

VFB CYCLE PROCESS - 2015

PRE ALKALINE DEGREASING					
1	MINIMUM FASE DURATION	60"	TOOL	METHOD	FREQUENCY
	PRESSURE	0,7–1,2 bar	PRESSURE GAUGE	AUTOMATIC	DAILY
	TEMPERATURE	40° – 50°	THERMOMETER	AUTOMATIC–MANUAL	DAILY–3MONTHS
	CONDUCTIVITY	10–20 ms	PROBE	AUTOMATIC–MANUAL	DAILY–3MONTHS
	CONCENTRATION (free alkalinity)	6,0–8,0		MANUAL	DAILY
ALKALINE DEGREASING					
2	MINIMUM FASE DURATION	120"	TOOL	METHOD	FREQUENCY
	PRESSURE	0,7–1,2 bar	PRESSURE GAUGE	AUTOMATIC	DAILY
	TEMPERATURE	40° – 50°	THERMOMETER	AUTOMATIC–MANUAL	DAILY–3MONTHS
	CONDUCTIVITY	10–20 ms	PROBE	AUTOMATIC–MANUAL	DAILY–3MONTHS
	CONCENTRATION (free alkalinity)	6,0–8,0		MANUAL	DAILY
WATER RINSE					
3	MINIMUM FASE DURATION	30"	TOOL	METHOD	FREQUENCY
	PRESSURE	0,7–1,2 bar	PRESSURE GAUGE	AUTOMATIC	DAILY
	TEMPERATURE	LOCAL			
WATER RINSE					
4	MINIMUM FASE DURATION	30"	TOOL	METHOD	FREQUENCY
	PRESSURE	0,7–1,2 bar	PRESSURE GAUGE	AUTOMATIC	DAILY
	TEMPERATURE	LOCAL			
DEMINERALIZED WATER RINSE					
5	MINIMUM FASE DURATION	30"	TOOL	METHOD	FREQUENCY
	PRESSURE	0,7–1,2 bar	PRESSURE GAUGE	AUTOMATIC	DAILY
	TEMPERATURE	LOCAL			
	CONDUCTIVITY	0–50 us	PROBE	AUTOMATIC–MANUAL	DAILY–1 MONTHS
NANOCERAMIC					
6	MINIMUM FASE DURATION	30"	TOOL	METHOD	FREQUENCY
	PRESSURE	0,7–1,2 bar	PRESSURE GAUGE	AUTOMATIC	DAILY
	TEMPERATURE	LOCAL			
	CONDUCTIVITY	0–50 us	PROBE	AUTOMATIC–MANUAL	DAILY–1 MONTHS
	CONCENTRATION (oxsilan points)	2,5–4,0		MANUAL	1 WEEK
DEMINERALIZED WATER RINSE					
7	MINIMUM FASE DURATION	30"	TOOL	METHOD	FREQUENCY
	PRESSURE	0,7–1,2 bar	PRESSURE GAUGE	AUTOMATIC	DAILY
	TEMPERATURE	LOCAL			
	CONDUCTIVITY	0–50 us	PROBE	AUTOMATIC–MANUAL	DAILY–1 MONTHS
FOSFOCROMATATION – only for AL					
8	MINIMUM FASE DURATION	45"	TOOL	METHOD	FREQUENCY
	PRESSURE	0,7–1,2 bar	PRESSURE GAUGE	AUTOMATIC	DAILY
	TEMPERATURE	40° – 50°	THERMOMETER	AUTOMATIC–MANUAL	DAILY 3 MONTHS
	CONCENTRATION (chrome points)	5,5–7,0		MANUAL	1 WEEK
	FLOURIDE PPM	400–1000		MANUAL	2 WEEK
WATER RINSE					
9	MINIMUM FASE DURATION	30"	TOOL	METHOD	FREQUENCY
	PRESSURE	0,7–1,2 bar	PRESSURE GAUGE	AUTOMATIC	DAILY
	TEMPERATURE	LOCAL			
DEMINERALIZED WATER RINSE					
10	MINIMUM FASE DURATION	30"	TOOL	METHOD	FREQUENCY
	PRESSURE	0,7–1,2 bar	PRESSURE GAUGE	AUTOMATIC	DAILY
	TEMPERATURE	LOCAL			
	CONDUCTIVITY	0–50 us	PROBE	AUTOMATIC–MANUAL	DAILY–1 MONTH
DRYING					
11	MINIMUM FASE DURATION	10'	TOOL	METHOD	FREQUENCY
	TEMPERATURE	80° – 160°	OVEN TRACKER	MANUAL	3 MONTHS
COATING					
12	MINIMUM FASE DURATION		depending on parts morphology		
	AIR FLOW		setups depends from functional and aesthetic measurements		
	AMPERE		setups depends from functional and aesthetic measurements		
CURING					
13	MINIMUM FASE DURATION	20 min	TOOL	METHOD	FREQUENCY
	TEMPERATURE	180° – 220°	depending on powder tecnical sheets and parts thickness		
			OVEN TRACKER	MANUAL	3 MONTHS