

Colour Coating

Coating variants for individual parts and components

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1 Scope

This factory standard applies to the coating of individual parts and components for REINTJES gearboxes with various coating systems. This part of the standard describes the requirements placed on different coating systems.

The described coating systems are designed as passive atmospheric corrosion protection in the specified corrosivity categories for a medium protection duration.

The order variants of the coating systems used at REINTJES and listed below are to be seen as supplementary to the systems specified in RN 79. The basic principles and general requirements for coating systems and the requirements for priming can be found in RN 79-a. The specifications from RN 79-a stated in the respective variants must be complied with; in addition, the regulations of this standard apply.

If there are any uncertainties regarding the intended variant and/or surface preparation, REINTJES should be contacted in advance for clarification and, if necessary, approval.

2 References

The following documents, cited in part or in whole, shall apply for the use of this standard. In the case of dated references, only the referenced edition applies; in the case of undated references, the latest edition of the referenced document (including all amendments) applies. The applicable version of the standards listed below shall apply to all contents not covered by this factory standard.

RN 71	Packaging and preservation; Initial preservation, transport and storage of REINTJES products
RN 72	Packaging and preservation; Supply parts for production
RN 79	Colour Coating; Coating variants for gearboxes
RN 79-a	Colour Coating; General requirements and pre-treatment

3 Coating systems

Table 1 Overview over the possible variants (extract from RN 79)

Variant	Primer	Top layer	Designation, examples
4	--	--	RN 79-4, Individual parts and components, uncoated
4.1	RAL 7032	--	RN 79-4.1, Individual parts and components, primed
4.2	RAL 9010	--	RN 79-4.2, Individual parts and components, REINTJES Yacht Premium primed
4.3	RAL 7032	order	RN 79-4.3, Individual parts and components, end coated
4.4	RAL 9010	order	RN 79-4.4, Individual parts and components, REINTJES Yacht Premium end coated
4.5	order	order	RN 79-4.5, Individual parts and components, powder coated
4.9	order	order	RN 79-4.9, Individual parts and components, customer specific

The design variants described in the following specify the type and scope of the colour coating of individual parts and components for REINTJES products for different areas of application in the standard case. Deviations from this required in individual cases are to be specified in detail in the order description and must be agreed in writing with REINTJES. The general requirements from RN 79-a and the applicable form of preparation and primer must be complied with.

Variant 4 Individual parts and components, uncoated

Designation, colour	RN 79-4, Individual parts and components, uncoated
Description, scope of application	Individual parts and components without any primer or coating. Painting and assembly are carried out externally.
Protection period	CAUTION! High risk of corrosion; the necessary preservation or packaging must be specified in the order in accordance with RN 71.
Surface preparation	in accordance with RN 79-a chapter 6.1 c)

Variant 4.1 Individual parts and components, primed

Designation, colour	RN 79-4.1, Individual parts and components primed
Description, scope of application	Individual parts and components with standard primer in RAL 7032. A different colour is to be specified in the order. Top Coating and assembly are carried out externally.
Protection period	CAUTION! High risk of corrosion; the necessary preservation or packaging must be specified in the order in accordance with RN 71.
Surface preparation	in accordance with RN 79-a chapter 6.1
Primer coating	Zinc-phosphate-containing 1K synthetic resin-based primer Colour: RAL 7032 Dry film thickness: 40 - 60 µm
Special features	Other forms of coating must be tested and approved in writing by REINTJES.

Variant 4.2 Individual parts and components, REINTJES Yacht Premium primed

Designation, colour	RN 79-4.2, Individual parts and components REINTJES Yacht Premium primed
Description, scope of application	Yacht Premium primer coating with 2K primer in RAL 9010. Top Coat and assembly are carried out at REINTJES.
Protection period	CAUTION! High risk of corrosion; the necessary preservation or packaging must be specified in the order in accordance with RN 71.
Material	steel / cast iron / cast steel / aluminium alloys
Surface preparation	in accordance with RN 79-a chapter 6.1 in combination with chapter 6.2 c)
Primer coating	2K EP Primer Colour: RAL 9010 Dry film thickness: 80 µm ± 20 µm
Special features	Other forms of coating must be tested and approved in writing by REINTJES.

Variant 4.3 Individual parts and components, end coated

Designation, colour	RN 79-4.3, Individual parts and components end coated
Description, scope of application	Individual parts and components with standard primer and top coating acc. to order. The colour of the top coating must be defined separately in the order.
Protection period	in category C2: high in category C3: medium
Surface preparation	in accordance with RN 79-a chapter 6.1
Primer coating	Zinc-phosphate-containing 1K synthetic resin-based primer Colour: RAL 7032 Dry film thickness: 40 - 60 µm
Top Coat, standard	Synthetic resin top coat on alkyd resin basis (AK) Colour: customer specific Dry film thickness: 40 - 60 µm
Top Coat, optional	2K PUR Direct Topcoat Colour: customer specific Dry film thickness: 40 - 60 µm Use case: see RN 79-a chapter 5 d)

Variant 4.4 Individual parts and components, REINTJES Yacht Premium end coated

Designation, colour	RN 79-4.4, Individual parts and components REINTJES Yacht Premium end coated	
Description, scope of application	Yacht Premium coating by manufacturer with 2K primer and 2K top coat.	
Protection period	in category C2:	high
	in category C3:	medium
Material	steel / cast iron / cast steel / aluminium alloys	
Surface preparation	in accordance with RN 79-a chapter 6.1 in combination with chapter 6.2 c)	
Primer coating	2K EP Primer	
	Colour:	customer specific (Standard RAL 9010)
	Dry film thickness:	100 - 120 µm
Top Coat	2K topcoat on polyurethane basis (PUR)	
	Colour:	customer specific (Standard RAL 9010)
	Gloss grade:	≥ 80 GU (medium gloss, semi-gloss)
	Dry film thickness:	100 - 120 µm
	Total dry film thickness:	200 - 240 µm

Variant 4.5 Individual parts and components, powder coated

Designation, colour	RN 79-4.5, Individual parts and components powder coated	
Description, scope of application	Individual parts and components with standard primer and top coat acc. to manufacturer's standard. The primer and top coat can be detailed in the order in a way that differs from the specifications below. The colour of the top coating must be defined separately in the order. Powder coating is only permitted for external individual parts and components.	
Protection period	in category C2:	high
	in category C3:	medium
Surface preparation	in accordance with RN 79-a chapter 6.1	
Primer coating	Immersion primer with water-based paint	
	Colour:	manufacturer's standard
	Film thickness:	approx. 10 - 20 µm
Top Coat, standard	Powder coating based on polyester resin, free of heavy metals, chromate and silicone	
	Colour:	manufacturer's standard
	Film thickness:	approx. 50 - 100 µm
Top Coat, optional	Powder coating based on polyester resin, free of heavy metals, chromate and silicone	
	Colour:	manufacturer's standard
	Film thickness:	approx. 50 - 100 µm
	Use case:	see RN 79-a chapter 5 d)

Variant 4.9 Individual parts and components, customised coating

Designation, colour	RN 79-4.9, Individual parts and components - customised
Description, scope of application	Individual parts and components with primer and top coat according to customer specification, in-house design
Protection period	depending on the desired coating
Surface preparation	in accordance with RN 79-a chapter 6.1
Special features	<p>For all special finishes, additional work and time, in some cases considerable, must be expected.</p> <p>All requirements deviating from the specifications of this standard, e.g. other coating agents (2K lacquer, etc.), a special layer structure, colouring or coating of components, etc. must be noted in detail in the order description. The specifications of RN 79-a Chapters 4 and 5 must be observed.</p> <p>To be indicated in particular:</p> <ul style="list-style-type: none"> • number and sequence of layers • type of coating, product description, e. g. synthetic resin varnish, possibly manufacturer's name, manufacturer's no. • colour shade and/or number (RAL, Munsell, ...) and gloss grade layer thicknesses
