

TITLE: MULTI-TURN ACTUATORS. PAINTING AND CORROSION PROTECTION.
MODELS: CK, CKR, CKC, CKRC

Rotork actuators are designed for use worldwide in nonhazardous water, power and industrial applications. Corrosion protection is a vital part of a reliable actuation solution to ensure a long service life is achieved for the product.

All CK range actuator finishes are tested in accordance with a 1.000 hour cyclic salt spray test procedure which is the most realistic and arduous test cycle applicable. The test combines cyclic salt spray, drying and humidity at elevated temperatures on complete factory built actuators. This procedure is designed to test the finish coatings and the various substrate materials, fixings and interfaces on an actuator. Substrate materials and finishes are selected to provide maximum corrosion resistance combined with good adhesion achieved by following process and technical solutions:

- After machining, all castings are cleaned by dipping into an acid etch solution and then subsequently rinsed in a cold water rinse. Aluminum castings are then dipped in Gardobond® X4707 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 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.

Standard corrosion protection degree

- Spray castings, using electrostatic spray, INTERPON D1036 DFT 100 micrometers.
- Final Colour – Actuator to be **RAL5024 blue**, handwheel & lever to be RAL9005 black and cover tube (if required) to be RAL9005 black. (Other colors under request)
- Total DFT 100 micrometers
- Heat castings to 200degC (skin temperature) and maintain for a minimum of 10 minutes.

High corrosion and protection degree: Coastal and off-shore areas

- Spray castings using epoxy based powder coating Interpon APP120 - DFT 100 micrometers.
- Heat castings to 200degC (skin temperature) and maintain for a minimum of 10 minutes
- Spray castings, using electrostatic spray, INTERPON D1036 - DFT 100 micrometers.
- Final Colour – Actuator to be **RAL5024 blue**, handwheel & lever to be RAL9005 black and cover tube (if required) to be RAL9005 black. Other colors under request)
- Total DFT 200 micrometers
- Heat castings to 200degC (skin temperature) and maintain for a minimum of 10 minutes.

NOTE:

Other Treatments, materials or processes under request.
 Other colors are available, under request.

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