












**TECHNICAL INFO**

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**SELECTION TABLE : Type of Surface Treatments related to the Corrosion Class and Risks per type of Environment (EN ISO 14713)**

Corrosion Class - Risk + Average zinc loss per year	Surface treatments	Typical environment - Indoor	Typical environment - Outdoor
<b>C1 - Very low</b> < 0,1 µm	Electro-galvanisation EN ISO 2081	 Heated buildings with neutral atmospheres : offices, shops, schools, hotels.	 Rural areas. Atmosphere with low impurities.
<b>C2 - Low</b> 0, 1-0,7 µm	Pre-galvanisation (SZ) Sendzimir galvanisation EN 10327 - EN 10 346	 Unheated buildings where condensation may occur: warehouses, shops, sports halls.	 City and industrial atmosphere, some impurities from sulphur dioxide, coastal areas with low salt loads.
<b>C3 - Medium</b> 0,7 – 2,0 µm	Hot-dip galvanisation (HD) EN ISO 1461	 Production facilities with high moisture levels and some air impurities : plants for food production, laundries, breweries, dairies.	 Industrial areas and coastal areas with low salt load.
<b>C4 - High</b> 2,0 – 4,0 µm	Hot-dip galvanisation (HD) EN ISO 1461	 Chemical plants, swimming pools, bathouses above sea water.	 Industrial areas with high moisture levels and aggressive atmosphere.
<b>C5-I - Very high (industry)</b> 4,2 – 8,4 µm	Duplex (HD + Powder Coating) Stainless steel AISI 316L	 Buildings or areas with almost constant condensation and with heavy impurities.	 Coastal or offshore areas with salt load.
<b>C5-M - Very high (sea)</b> >4,2 – 8,4 µm	Duplex (HD + Powder Coating) Stainless steel AISI 316L	 Buildings or areas with almost constant condensation and with heavy impurities.	

**SURFACE TREATMENTS****Sendzimir galvanised EN 10..346**

Ref. : SZ

Most of the cable trunkings, accessories and threaded rod fixings are made of Sendzimir galvanised steel, also called continuous galvanised steel.

The hot-rolled steel belt goes, after preparation, through a continuous bath with liquid zinc. Through this, a layer of zinc is formed which guarantees the increased corrosion protection. Depending on the product type the thickness of the zinc layer varies from 140 to 275 gr/m<sup>2</sup>, bilaterally calculated. This corresponds to 10 to 20µm with a tolerance of +/- 4µm.

Through the special Sendzimir zinc process, the steel-engraving can still be very easily carried out even after galvanisation. During the fabrication of the cable trunkings, the steel-engraving and the belt are punched, cut and bent. The exposed steel-edges are cathodically protected till a material thickness of 1.5mm is reached, as far as the zinc-layer had not already been bent over it during manufacturing. Substrate rust does not occur.

For normal interior construction purposes the Sendzimir galvanised materials offer more than adequate protection against corrosion (covered parking areas, various uses indoors etc.).

**Hot-dip galvanised EN ISO 1461**

Ref. : HD

Many cable ladders, ceiling profiles and brackets are hot-dip galvanised. For this surface treatment, other various terms are used such as fire galvanisation, thermal galvanization etc.

The finished pieces are plunged in a melt-bath with liquid zinc, after pre-treatment, at a temperature  $\geq$  +/- 450°C. A layer of zinc and iron is formed on the steel, which is covered with a pure zinc layer after removal from the zinc bath.

The thickness of the zinc layer depends on the thickness (gauge) of the steel. The guidelines in accordance with EN ISO 1461 are followed:

Material thickness	minimum localized layer thickness (µm)	minimum average layer thickness (µm)
$\geq$ 6 mm	70	85
$\geq$ 3 mm to < 6 mm	55	70
$\geq$ 1.5 mm to < 3 mm	45	55
< 1.5 mm	35	45

Small Items are galvanised and centrifuged. With regard to this the specific guidelines recorded in EN ISO 1461 are followed:

Material thickness	minimum localized layer thickness (µm)	minimum average layer thickness (µm)
$\geq$ 3 mm	45	55
< 3 mm	35	45

The increased thickness of the zinc layer ensures a better resistance against corrosion compared to continuous galvanised steel. Hot dip galvanised steel is also more suited to outdoor applications.

The requirements for hot dipped galvanised products refer to:

- the coating thickness of the galvanised layer or to its mass per unit area
- the outward appearance of the surface coating

The coating thickness is the deciding factor for the wear life in well-defined operating conditions. The thicker the coating, the longer the expected wear life. For most atmospheric exposures, a near-linear relationship exists between the two.

The second requirement concerns the outward appearance of the coating. On that score, the relevant standard (EN ISO 1461) stipulates the following:

- Products on which darker or lighter grey areas occur, whose surface exhibits some surface roughness or on which white storage stains can be found, will still meet the standard EN ISO 1461, providing the coating thickness remains above the specified minimum value.
- Lumps and zinc ash are permitted in places where they do not affect the intended use of the hot dipped galvanised object or its corrosion resistance requirements

**Electro zinc plated (EN ISO 2081)**

The wire cable trays and all sorts of fixation elements are electro zinc plated. During this procedure a thin zinc-layer is precipitated, varying in thickness between 6 and 8 microns, by means of an electrolytic process. After this the items are passivated and in this way protected against corrosion under normal indoor conditions.

**Coated finishes**

Our fully automated coating process applies a satin finish as standard. We can apply a high gloss, matt or textured coat on request.

**Polyester powder coating (standard)**

Ref : PE

The products we supply with a polyester powder coating finish easily meet the required standards. Polyester powder coating is suited to indoor and outdoor applications and offers a very high degree of resistance to all weather conditions.

**Epoxy powder coating**

Ref: EP

Epoxy coatings are characterised by their great resistance to both corrosion and chemicals. On the other hand epoxy powder coatings are not suitable for outside uses due to their poor resistance to UV light which results in degradation of the coating.

**Epoxy powder coating + Polyester powder coating**

Ref : EPPE

Epoxy is often used as a primer which will then have a polyester topcoat applied. This double layer coating results in a product that is both chemically and UV resistant.

**Duplex System**

Ref: DUPLEX

The combination of a hot-dip galvanizing and powder coating creates an extremely powerful protection against corrosion.

For technical advice and price inquiries, please consult our sales team. Delivery period of powder coated and duplex coated products is to be agreed upon in respect to volume and specifications.



## Alphabetical list of references

Reference	Page	Reference	Page	Reference	Page	Reference	Page
<b>A</b>		DAS	1-24	HDAB35.110	7-413	HDMP41.41DG	5-267
ADPU	6-365	DAVIDKV	4-141	HDAB35.110	7-387	HDNL	4-143
ADPUB	6-365	DB90	1-22	HDABIE	4-155	HDRU1	4-208
ADSU	6-366	DBTFCL	2-54	HDAHIE	4-156	HDRU2	4-209
AM	6-361	DCL	4-105	HDBKID25	4-158	HDSKIPE	5-260
AS	1-24	DCL	1-20	HDBKIE25	4-157	HDSKP	5-258
ASTFCL	2-55	DCL	8-443	HDBKIE40	4-157	HDSSU	4-145
AZH	1-31	DCLVF	3-67	HDBSKLEM	7-392	HDSU	7-415
<b>B</b>		DCLVF	8-445	HDBSKLEM	7-414	HDSU	5-255
B	5-274	DCLVF35	3-68	HDDI	4-151	HDVK2	4-144
B	7-428	DCO	1-20	HDDI	4-140	HDVS41	5-270
B90	1-21	DGBTFCFL	2-55	HDDIB	4-141	HDVS41	7-418
BDRITWD3	6-327	DGTFCL	2-53	HDDIB	4-152	HDVS41	5-271
BDRKK3	6-317	DKBS	7-416	HDDIB	4-106	HDVS41.05	7-413
BDVITWD2	6-326	DKI	4-152	HDDIB	4-122	HDVS41.45	7-395
BDVITWD3	6-326	DKR	1-25	HDDIG	4-196	HDVSIE	4-157
BDVIZ	6-362	DOP41.21	5-256	HDDIG	4-182	HDWK	5-242
BDVKK2	6-315	DOP41.41	5-257	HDDIG	4-166	HDWK	7-392
BDVKK3	6-316	DOP41.82	5-257	HDDIT	4-142	HDWK	7-413
BG	5-221	DOPHSMU	5-257	HDDIT	4-153	HDWKM	5-247
BGVF	3-72	DOPIPE80	5-259	HDDIT	4-123	HDWKM	7-414
BK	4-108	DOPKIE	4-158	HDDKIG	4-196	HDWKMD	5-247
BK	7-386	DOPKLL	8-461	HDDKIG	4-182	HDWVPIPE	5-261
BP	4-154	DOPKLL	4-130	HDDKIG	4-166	HSLE3	5-252
BP	4-203	DOPKLL60.M	4-131	HDDKIPE	5-261	HSMC	5-254
BP	4-189	DOPKLM	8-470	HDDSIH	4-156	HSMES	5-253
BP	4-173	DOPKLM	4-172	HDDSIH	4-156	HSMES	7-416
BTFCFL	2-54	DOPKLW	4-202	HDDSKSH	4-144	<b>I</b>	
BVSI	1-31	DOPKLZ	8-479	HDH1	4-208	I4COMEGA290	8-481
<b>C</b>		DOPKLZ	4-188	HDH1	7-389	I4D	8-439
CBCL60	5-238	DOPKS	4-145	HDH2	4-209	I4D	8-453
CCLI	5-233	DOVG	6-336	HDHKI	5-248	I4KBSI60	8-437
CL	1-35	DOVGR.3	6-338	HDHKIZ	5-249	I4KG60	8-438
CLHS	5-251	DOVGV.2	6-337	HDHSIZ	5-256	I4KLL110	8-451
CLHS	7-418	DOVGV.3	6-337	HDHSLDCL	5-252	I4KLLDK	8-454
CLHS	7-394	DR15.30	5-222	HDHSLDCL	5-251	I4KLLI60	8-449
COMEGA290	7-390	DR15.30	5-222	HDHSLDCL	7-417	I4LOMEGA150	8-482
COMEGACLU170	3-74	DR15.30	7-388	HDHSLDCL	7-394	I4MP41.21.250.6S	8-485
COMEGACLU170	5-232	DRTWD3	6-330	HDHSLDCL	5-254	I4MP41.41.250.6S	8-486
COMEGACLU290	5-233	DS	1-30	HDHSMU50	7-415	I4VOMEGA	8-480
CRO	5-276	DS	4-109	HDHSMU50	5-255	I4WK	8-483
CRO	7-430	DSB90	1-27	HDHSMU50	5-258	I6AS	8-441
CS45LP	5-224	DT	1-23	HDHSMU50	5-259	I6B	8-489
CS45M6	5-226	DTFCL	2-53	HDHSMU50	5-259	I6B90	8-440
CS45SH	5-225	DVB90	1-29	HDKIPE	5-261	I6COMEGA290	8-481
CS45SHY	5-229	DVITWD3	6-329	HDKK	4-144	I6CRO	8-489
CS45SHYA	5-228	DZ	1-20	HDKLIB	4-152	I6D	8-453
CS45TG	5-227	DZK	1-21	HDKLIE	4-151	I6D	8-444
CS90EY	5-226	<b>E</b>		HDKLIT	4-153	I6D	8-439
CS90LP	5-224	E	1-32	HDKLIVSB	4-154	I6DAS	8-441
CS90M8	5-226	<b>F</b>		HDKLIX	4-154	I6DB90	8-440
CS90SH	5-225	FL	5-219	HDKPIPE	5-260	I6DIG	8-472
CS90SHY	5-229	<b>G</b>		HDKS60	4-139	I6DIG	8-463
CS90SHYA	5-228	GBP	6-368	HDKS90	4-141	I6DKIG	8-472
CS90TG	5-227	GM	5-273	HDKSR60	4-140	I6DKIG	8-463
CSL	5-223	GM41	5-273	HDKST	4-142	I6DS60	8-442
<b>D</b>		GM41	7-429	HDKSVSB	4-143	I6GM	8-487
D	4-104	GMV41	5-273	HDKSX	4-143	I6GM41	8-487
D	3-67	GVFUL	3-66	HDLVIE	4-159	I6HSL	8-484
D	1-19	<b>H</b>		HDLVIRL	4-155	I6KBSI60	8-437
D	4-120	HDAB35.110	4-108	HDLVIRR	4-155	I6KG60	8-438
		HDAB35.110	4-130	HDMBZ	5-235	I6KLL110	8-452
				HDMP41.21	5-265	I6KLLABD	8-454
				HDMP41.41	5-266		

Reference	Page	Reference	Page	Reference	Page	Reference	Page
I6KLLAH	8-458	I6TIM	8-486	KLLBK	4-127	KLZSB	4-185
I6KLLAHV	8-458	I6V60.200	8-443	KLLCBCL	5-239	KLZT	4-183
I6KLLB	8-455	I6VF60	8-444	KLLCBCL	5-239	KLZVB	4-184
I6KLLBK	8-460	I6VFCB	8-447	KLLDK	4-120	KLZVS	4-187
I6KLLDK	8-454	I6VFK	8-445	KLLDSH	4-128	KLZVSB	4-185
I6KLLDSH	8-459	I6VFKG30	8-446	KLLDSV	4-129	KLZVST	4-187
I6KLLDSV	8-459	I6VFKK25	8-446	KLLI60	4-115	KLZX	4-184
I6KLLI60	8-450	I6VFKS	8-446	KLLI60.6	4-116	KPBS	7-385
I6KLLKP	8-460	I6VFM	8-447	KLLIBS60	7-411	KPBSKL	7-386
I6KLLSB	8-457	I6VFMM	8-448	KLLKP	4-131	KPCL	5-249
I6KLLT	8-456	I6VFO	8-448	KLLSB	4-126	KPVF	3-78
I6KLLVB	8-457	I6VM	8-487	KLLT	4-123	KPVFL35	3-78
I6KLLVS	8-459	I6VMB	8-448	KLLVB	4-125	KPW	1-38
I6KLLVSB	8-458	I6VOMEGA	8-480	KLLVS	4-129	KR	1-25
I6KLLVST	8-460	I6WK	8-483	KLLVSB	4-127	KUWDT	6-330
I6KLLX	8-456	I6WSU	8-484	KLLVST	4-130		
I6KLM	8-462	IDP	6-367	KLLX	4-124	<b>L</b>	
I6KLMAH	8-467			KLM	4-165	L25	5-262
I6KLMAHV	8-467	<b>K</b>		KLMAH	4-169	L25.50	5-262
I6KLMB	8-464	KBS110	1-12	KLMAHV	4-170	L50.50	5-262
I6KLMDSH	8-468	KBS110.6	1-13	KLMB	4-167	LBS	7-412
I6KLMDSV	8-467	KBS35	1-9	KLMDSH	4-170	LOMEGA150	7-389
I6KLMKP	8-469	KBS60	1-10	KLMDSV	4-170	LOMEGACLU150	3-74
I6KLMSB	8-466	KBS60	7-385	KLMKP	4-172	LOMEGACLU150	5-234
I6KLMT	8-464	KBS85	1-11	KLMMSB	4-169	LV	1-39
I6KLMVB	8-465	KBSI35	1-6	KLMT	4-167	LVBS60	7-387
I6KLMVS	8-468	KBSI60	1-7	KLMVB	4-168		
I6KLMVSB	8-466	KBSI60	7-411	KLMVS	4-171	<b>M</b>	
I6KLMVST	8-468	KBSI60.6	1-8	KLMVSB	4-169	M	5-275
I6KLMX	8-465	KBSM(I)60	1-14	KLMVST	4-171	M	7-428
I6KLMZWAB	8-478	KBV	1-39	KLMX	4-168	MK	6-369
I6KLMZWAB	8-469	KBV	8-443	KLMZWAB	4-201	MP	1-33
I6KLMZWABD	8-472	KCL	5-237	KLMZWAB	4-187	MP3.41.41	5-268
I6KLMZWABD	8-463	KCLBS	7-391	KLMZWAB	4-171	MP41.21	5-265
I6KLMZWABD	8-478	KDRKK3	6-320	KLMZWABD	4-196	MP41.41	5-266
I6KLMZWABD	8-469	KDRKK3	6-346	KLMZWABD	4-182	MP41.41DG	5-267
I6KLZ	8-471	KDVIRK2	6-347	KLMZWABD	4-166	MPCL	7-417
I6KLZAH	8-476	KDVIRK2	6-321	KLMZWABD	4-166	MPCL	7-393
I6KLZAHV	8-476	KDVIRK3	6-322	KLMZWABD	4-166	MPCL41.21	5-250
I6KLZB	8-473	KDVIRK3	6-322	KLMZWABD	4-166	MPV	1-33
I6KLZDSH	8-476	KDVIRK3	6-348	KLMZWABD	4-166	MPVCL	1-34
I6KLZDSV	8-477	KDVIT2	6-323	KLMZWABD	4-166	MPVFCL	3-73
I6KLZKP	8-478	KDVIT3	6-324	KLMZWABD	4-166		
I6KLZSB	8-475	KDVITV3	6-325	KLMZWABD	4-166	<b>N</b>	
I6KLZT	8-473	KDVITWD3	6-328	KLMZWABD	4-166	NATO15	1-19
I6KLZVB	8-474	KDVIZ	6-362	KLMZWABD	4-166	NEO	6-312
I6KLZVS	8-477	KDVKK2	6-344	KLMZWABD	4-166	NEOAVT	6-360
I6KLZVSB	8-475	KDVKK2	6-318	KLMZWABD	4-166	NEOT	6-360
I6KLZVST	8-477	KDVKK3	6-345	KLMZWABD	4-166		
I6KLZX	8-474	KDVKK3	6-319	KLMZWABD	4-166	<b>O</b>	
I6KPVF	8-445	KG110	1-17	KLMZWABD	4-166	OBG	5-220
I6LOMEGA150	8-482	KG110S	1-18	KLMZWABD	4-166	OBG	3-71
I6M	8-489	KG160	1-15	KLMZWABD	4-166	OBGVF	3-71
I6MP41.21.250.6S	8-485	KG160S	1-16	KLMZWABD	4-166	OBZ130	5-230
I6MP41.41.250.6S	8-486	KL60	4-103	KLMZWABD	4-166	OBZ180	5-231
I6PB	8-479	KL60	7-387	KLMZWABD	4-166	OHE	6-361
I6RB	8-488	KL60	4-105	KLMZWABD	4-166	OV	6-369
I6RBK	8-488	KLB	4-105	KLMZWABD	4-166	OVG	6-336
I6RM	8-488	KLBS60	7-386	KLMZWABD	4-166	OVGAN	6-341
I6RO	8-490	KLL110	4-118	KLMZWABD	4-166	OVGB	6-338
I6SLOS	8-479	KLL110.6	4-119	KLMZWABD	4-166	OVGE	6-340
I6SLOS	8-470	KLL85	4-117	KLMZWABD	4-166	OVGEQH	6-342
I6SLOS	8-442	KLLABD	4-121	KLMZWABD	4-166	OVGEQH	6-343
I6SLOS	8-461	KLLAH	4-128	KLMZWABD	4-166	OVGHV	6-342
		KLLAHV	4-128	KLMZWABD	4-166	OVGK	6-339
		KLLB	4-121	KLMZWABD	4-166	OVGP	6-340



## Alphabetical list of references

Reference	Page	Reference	Page	Reference	Page
OVGT	6-339	V15.200	1-35	WKCL	5-243
OVGTAP	6-342	V35	1-36	WKMP27.18	5-243
OVGTR	6-341	V35.200	1-37	WKMP41.21	5-244
OVGVST	6-341	V35.200	2-56	WKMP41.41	5-244
OVGZ	6-340	V35.200	3-78	WKMPCL41.21	5-244
<b>P</b>		V60	1-36	WKMPCL41.41	5-245
PBR	5-219	V60.200	1-37	WKS	5-240
<b>Q</b>		V60.200	4-109	WKSS	5-241
QL	7-412	V60.200	2-56	WKUMP41.41	5-245
<b>R</b>		V85	1-36	WKUMPCL41.41	5-246
RB	5-276	V85.200	1-38	WS	5-235
RBK	5-274	V85.200	2-56	WSUN	5-236
RBKBSM	1-33	VB90	1-28	<b>Z</b>	
RBS	5-278	VBCL	1-28	Z25	5-263
RM	5-276	VE	6-311	Z50	5-263
RO	5-277	VERP	6-314	ZCL	3-73
RO	7-430	VERV	6-313		
ROTD	5-277	VEVP	6-314		
<b>S</b>		VEVV	6-313		
SB90	1-26	VFCB	5-220		
SBCL	1-26	VFCB	3-70		
SDB	1-30	VFCL	3-70		
SDBG	5-219	VFK	3-76		
SKL60	4-104	VFKG30	3-77		
SKPD	5-268	VFKK25	3-77		
SKPE	5-268	VFKNIP	3-79		
SLIS	1-34	VFKS	3-77		
SLOS	1-34	VFM	3-69		
SLOS	3-76	VFMM	3-69		
SLOS	4-109	VFMM35	3-69		
SLOS	4-158	VFO	3-68		
SLOS	6-343	VFOCL	3-68		
SLOS	4-145	VFSLOSCL	3-76		
SLOS	4-131	VFU110	3-66		
SLOS	4-203	VFU35	3-63		
SLOS	4-189	VFU60	3-64		
SLOS	4-173	VFU85	3-65		
SSBU	6-366	VFUL35	3-61		
SYBS	7-388	VFUL60	3-62		
<b>T</b>		VFVLB	3-72		
T	1-23	VGI28	6-307		
TFCL110	2-52	VGI38	6-307		
TFCL110S	2-52	VGI48	6-308		
TFCL60	2-50	VGLI28	6-308		
TFCL60S	2-50	VGLI38	6-309		
TFCL85	2-51	VGLI48	6-310		
TFCL85S	2-51	VH	1-22		
TIM	5-271	VK	6-311		
TIM	7-418	VM	5-275		
TIM	7-395	VM	7-429		
TSBL	6-368	VM6334	5-272		
TSBU	6-363	VM6334	7-428		
TSBU45	6-363	VMB	5-230		
TSBU50	6-364	VMB	3-75		
TSBUD	6-364	VMK	5-275		
<b>U</b>		VMK	7-429		
U24	5-264	VOMEGA	5-234		
U48	5-264	VOMEGA	7-390		
<b>V</b>		VS	1-32		
V110.200	1-38	VS41	5-269		
		VSB	6-310		
		VSSPRAY	5-277		
		<b>W</b>			