

## ZABAG corrosion protection system “3Plus“

### 1. Preparation:

All steel parts – if not hot-dip galvanised inside and outside (DIN 1461) - are being blasted in order to achieve a metallic bright condition (all according to DIN 8567 and DIN 8201). The metallic bright and roughened surface offers the ideal basis for all protection layers to be applied afterwards.

### 2. Surface galvanisation

Excluding outdoor weathering, the metallic bright surfaces are being flame-spray galvanised with pure zinc (according to DIN EN 22063) directly afterwards. The minimum thickness of the applied zinc layer amounts to 100 µ. A thermal distortion is excluded.

### 3. Thermal outgassing:

Afterwards, the parts are being tempered in the oven at about 200 °C, whereby gasses contained in the galvanised surface escape. This prevents blister under the powder coating layers.

### 4. Two-phase powder coating

The first powder layer is being applied by using epoxy primer (airless procedure, electrostatically) and afterwards thermally hardened in the oven at 180 °C for about 20 minutes. The minimum thickness of the primer layer amounts to about 80 µ. The second powder layer in the chosen RAL colour is being applied according to the first one and thermally hardened. The minimum thickness of the primer layer also amounts to about 80 µ.

The ZABAG corrosion protection system “3Plus“ altogether reaches a layer thickness of about 250 µ and is suitable as a long term corrosion protection for all climate zones. Moreover, the ZABAG corrosion protection 3Plus meets highest standards as to UV and scratch resistance, is abrasion- and shock-proof as well as resistant against solvents, chemicals and oils.

The following standards are met:

- ✓ condensation water alternating atmosphere with sulphur dioxide containing atmosphere (DIN 50017)
- ✓ adhesiveness (EN ISO 2360)
- ✓ bending strength (ASTM D522, 5 mm)
- ✓ acetic acid-salt spray test (ISO 9227)
- ✓ accelerated weathering test (EN ISO 11341)
- ✓ Kesternich-test (EN ISO 3231)

## OBJEKTSICHERUNG

Schiebetoranlagen  
Teleskop-Schiebetoranlagen  
Drehflügelstore, Faltflügelstore  
Drehkreuze  
Schranken  
Parksysteme  
Arealsicherung für Gewerbe und Industrie  
Sonderkonstruktionen

## MECHANISCHE FERTIGUNG

Drehen/Fräsen  
2D-/3D-Laserschneiden  
CNC-Abkanten  
Rundrohr- u. Rechteckschneiden  
Schweißbaugruppen  
Sonderkonstruktionen

## E-SERVICE

Zugangsanlagen  
Prüfung/Wartung  
E-Sicherheitstechnik  
SPS-Steuerungen

## OBERFLÄCHENVEREDELUNG

Pulverbeschichtung  
Lichtbogenspritzverzinkung  
Feuerverzinkung  
Nasslackbeschichtung

## KONTAKT:

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## NIEDERLASSUNGEN

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## GESCHÄFTSFÜHRENDE

GESELLSCHAFTER:  
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Amtsgericht Chemnitz · HRB 1946  
USt-IdNr. DE 140918786

## BANKVERBINDUNGEN:

KREISSPARKASSE FREIBERG  
Konto: 32 19 000 699  
BLZ: 870 520 00  
VOLKSBANK ERZGEBIRGE  
Konto: 39 865 00  
BLZ: 870 960 34  
VOLKSBANK CHEMNITZ  
Konto: 36 000 67 51  
BLZ: 870 962 14



Großer  
Eignungsnachweis  
zum Schweißen nach  
DIN 18800  
DIN 18801  
DIN 18808



Verein  
für die Präqualifikation  
von  
Bauunternehmen  
e.V.  
eingetragen unter der  
Registernummer 010.234563