



Colouring of purchase parts and especially designed parts

WN
9 66 65-03

Replacement for
edition 2010-07

1 Range of application and purpose:

This standard applies for painting / powder coating of purchase parts and especially designed parts.

The purpose of this standard is to ensure a uniform appearance and a constant quality of surface coating of purchase parts and especially designed parts.

2 Provisions for colouring and surface quality:

- Colour shade according to order
- Structure: fine structure ¹⁾
- Gloss level: silk-mat ²⁾
- Special colouring according to drawing specifications are to be observed
- Faces machined via metal-cutting procedure shall not be primed, painted or coated.
Examples: milled or ground faces, fits, threads

3 Per-treatment and coating provisions:

3.1. Raw metal sheet and welded assemblies

- Powder coated and burnt in
- For pre-treatment adequate procedures, such as phosphating are being used

Drawing note: „Powder-coated according to works standard 9 66 65-03 “

3.2. Casting and welded assemblies machined in metal-cutting procedure

- Unmachined surfaces sandblasted, primed and painted
- Primers as well as top coats on 2-component epoxy basis are allowed
(see point 4.1 reference products for priming)

Drawing note: „Painted according to works standard 9 66 65-03 “

- 1) The SW designation ‚Fine structure‘ corresponds to the structure of Freiotherm – powder lacquer PL1033A (see Item 4.2.1 reference product top coat)
- 2) The SW designation ‚Silk-mat‘ corresponds to silk gloss according to DIN EN ISO 2813

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4 Reference products:

4.1 Primer:

- Frepox primer + hardener
Primer ER1925 (reseda green)
Hardener HE0087
Mixing ratio: 10 portions primer, 1 portion hardener

4.2 Top coat:

4.2.1 Powder lacquer

- Freiotherm – powder lacquer PL1033A
Silk gloss, coarse structure

4.2.2 System lacquer (liquide lacquer)

- System structure lacquer GS9141

5 Manufacturer of the reference products:

Frei Lacke

Emil Frei GmbH & Co.

Döggingen

Am Bahnhof 6

DE-78199 Bräunlingen

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6 Normative references:

Paints and varnishes - Determination of specular gloss of non-metallic paint films at 20°, 60° and 85° (ISO 2813:1994, including Technical Corrigendum 1:1997);
German version EN ISO 2813:1999

Modifications

In comparison with works standard 9 66 65-03:2008-10 the following has been modified:

- The drawing notes „Powder-coated according to works standard 9 66 65-03 “ and „Painted according to works standard 9 66 65-03“ have been fixed.

Former editions:

Works standard 9 66 65-03: 2008-04, 2008-10