



MÄKELÄ ALU

DECORAL

Instructions for delivering
items for batch coating



What can be coated?

- Aluminium, steel. Steel should be as thin as possible.
- Profiles, flat sheets, bent sheets, 3D objects.
- Maximum dimensions: length 6700mm, height 240mm, width 1500mm.
- The optimum maximum size of flat sheets is 1250x2500mm.
- Larger items must be assessed on a case-by-case basis.





Before sending any items, please note the following:

- The raw material must be well packed and visible surfaces must be protected.
- Powdercoating does not remove imperfections or fill holes. The surface quality of the material must be good even when raw.
- Visible surfaces must not be marked in ink or taped.
- Do not send puttied or oxidised items for coating. All sharp edges/chamfers must be sanded before coating, even on non-visible surfaces.
- Powdercoating leaves a hanging mark. As a rule, the items must have hanging holes/hooks! For long profiles, we make the necessary hanging holes ourselves!

- Profiles have to be protected with tape at both ends, which takes away 25mm + 25mm from the working length. For heavy profiles, the working length is reduced by 75mm + 75mm.
- If the item to be coated is cut to size, the cut surfaces must be sanded inside and out.
- Do not send any items until you have received an order confirmation and a notification of arrival.
- The notification of arrival must be visible in the incoming consignment. The items will be delivered to the address indicated in the notification of arrival.
- The incoming consignment must also include a consignment note with photos. Provide photos only for the items to be coated. The photos should clearly show the visible surfaces and the pattern direction.
- Orders must always include the coating code and film code.
- Orders must indicate the estimated date of arrival of the material. The final delivery time will be confirmed when the material arrives.





Failed deliveries

If the above instructions have not been followed and the items sent for surface treatment show the above problems, please note the following:

- We may need to return the items for repair.
- The delivery time will change.
- If the items have to be repaired by us, we will charge you for the additional work.
- Repairs do not necessarily solve the problem, leaving the customer responsible for the outcome.



See examples of failed deliveries

- SLIDE 8: On the left, the cut surfaces and burrs are so rough and sharp that even sanding won't fix it. On the right, there are some burrs left along cutting edges, which need to be sanded before coating.
- SLIDE 9: On the left, impurities are visible after coating. On the right, the edges of the holes need to be sanded before coating.
- SLIDE 10: Poor-quality welding on the left → the holes cannot be filled. On the right, welding debris that breaks the heat-transfer film and the coating fails.
- SLIDE 11: On the left, poorly welded seams → the hole above cannot be filled and the seam below needs to be sanded to smooth out the surface. On the right, bad welding → holes cannot be filled.
- SLIDE 12: Surface oxidation → this can prevent the coating from adhering properly. Even after sanding and pre-treatment, oxidation can appear as patches after coating.
- SLIDE 13: Oxidation (see slide 12)
- SLIDE 14: On the left, old paint + putty → Decoral cannot be applied on top of old paint. Only anodizing is allowed. The powder-coating material will not cross-link to the surface of the putty and the silicone used in them can impair the properties of the powder-coating paint shop's pre-treatment agents! Oxidation on the right (see slide 12).



See examples of failed deliveries

- SLIDE 15: On the left, other paint (see slide 14) and traces of edging → Decoral does not fill the holes. On the right, other paint (see slide 14) and scratches → Decoral does not fill the holes!
- SLIDE 16: Air bubbles on the left → Decoral does not cover unevenness. On the right, material insufficiency and impurities on the profile → Decoral does not fill the holes/scratches!
- SLIDE 17: On the left, the cut surfaces are sharp → If the product to be coated is cut to size, it must be sanded inside and out. On the right, putty (see slide 14) and a fracture → Decoral does not fill the holes!
- SLIDE 18: On the left, debris on a visible surface → breaks the heat-transfer film and the coating fails. Visible after coating. On the right, sharp cut surfaces (see slide 17).
- SLIDE 19: An example video of how sharp edges should be sanded → you should be able to slide your bare hands on the surface without getting cuts/scratches.
- SLIDES 20 & 21: Examples of bagging. Each item is bagged and the air is sucked out of the bag before heating. Even the slightest sharp edge can break the bag and the sublimation will fail. Therefore, all sharp edges, not only on visible surfaces, must be sanded before coating.



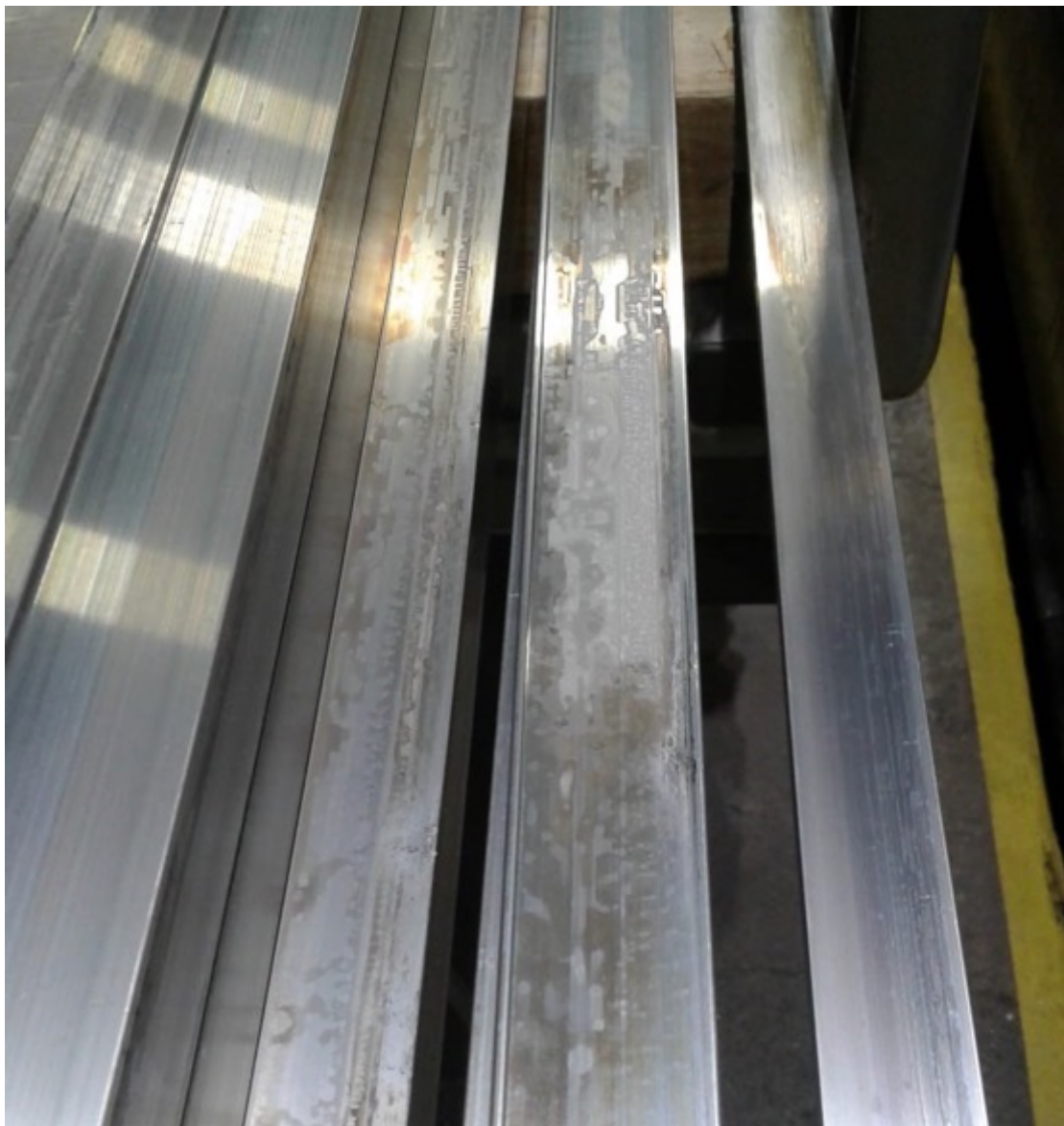






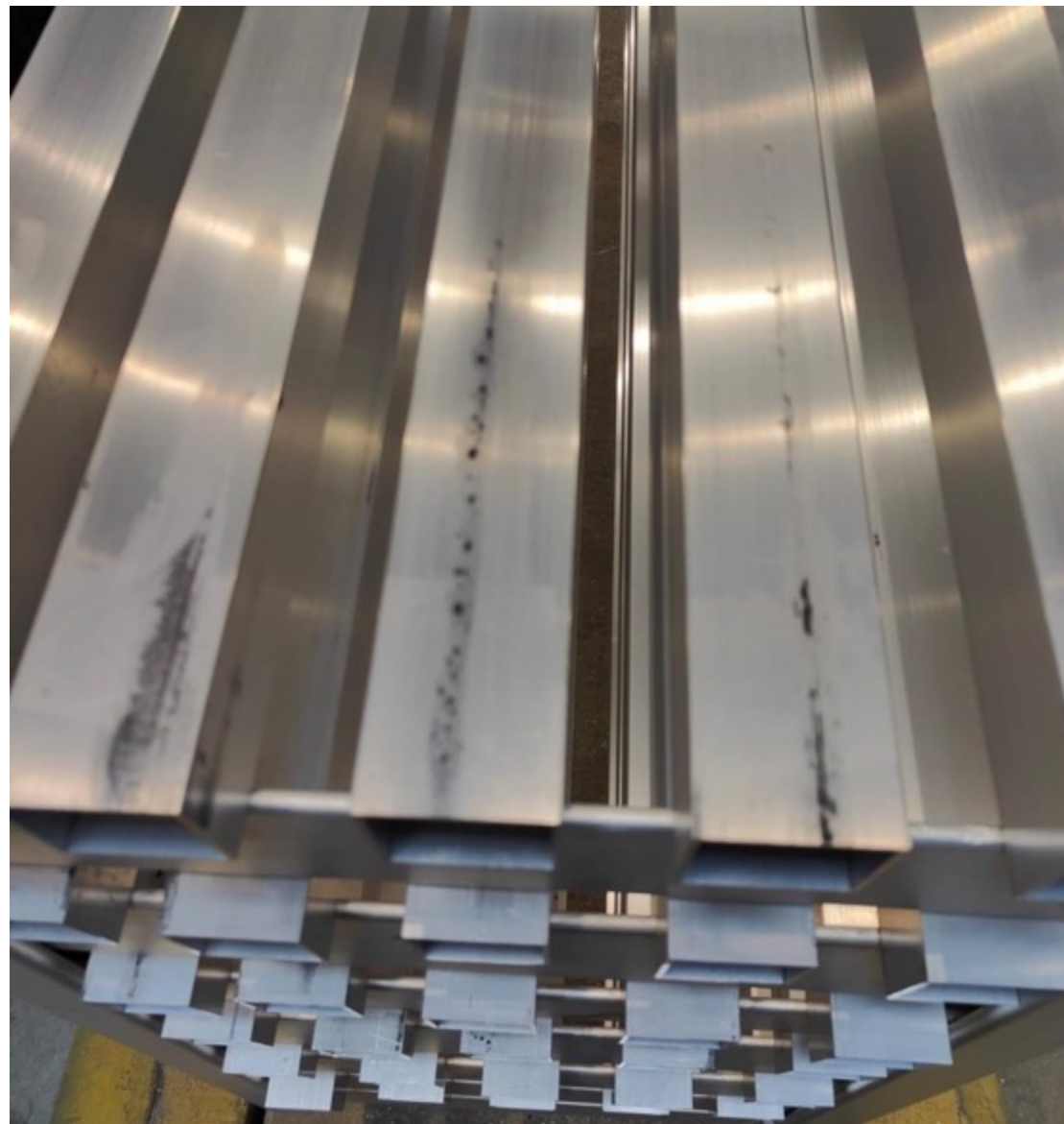
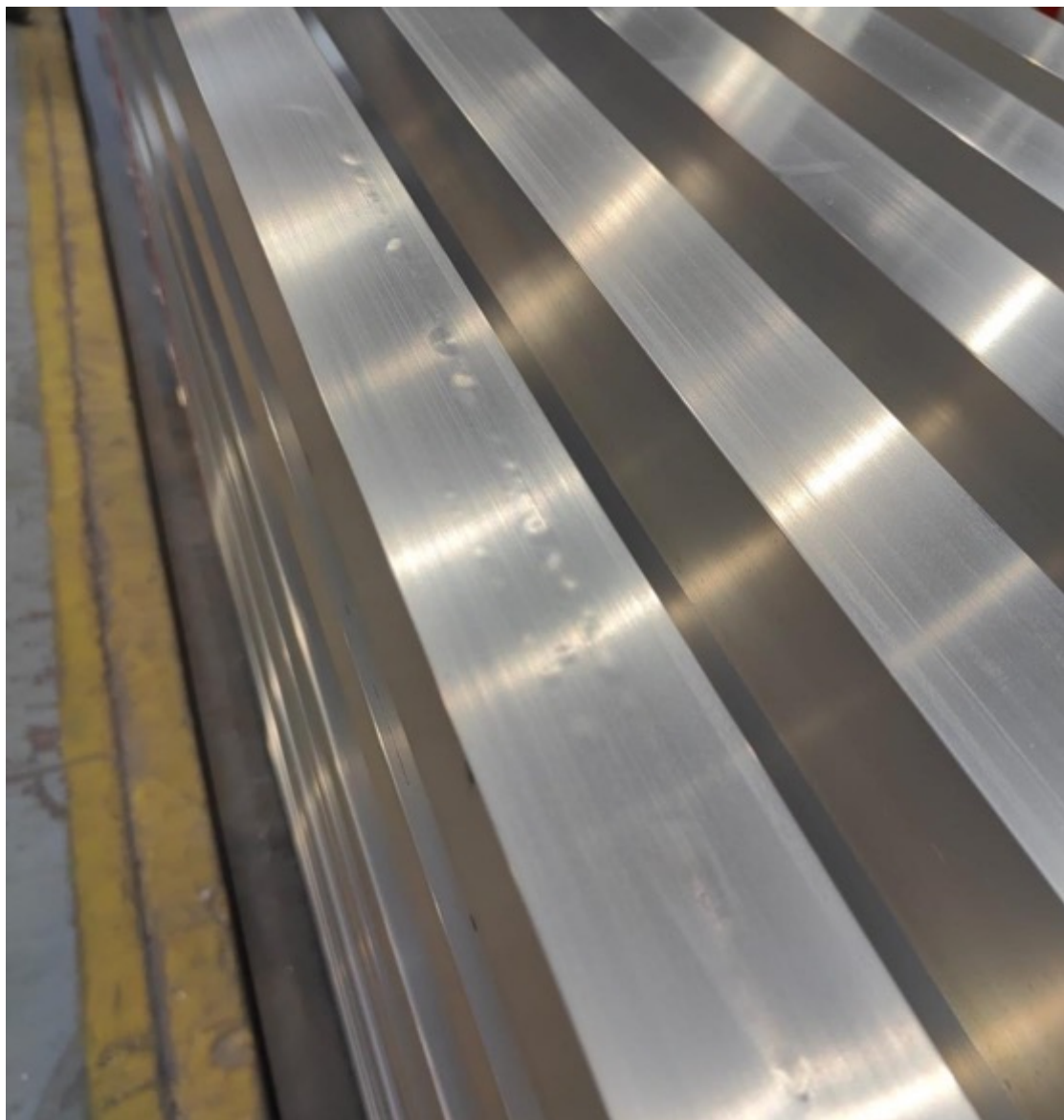


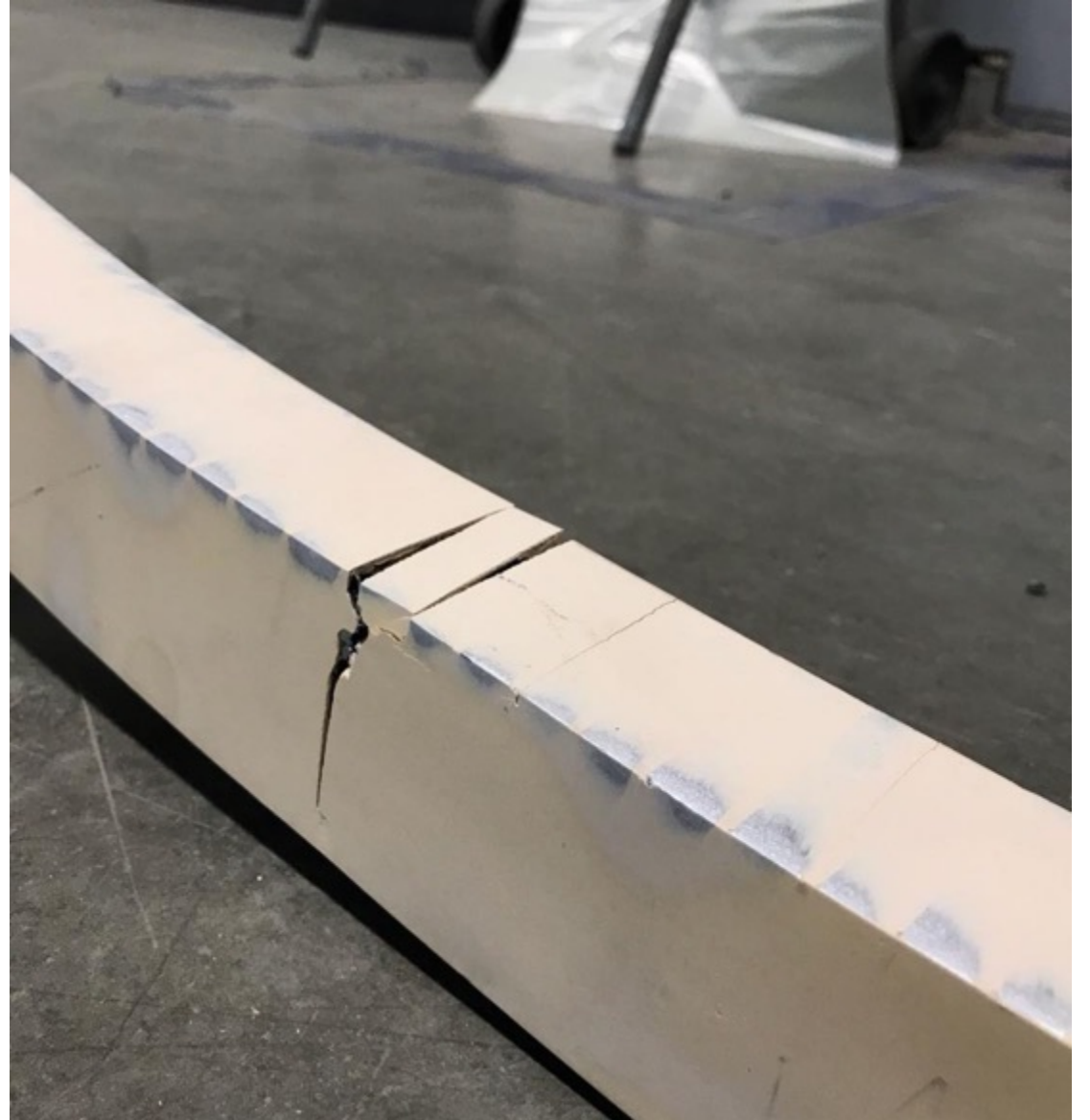


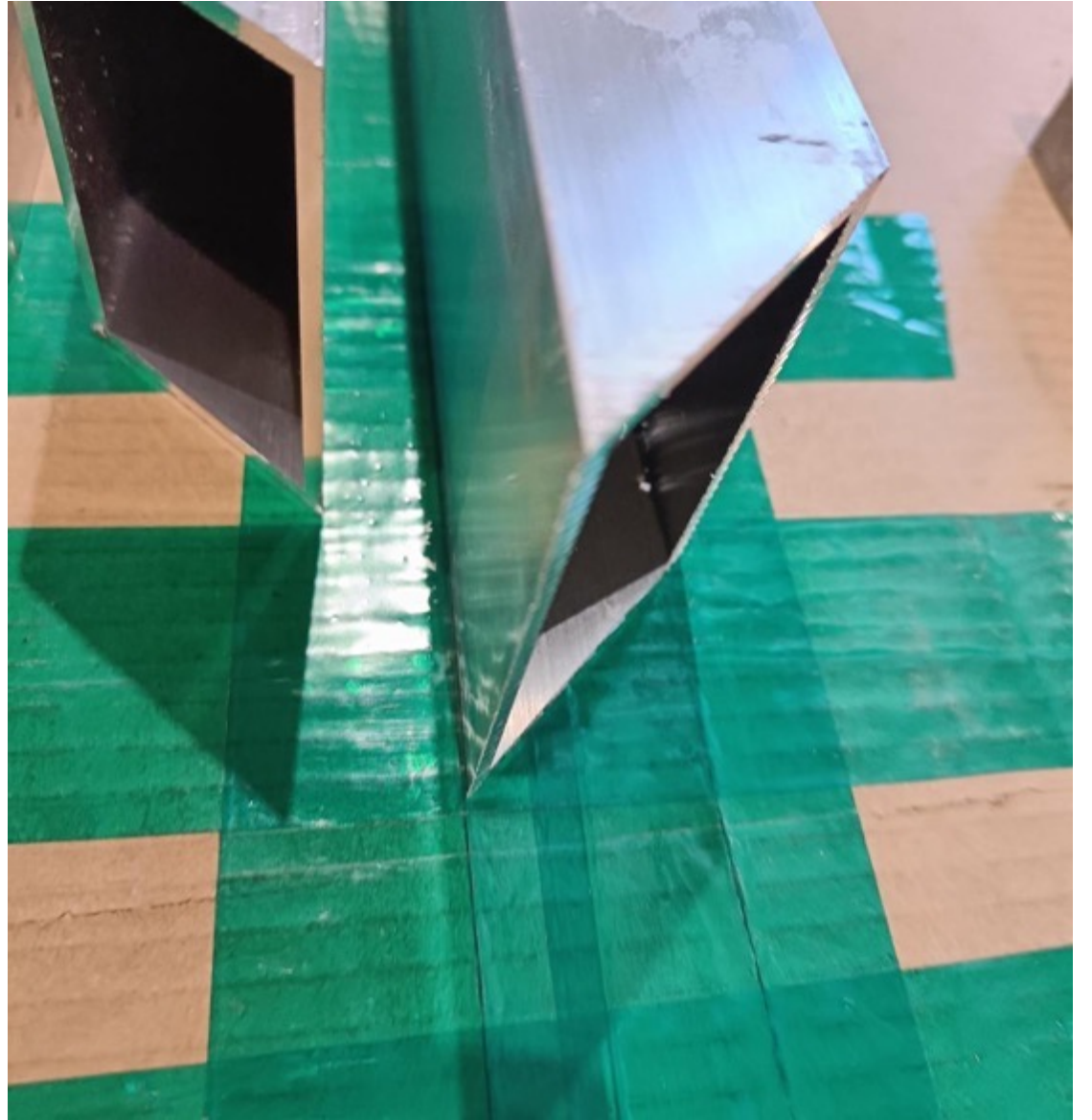


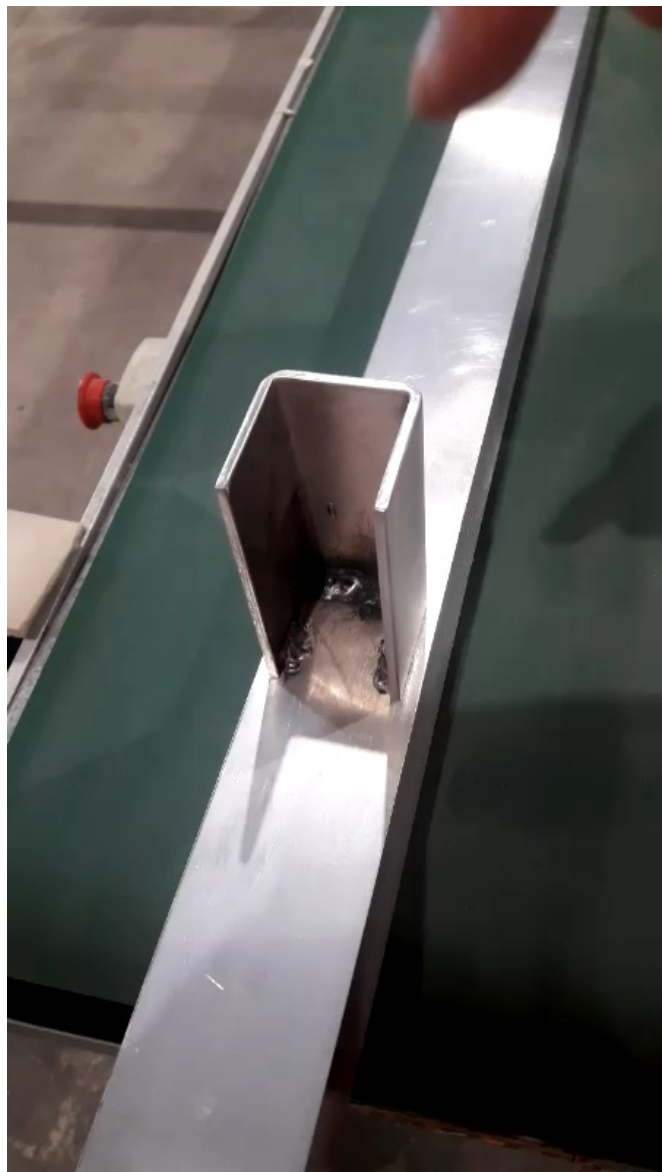




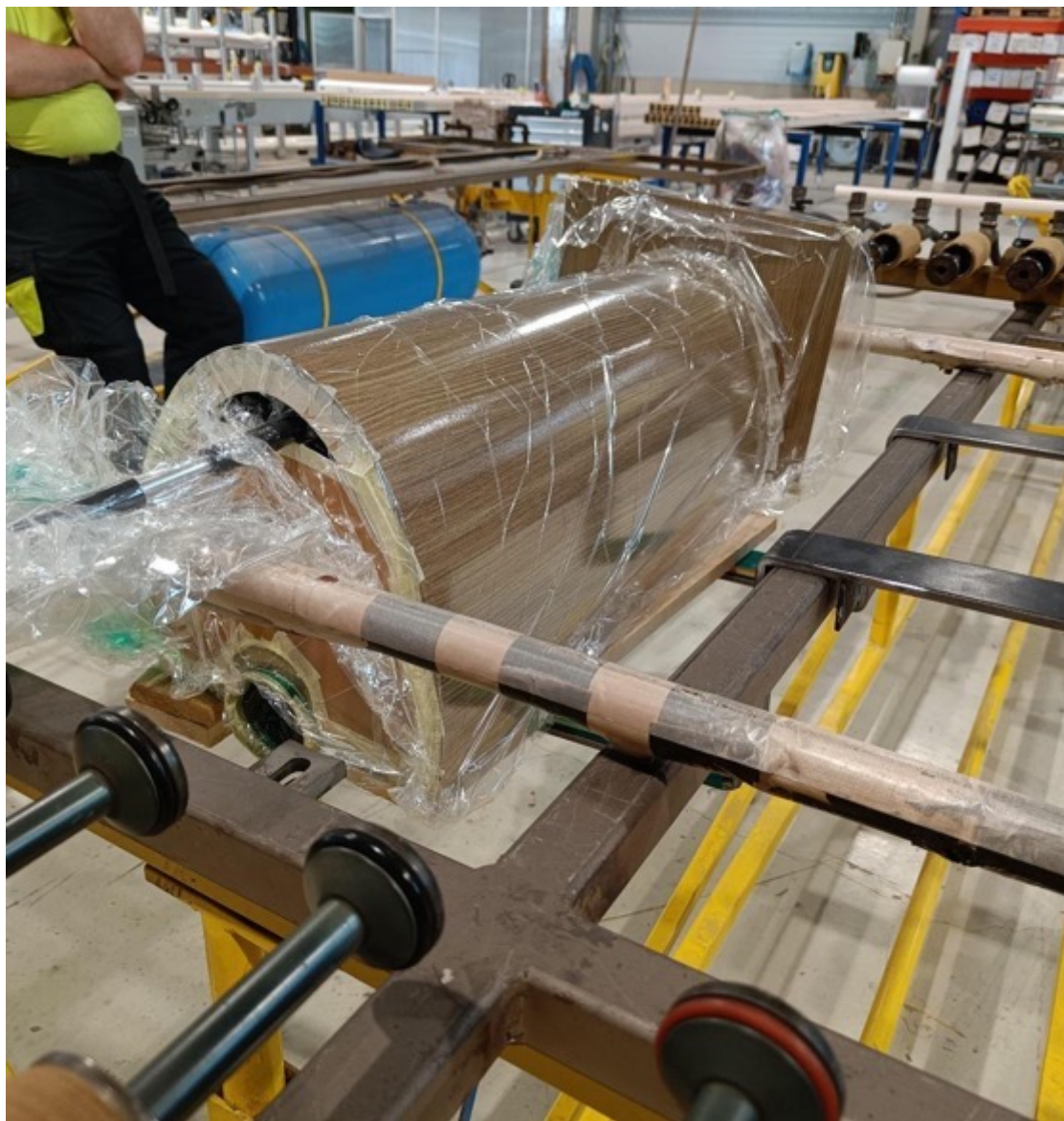














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