

Title (en)

ARRANGEMENT AND METHOD FOR ELECTROPHORETIC ENAMELLING BY THE 2-COAT 1-BAKE METHOD

Title (de)

ANORDNUNG UND VERFAHREN ZUM ELEKTROPHORETISCHEN EMAILLIEREN NACH DEM 2 SCHICHTEN-1 BRAND-VERFAHREN

Title (fr)

SYSTEME ET PROCEDE D'EMAILLAGE ELECTROPHORETIQUE SELON LE PROCEDE 1 CUISSON 2 COUCHES

Publication

**EP 0791084 B1 20000315 (DE)**

Application

**EP 96931069 A 19960911**

Priority

- DE 19533668 A 19950913
- EP 9603974 W 19960911

Abstract (en)

[origin: DE19533668A1] The invention concerns an arrangement for electrophoretic enamelling by the 2-coat - 1-bake method, using a treatment bath for applying the base enamel, at least one subsequent rinsing bath before a treatment bath for applying the cover enamel, at least one further rinsing bath and a baking furnace. The invention further concerns a method of enamelling using the above arrangement. In order to be able to prevent flaws in the enamel irrespective of the base and cover enamel frit compositions, an additional treatment bath is introduced after a first rinsing bath following the application of the base enamel. This additional treatment bath contains at least one chemical substance which acts on the aluminium hydroxide in the base enamel and/or forms undissociated compounds with aluminium ions. This substance is advantageously rinsed off the workpiece in a subsequent rinsing bath, before the cover enamel is applied.

IPC 1-7

**C25D 5/02**; **C25D 13/02**

IPC 8 full level

**C25D 5/02** (2006.01); **C25D 13/02** (2006.01)

CPC (source: EP US)

**C25D 5/02** (2013.01 - EP US); **C25D 13/02** (2013.01 - EP US)

Designated contracting state (EPC)

DE FR IT

DOCDB simple family (publication)

**DE 19533668 A1 19970320**; DE 59604682 D1 20000420; EP 0791084 A1 19970827; EP 0791084 B1 20000315; US 5855754 A 19990105; WO 9710371 A1 19970320

DOCDB simple family (application)

**DE 19533668 A 19950913**; DE 59604682 T 19960911; EP 9603974 W 19960911; EP 96931069 A 19960911; US 81728197 A 19970619