AT THE QUOTING PHASE

Dimensional accuracy
All tolerances or specified dimensions given by the customer must be expressly confirmed in written form in our quotations. Otherwise, these shall be deemed not to have been agreed. This applies in particular to drawing specifications – especially if these are sent to us after the order has been placed with the delivery documents or just noted on the parts to be coated. Measuring and testing methods from metal processing must not be used as a basic principle for elastomers. This applies in particular to metallic tolerance and fitting specifications.

Surface preparation
All components will be grit blasted to an Rt of approx. 125 my. Distortion and warpage cannot be ruled out, although we make every effort to avoid these dimensional changes. Areas that are not to be coated are covered for the blasting treatment several times with special protective tape. Therefore, extremely precise, sharp-edged straight edges cannot be produced. If components should NOT be grit blasted, this must be specified in advance in the correspondence.

Coating removal
Is only possible on chemically resistant, metallic substrates. Chemical immersion or thermal treatment removes ALL (including any desired) synthetic treatments present on the component. Non-metallic substrates are generally unsuitable for decoating. These can be damaged or destroyed through no fault of our own. We accept no liability for damage or destruction.

Hardness specifications for elastomers
Shore hardness values plus a tolerance of +/- 5 measuring points. According to DIN, hardness measurements can only be carried out from a coating thickness of plus 3 mm, as otherwise the hardness of the substrate is also measured due to the compression of the measuring device. Consequently, hardness specifications are not permissible for lower coating thicknesses.

Electrical insulation / non-stick properties
All coating materials used are basically highly electrically insulating. For “anti-static custom-made products” we cannot provide any property assurances. This is due to the fact that the conductive properties only develop during material polymerization, which can lead to a variation in effect due to influences such as humidity and temperature. The same applies to anti-adhesion properties. Anti-static coated components must be subjected to individual component testing by the customer.

Colors
These are functional coatings only and not decorative. Color specifications (e.g. RAL) are to be understood as similar and not identical. Color changes (yellowing/browning) are a characteristic of elastomers and are no reasons for complaint. Gloss levels are not material constants but vary depending on air humidity and cannot be influenced by us. Natural rubber or synthetic substrates can emit substances (e.g. gum resin) which lead to massive discoloration/alteration of the coating. Such migrations are substrate-related and are therefore not our responsibility.

Coating thicknesses
Coating thickness values are approximate and may vary considerably depending on spray accessibility and/or part geometry. Only electronic coating thickness gauges are permitted as measuring methods. Calipers and micrometers are generally not permitted for elastomer materials due to their compression force. Target coating thicknesses are always understood to apply only to the defined functional surfaces, not to remote areas that have no effect on the function.

Structures
These are unique hand-made profiles that are applied from a great distance in a few seconds under approx. 200 bar maximum pressure. They can neither be measured exactly nor reproduced in a completely identical manner. A formal deviation cannot be excluded.

DURING MANUFACTURING

Delivery
We do not inspect delivered components for drawing conformity. There is a simple visual inspection for obvious transport damage but no intensive inspection for integrity.

Markings & execution instructions
Hand drawings, markings or hatchings made on the parts to be coated must be photographed by the customer and provided with the parts as a paper printout. In most cases, these markings must be removed and overcoated during processing and are therefore no longer verifiable. MetaLine does not assume any obligation to save or document these beforehand. These are customer markings which must be documented in the customer’s own interest. In case of deviations, the execution selected by us is otherwise always considered as desired.

Edge rounding
Due to their required flow behavior, coatings have a basically ROUND edge. This cannot be prevented physically. With increasing coating thickness, the radius also increases automatically. Depending on the geometry and the selected coating, we cannot promise a fixed radius.

Edge trimming
When removing excess coating, extremely sharp blades must be used in the edge area to cut the coating cleanly. Even with the greatest care, it cannot be ruled out that scratches or slight injuries may occur in the substrate. This cannot be avoided due to the process and is NOT an expression of improper handling.

Date of delivery
All time schedules are to be understood as target performance for a complaint-free first run and internal QA approval. In unfortunate cases, a deviation may occur which requires a part remanufacture including a prior decoating. This rework cannot possibly be carried out within a calculated initial production time, which is why we cannot, as a matter of principle, promise fixed coating deadlines.

AFTER COMPLETION

Vibratory feeder bowls
For feeder bowls, the bowl geometry as well as the baffle design must meet the requirements of the material to be conveyed before coating. The coating cannot compensate for defects in the drive, sorting or baffles. A test run of the bowl does not take place. Depending on the treatment, processing residues (blasting or cleaning agents) may accumulate in cavities and will only come out after commissioning. Baffles and dimensionally accurate outlets cannot usually be coated as well and are kept free of coating in case of doubt. Conveyed goods cannot be returned for reasons of safety against mix-up, but will be disposed by us.

Surface Imperfections
Unlike automotive paint, elastomeric coatings cannot be polished after polymerization. This means that small imperfections, such as particle inclusions, can no longer be removed or corrected. Therefore, normal coating unevenness is not a reason for complaint.

Visibility
Visibility complaints that are not perceptible at the usual viewing distance are considered unfounded. Enlargements, in particular by photo zoom, are not a representation of the technically correct, part-specific use and are not recognized as a basis for complaint.

Shipping
The packaging of each component is just as individual as the coating. We make every effort to provide the best possible protection for the part and coating during return transport by means of sensible packaging. However, we do not assume any responsibility for destructive external effects or even destruction. It is mandatory that the customer has his own transport insurance. The transfer of risk takes place ex works with the handover to the carrier.

A final word
MetaLine are purely FUNCTIONAL coatings that are applied in a multi-step free-measurement process using 100% manual work. The material is rubber-like tough-elastic and thus prevents automated, consistently perfect OPTICAL results. With our service we owe a perfect performance in the form of a professional processing and the achievement of the documented, physical coating material parameters. However, we do not owe the desired coating function, which results from a multitude of more or less known and uncontrollable, customer-specific parameters. All our services and deliveries are commercially based on our “General Terms and Conditions” in the latest version.

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