

Standard coating axial piston units

General

In the Bursa, Elchingen und Horb plants, axial piston units can be supplied with a two-component coating.

The following coating variants can be supplied:

- ▶ Primer coating
- ▶ Double coating

The currently used coating is an Epoxy resin metal coating. It contains solvents, is rich in solids, two-component, free of chromate and lead.

Coatings

The two coating variants are applied in one operation and differ as follows:

- ▶ Primer coating:
2-component Epoxy high-solid primer coating with a minimum coating thickness of 40 µm
- ▶ Double coating:
2-component Epoxy high-solid double coating with an increased coating thickness and a minimum coating thickness of 70 µm

Coating inspection

After an aqueous spray cleaning with subsequent component drying, the parts are coated.

The coating quality is checked using the following test methods:

Test method	Standard	Test duration	Test interval
Cross-cutting test	DIN EN ISO 2409	–	1 × week
Coating thickness test	DIN EN ISO 2178	–	Test according to test plan
Salt spray test (valid for TSD ²⁾ ≥ 70 µm)	DIN EN ISO 9227	480 hours	1 × year
Test for distilled water, oil, diesel	DIN EN ISO 2812	240 hours	Test according to test plan
Fire protection test R7 / HL3	EN 45545-2	R7 / HL3	One time

1) Further colors on request

2) TSD = Dry film thickness

Notice

- ▶ All surfaces of the axial piston unit are coated with the exception of:
 - Drive shaft
 - Hydraulic ports
 - Hydraulic lines
 - Mounting flange
 - Through-drive flange
 - Cable/cable connections
 - Emergency actuation
 - Customer-specific requirements (e.g. support threads, tank ports)
- ▶ Covers are partially coated and may need to be removed by the customer.

Preferred colors for coating in the Bursa, Elchingen und Horb plants

Color system	Color ¹⁾	Color name
RAL	1013	Oyster white
RAL	1023	Traffic yellow
RAL	3020	Traffic red
RAL	5010	Gentian blue
RAL	7015	Slate grey
RAL	7037	Dusty grey
RAL	9005	Jet black

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