

Standard Paint Specifications – See Page 3 for Premium Epoxy Paint

Primer — Lead & Chrome Free, Medium Dark Gray, Universal High-Solids, Phenolic Alkyd Primer

For use on such products as drive housings, accessories, bedplates and other steel and gray iron parts.

WEIGHT: 11.5 lb/gal minimum (1.4 kg/L)

TOTAL SOLIDS: 70% minimum by weight

COMPOSITION OF SOLIDS BY WEIGHT:

Pigment — 70–74%

Non-Volatile Vehicle — 26–30%

COMPOSITION OF PIGMENTS BY WEIGHT:

Rust Inhibitive Pigments — 15% min

TiO₂ — 9% min

Others — approximately 76%

APPLICATION: One spray coat of primer shall be applied on thoroughly cleaned surfaces to produce a minimum dry film thickness of 1.0 mil (0.001") (25 microns).

AIR DRYING TIME: Primer shall be "set-to-touch" in 20 to 30 minutes and "dry hard" in one hour for handling. It shall be ready to accept the standard finish coat after one hour.

VOC CONTENT: Meets 3.5 lb/gal Maximum (393 g/L)

Finish Coat — Lead & Chrome Free, Medium Dark Gray, High-Solids Alkyd Enamel

For use on such products as Gear Drives (*except 4000J[Quadrive®], Drive One®, 1020/1030F & 2000F[UltraMax®], Type MD Mixer Drives, see below*), Backstops and Motorbeds.

WEIGHT: 10.9 lb/gal minimum (1.3 kg/L)

TOTAL SOLIDS: 68.5% minimum by weight.

APPLICATION: One spray coat shall be applied on thoroughly cleaned surfaces to produce a minimum dry film thickness of 1.0 mil (0.001") (25 microns).

AIR DRYING TIME: Finish shall be "set-to-touch" in 15 to 20 minutes and "dry hard" overnight. (4000J[Quadrive], Drive One, 1020/1030F & 2000F[UltraMax] and Type MD Mixer Drive — Force dry hard: 30 minutes, at 180°F [82°C] in catalytic oven to handle.)

COLOR: Medium Dark Gray (RAL 7015) as per ANSI Standard Z55.1-1967

Munsell Color Notation — 7.8B 3.3/0.94

VOC CONTENT: Meets 3.5 lb/gal maximum (393 g/L)

4000J(Quadrive), 1020/1030F & 2000F(UltraMax), Drive One, and Type MD Mixer Drive Paint Specifications

Finish Coat — Medium Dark Gray, Semi-Gloss, Two-Component, Topcoat Urethane Coating

WEIGHT: Mixed: 12.4 lb/gal minimum (1.5 kg/L).

TOTAL SOLIDS: Mixed: 73.5% 1% by weight.

AIR DRYING TIME: Force dry hard: 30 minutes, at 180°F (82°C) in catalytic oven to handle.

Falk Paint Specifications

The above specifications apply to Falk® products manufactured and painted by Rexnord. Motors and other non-Falk equipment received at Rexnord (to be fitted by Rexnord) will not be repainted unless special arrangements are agreed upon in advance. Without these arrangements, non-Falk components will be fitted and shipped as painted by the original supplier.

Customer Paint Specifications

Consult Rexnord for a quotation for preparation and painting of Falk products with paints that are not to the above specifications.

Paint Over Prime Coat

After the Falk prime coat has cured a minimum of 30 days, most finish coat paints (including most epoxy-based paints) will bond satisfactorily with the Falk primer, if applied within 30 days of primer application. See CAUTION notes below.

Paint Over Finish Coat

After the Falk finish coat has cured a minimum of 7 days, most air-dried enamels will bond satisfactorily with the Falk finish coat. Epoxy and urethane paints require sand blasting to clean "white metal" before painting. *4000J[Quadrive], 1020/1030F & 2000F[UltraMax], Drive One, and Type MD Mixer Drive — Most epoxy, urethane, or alkyd enamel-based paints will bond satisfactorily with the Falk finished coat if re-coated within 30 days of the original paint application. Paint compatibility may vary according to solvent and resin make-up. See CAUTION notes below.*

CAUTION — TEST PAINT ADHESION BEFORE

RE-COATING: Test paint adhesion before 100% re-coat application. If previous history is not available, check compatibility by applying coating to a small area and allow to cure for at least 72 hours at normal room temperature. Make crosshatch cuts according to ASTM D3359. If coating remains intact (at least 85% adhesion) and overall appearance is satisfactory, the coatings can be assumed compatible. Refer any questions or unusual circumstances to the paint manufacturer.



CAUTION — SAND BLASTING: Mask all shafts, shaft seals, air vents, surfaces and accessories subject to damage before sand blasting.

Step-by-Step Falk Paint Procedures

1. **SURFACE PREPARATION** — Structural members are first flame cut from stock steel plate, spot ground and shot blasted. Next, structural members are deep-flux welded, chipped and again spot ground. After a final hand cleaning, to ensure a good bonding surface, the unitized structure is now ready for the universal primer.
2. **PRIMER APPLICATION** — In the machine shop, another series of planned procedures occur. As excess metal (and the prime coat) is removed in the various machining operations, the raw metal surfaces are simultaneously coated with a rust preventive. The final operation is a cleaning/coating procedure which protects the machined surfaces until ready for assembly.
3. **FINAL ASSEMBLY** — According to a planned building schedule, stock components are thoroughly cleaned in an automatic washer and kitted with bearings, seals and other hardware. After final assembly, drives are tested with a rust preventive run-in oil.
4. **FINISH COAT APPLICATION** — After hand cleaning a spraying method produces a paint coat of desired thickness. Shaft extensions and other machined surfaces (which receive mating parts) are not painted but are coated with an easily removed rust preventive.
5. **SHIPMENT PREPARATION** — During shipment, and until filled to the proper level with specified oil, all internal parts and surfaces are protected by the residual coating of rust preventive oil applied during the shop run-in test.
6. **STORAGE** — Drives which are to be stored for periods exceeding four months outdoors or twelve months indoors (in a dry building) from date of shipment, or drives to be exported, should be specified to be protected for long term storage. Such drives are protected for twelve months storage outdoors or twenty-four months indoors.

Premium Epoxy Paint Specifications – See Page 1 for Standard Paint

General Description of Premium Epoxy Paint System

A high performance, multipurpose, two-component chemically-cured epoxy semi-gloss coating. Epoxy paint prices include surface preparation in accordance with SSPC-SP10 (abrasive blasted to a near white finish), two coats of Devran® 224HS or Macropoxy 646 High Build Epoxy (8-16 mils [200-400 microns] DFT). Complete paint specifications, available colors, and paint procedures can be found below.

Features

Excellent corrosion protection from salt water, resists spillage of solvents and chemicals.

Surface Preparation

Abrasive cleaning to a near white finish in accordance with SSPC-SP10.

Primer — Devran 224HS or Macropoxy 646 High Build Epoxy

APPLICATION: One spray coat shall be applied on abrasive cleaned surface to produce a minimum dry film thickness of 4.0–8.0 mils (100–200 microns) d.f.t.

AIR DRYING TIME: At 6.0 mils (150 microns), 70°F (21°C), Dry Hard 9 Hours.

Finish Coat — Devran 224HS or Macropoxy 646 High Build Epoxy

APPLICATION: One spray coat shall be applied to produce a minimum dry film thickness of 4.0–8.0 mils (100–200 microns) d.f.t.

AIR DRYING TIME: At 6.0 mils, 70°F (21°C), Dry Hard, 9 Hours

COLOR: Medium Dark Gray

Color Notation — RAL 7015 Gray. Other colors available. Contact Rexnord for a complete color chart or provide a color chip for matching.

Special Paint System/Color — Consult Rexnord.

WEIGHT: (Mixed) 12.5 lb/gal (1.5 kg/L)

VOC (EPA 24): (Mixed) 1.8 lb/gal (212 g/L) Varies with color.

SOLIDS BY VOLUME: (Mixed) 75%. Varies with color.

HARDNESS: (ASTM D 3363) — 7 day Cure @ 77°F (25°C) -3H

SERVICE TEMPERATURE LIMITS: 250°F (121° C) dry

Falk Paint Specifications

These specifications apply to Falk products manufactured and painted by Rexnord. Motors and other non-Falk equipment received at Rexnord (to be fitted by Rexnord) will not be repainted unless special arrangements are agreed upon in advance. Without these arrangements, non-Falk components will be fitted and shipped as painted by original supplier.

Customer Paint Specifications

Consult Rexnord for a quotation for preparation and painting of Falk products with paints that are not to the above specifications or listed on Rexnord Standard Paint Specifications on page 1.

Step-by-Step Paint Procedures

1. **SURFACE PREPARATION** — Structural members are first flame cut from steel plate, spot ground and shot blasted. Next, structural members are deep-flux welded, chipped and again spot ground. After gear drive assembly, but before mounting accessories; e.g., fans, bedplates, motor brackets etc., all shafts, seal areas, and air vents are masked. Gear drives and accessory surfaces are then abrasive-cleaned to a near white finish in accordance with SSPC-SP10.
2. **PRIME & FINISH COAT** — A spraying method produces a paint coat of desired thickness. Shaft extensions and other machined surfaces (which receive mating parts) are not painted but are coated with an easily removed rust preventive.
3. **SHIPMENT PREPARATION** — During shipment and until filled to the proper level with specified oil, all internal parts and surfaces are protected by a residual coating of rust preventive oil applied during the shop run-in test.
4. **STORAGE** — Drives which are to be stored for periods exceeding four months outdoors or twelve months indoors (in a dry building) from date of shipment, or drives to be exported, should be specified to be protected for long term storage. Such drives are protected for twelve months storage outdoors or twenty-four months indoors.