

## Paint Specification for Rotork Actuators

### AWT range paint finish

#### Sizes 1-3

After machining, all castings are cleaned by dipping into an acid etch solution and then subsequently rinsed in a cold water rinse. Aluminium castings are then dipped into a zinc chromate solution (Walterchrom 7400) 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 (Walterphos 3225) 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 75 microns. All castings are then cured at 200°C (Core temperature) for approximately 20 minutes.

#### Sizes 4 and 5

##### 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 Walterchrom 7400 (Walterisation process). 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 degreasing plant operating at 70°C to the spraying stage.

##### The spraying stage

Preheated paint is applied as follows:

##### Undercoat

**Make:** Ameron

**Type:** Anti-corrosion primer

**Ref no.** Tractol 838

**Min Film Thickness:** 2.00 mils (50.8 microns)

**Application:** Air assisted airless electrostatic system

##### Topcoat

**Make:** Ameron

**Type:** Air-dried urethane reinforced machine finish

**Ref no.** T565

**Colour:** Castings - Dark Grey RAL7011

Handwheel and Hand/auto lever – Black RAL9005

**Min Film Thickness:** 1.00 mils (25.4 microns)

**Application:** Air assisted airless electrostatic system

**Topcoat Drying time:** 12 hours to hard dry

**Film Thickness:** 3 mils (76.2 microns).



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