



Guidelines for the construction of components to be provided with a plastic coating.

In order to provide components with a high-quality, uniform and pore-free plastic coating, they must satisfy certain requirements with regard to construction, design and size.

These requirements have been taken from the German V.D.I. guideline no. 2532.

All components must be constructed so as to enable visual inspection of the surfaces to be coated. Visual inspection is necessary to evaluate the condition of the surface of the components to be coated with regard to steel purity, weld quality, and, later on, coating porosity.

All seams must be welded so that pores do not form. During construction, they must be positioned so as to allow them to be ground smooth later, and any welding spatters should be removed.

All sharp edges must be rounded off (minimum radius of 3 mm). Special care must be taken with regard to the sharp edges of flanges, welded tubes and pipe ends without flanges.

The surfaces of components to be coated must be uniform and free of pores and cavities. This is especially important with regard to cast-iron components.

Unless it is possible to grind all the welded seams smooth, curved components, etc., may not be welded to straight ones. In such cases, separate components with flanged connections are recommended.

In order to ensure adequate coating of the edges, it is particularly important that the internal edges of flanges be rounded off to the previously mentioned minimum radius of 3 mm.

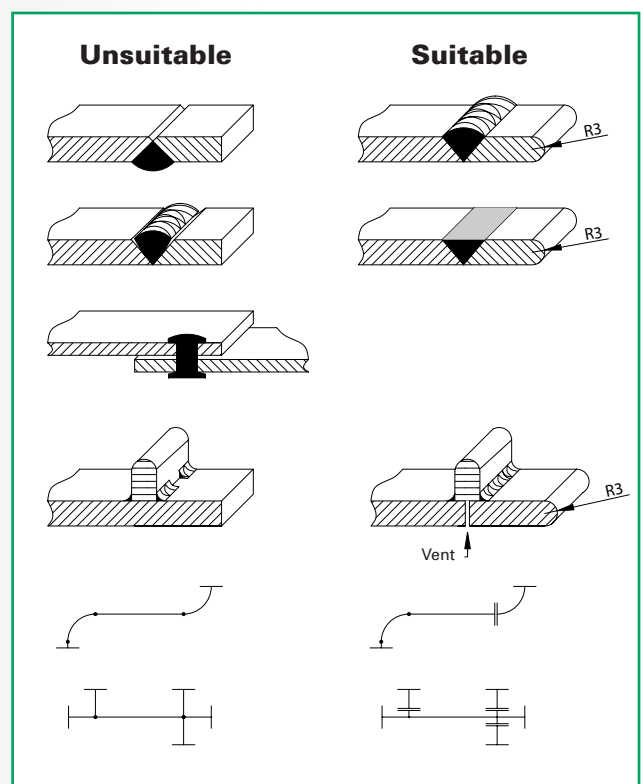
The sharp outer edges of a flange, as well as the bolt-holes must also be rounded off somewhat.

The coating reduces the diameter of the boltholes by approximately 1.5 to 2 mm. This must be taken into account when installing components in order to prevent damage.

Flanged connections are recommended for manometers, thermometers, etc. If this is not possible, externally threaded stainless steel nipples must be used. These must be placed as near to the end of the pipes as possible so that the weld can be ground smooth.

After installation, any resulting damage to the coating must be touched up. In order to prevent damage, washers must be used under both the bolt head and the nut.

Welding details and edges





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Effective anticorrosive measures originate at the design stage.

Close collaboration between all the parties concerned is very important and will, from the design phase on, keep costs down.

Guideline for pipe spools to be provided with Rilsan in a fluidised bed

Type	Straight spool	Spool with elbow	Spool with T-piece
DN	Max. length L1	Max. length L2 L3 ▲	Max. length L4 L5 ■
25	2000	2000 100	2000 100
32	3000	3000 110	3000 100
40	3500	3500 120	3500 150
50	4000	4000 140	4000 150
65	4500	4500 170	4500 150
80	5000	5000 200	5000 150
100	6000	6000 250	6000 200
125	6000	6000 300	6000 200
150	6000	6000 350	6000 200
200	6000	6000 450	6000 250
250	6000	6000 550	6000 300
300	6000	6000 650	6000 400
400	6000	6000 750	6000 400
500	6000	6000 900	6000 500
600	6000	6000 1100	6000 600
700	6000	6000 1200	6000 700
800	6000	6000 1350	6000 800
900	6000	6000 1500	6000 900
1000	6000	6000 1650	6000 1000
1200	6000	6000 1650	6000 1000

Maximum diameter of flanges: 1.500 mm.

▲ Welded components are allowed when the weldings internally are ground smooth.

■ The position of the sidetube should be placed in a position where a grinder can reach the internal welding.



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Guideline for pipe spools to be provided with Halar and other fluoropolymers

Type	Straight spool	Spool with elbow	Spool with T-piece
DN	Max. length L1	Max. length L2 L3 ▲	Max. length L4 L5 ■
32	500	500 150	500 100
40	1000	750 150	1000 150
50	1000	750 200	1000 150
65	1500	1000 200	1500 150
80	2000	1000 250	2000 150
100	3000	1500 250	3000 200
125	3000	1500 300	3000 200
150	3400	1500 350	3400 200
200	3400	1700 450	3400 250
250	3400	2000 600	3400 300
300	3400	2000 650	3400 400
400	4000	2000 750	4000 400
500	4000	2000 900	4000 500
600	4000	2000 1000	4000 600
700	4000	2000 1200	4000 700
800	4000	2000 1400	4000 800
900	4000	2000 1600	4000 900
1000	4000	2000 1600	4000 1000
1200	4000	2000 1600	4000 1000

The length of the spools are an indication and also depending on the selected coating.

▲ Welded components are allowed when the weldings internally are ground smooth.

■ The position of the sidetube should be placed in a position where a grinder can reach the internal welding.

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