
Kalmar Group Standard

KGS 50501

Part

Method Standards

Name

Surface treatment designations - Compilation

Group

Manufacturing Methods

1 Scope

This Kalmar Group Standard, hereinafter referred to as KGS, gives the overview of the different surface treatment methods used in Kalmar and how they shall be designated in drawings. It also helps suppliers to easily find the referred requirement standard in use.

2 Purpose

For the purpose of having one common way to designate different surface treatment methods.

3 Responsibilities

Design Engineers - when applicable, note the relevant information in technical documents such as drawings and BOMs

4 Definitions

BOM - Bill of materials

XX - Indication code

5 References

KGS 50501	Surface treatment designation - Compilation
KGS 50515	Surface treatment - Requirements - Hot dip galvanizing
KGS 50517	Surface treatment - Requirements - Chemical nickel-plating
KGS 50525	Surface treatment - Requirements - Alkaline Zinc + Black [...]
KGS 50523	Surface treatment - Requirements - Zinc + Thick films passivation [...]
KGS 50519	Surface treatment - Requirements - Nitrocarburizing + post oxidation
K-std. 20600.0001	Painting
K-std. 20651.0002	Organic surface treatment – manufacturing requirements: Powder coating

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6 Procedure description

The indication on drawing shall be written: "Surface treatment Kalmar KGS 50501" followed by a slash followed by the indication code for the selected surface treatment, i.e.

Surface treatment Kalmar KGS 50501/XX

Table 1 - Inorganic surface treatments

Indication code	Surface treatment method	Additional information specified on drawing	Requirements
I1	Hot dip galvanizing		KGS 50515
I2	Chemical nickel-plating	Coat thickness: 30 µm or 50 µm	KGS 50517
I3	Alkaline Zinc + Black passivation and Sealer		KGS 50525
I4	Zinc + Thick films passivation with sealer		KGS 50523
I5	Nitrocarburizing + post oxidation		KGS 50519

Table 2 - Organic surface treatments

Indication code	Surface treatment method	Additional information specified on drawing	Requirements
O1	Painting SC1		K-std. 20600.0001
O2	Painting SC2		K-std. 20600.0001
O3	Painting SC3		K-std. 20600.0001
O4	Powder coating 70 °C		K-std. 20651.0002
O5	Powder coating 400 °C		K-std. 20651.0002

Example 1

If selecting hot dip galvanizing as the surface treatment, the indication on drawing shall be written:
Surface treatment Kalmar KGS 50501/I1

Example 2

If selecting chemical nickel-plating as the surface treatment with a coating thickness of 30 µm, the indication on drawing shall be written:
Surface treatment Kalmar KGS 50501/I2 30 µm

Example 3

If selecting powder coating 70°C as the surface treatment, the indication on drawing shall be written:
Surface treatment Kalmar KGS 50501/O4