

ROLEC Gehäuse-Systeme GmbH

Enclosure cleaning procedure

(Preliminary treatment for surface coating)

Enclosures are introduced into the washing chamber. The chamber is flooded and the enclosures are cleaned by means of a rotating movement. Duration: 85 sec.
Cleansing agent drip off phase (due to entrainment) Duration: 30 Sec.
Clear rinsing with clean VE water Duration: 17 Sec.
Drip off phase VE water Duration: 9 Sec.
Rinsing procedure VE water The chamber is flooded and the enclosures are cleaned by means of a rotating movement.. Duration: 75 Sec.
Drip off phase VE water (due to entrainment) Duration: 25 Sec.
Clear rinsing with clean VE water Duration: 25 Sec.
Drip off phase VE water Duration: 12 Sec.
Spray rinsing with VE water Duration: 120 Sec.
Drip off phase VE water Duration: 25 Sec.
Rinsing procedure VE water Duration: 15 Sec.
Drip off phase VE water Duration: 10 Sec.
Drying Drying with hot air 120°C ±10°C Duration: 200 Sec.
Residual vacuum emptying Duration: 10 Sec.
Vacuum drying min. 80°C – max 140°C Duration: 120 Sec.

Cleaning procedure

During the whole procedure, the enclosures are subject to a rotating movement.

Cleansing and rinsing temperature: 75°C +10°C/-5°C.

Cleansing agent: ESKAPHOR K 6783
 ESKAPHOR EM 325 degreasing intensifier

