts must be announced on time with information of our Part-No.
Please note this on the delivery note for shipment. No quality tests are carried out on additional products by the incoming merchandise department.

Scheduled delays of complete shipments due to late supply have to be borne by the customer.



LACQUERING

- according to the drawing no., status, date (if required date of receipt)
- according to sample
- according to last delivery with/without modification

TECHNICAL REFERENCES

- colour definition acc. to sample, range of dyes, RAL, Pantone or NCS; colour deviation Delta E = 2.5 possible

The following colours are possible for soft touch lacquering:

All RAL and Pantone colours (metallic tone like white-aluminium or silver on demand)

- definition of requirements to be met by lacquer in terms of resistance to weathering, resistance to solvents or the like (resistance of lacquers see below), material data sheet for lacquer available on request
- surface finish matt (standard), glossy on request
- all lacquers UV-resistant
- with cases with aluminium vapour plating, a proportion of the equipment costs must be taken into account
- The following OKW products are not available with soft touch lacquering:
DIN-MODULAR CASES, POTTING BOXES, RAILTEC, Aluminium parts, tuning knobs made of Duroplast.

The cases are lacquered on the visible surfaces; however, lacquer mist may occur on the inside. Adhesion problems may occur on sharp edges.

RESISTANCE OF LACQUERS

	2-components lacquer*
Acetone	- /regenerated partially
Petrol (cleaning petrol)	+
Petrol "Super"	o
Diesel oil	-
Grease	+
Hand cream	+
Sea water	+
Hydrochloric acid 10%	o
Weak alkalis	o
Strong alkalis	-
Lactic acid	+
Glass cleaner	+
Ethanol	+
Resistance to weathering	+

+ = resistant, o = conditionally resistant, - = not resistant, unmarked = not tested

Material resistance may change through the simultaneous action of different media!

* The table only gives approximate values. Exact classification is dependent on:
Substrate (PS is more critical than, for example, ABS or PA) and
specification e.g. VDA 621-412 (concentration, testing method, duration of action, temperature)

TEST / CRITERIAS

100% of view control on damage and coating mistake.

Check of the adhesive strenght as follows:

Test	Type of measurement	Test equipment	Test equipment manufacturer
Adhesive strenght acc. DIN EN ISO 2409	Tape Test	GT2	Byk Gardner, USA

FIXED COSTS

Accordinging quotation.

FORM OF DELIVERY

Same as standard (in PE-bags, in layers in the cartons). Special agreements possible.
Quantity differencies + 10 % possible.

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