Handling instructions
Coating of composite metal/plastic profiles
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Composite metal/plastic profiles are generally coated as follows:

1. **Conventional cleaning and/or pre-treatment baths**

2. **Drying of profiles**
   (e.g. blowing-out or drainage using compressed air)
   It must be ensured that no residues from the bath are present on the profiles, in the cavities or gaps. Such moisture can lead to the following problems: Formation of blisters or even rupture of insulating strips as a result of oven temperature.

3. **Suspending profiles for coating**
   In order to avoid excessive bending in the horizontal coating process the profile might have to be supported if either the weight of the assembled profile ist too high or if the geometry-dependend expansions are too different. In order to eliminate lob-sideness in the vertical coating process it is important to hang the assembled profile from the aluminium part/parts (heavier part) so that it will hang as vertically as possible.

4. **Coating the profiles in the oven**
   The object temperature of 180°C – 200°C and the dwell time of approx. 20 min. must not be exceeded. If this temperature or time is exceeded, the stability of the insulating strips may suffer. There is the risk of the profiles dis-aligning and moving out of parallel as well as a considerable loss of strength in the connection between the two aluminium sections.

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Insulating profiles for windows, doors and facades

Dis-aligning of the composite profiles