

Title (en)

Process and apparatus for applying a phosphate coating on workpieces

Title (de)

Verfahren und Vorrichtung zum Aufbringen eines Phosphatüberzuges auf Werkstücke

Title (fr)

Procédé et dispositif pour appliquer sur des pièces une couche de phosphate

Publication

EP 0987350 B1 20060628 (DE)

Application

EP 99890263 A 19990805

Priority

AT 136398 A 19980806

Abstract (en)

[origin: EP0987350A2] A long ferrous metal workpiece is phosphate coated by passing the heated moving workpiece through a phosphating bath while supplying an electric (preferably cathodic) current. A phosphate coating is applied onto a long ferrous metal workpiece by heating the moving workpiece and then passing it through a phosphating bath with a dwell time of 1.5-19 (preferably 4-9) sec. in the presence of an electric (preferably cathodic) current. An Independent claim is also included for a phosphate coating apparatus for carrying out the above process, in which the phosphating unit (5) is preceded by a workpiece preheater (3) and is in the form of an electrolytic unit with a tubular electrode surrounding the workpiece (11).

IPC 8 full level

C25D 11/36 (2006.01)

CPC (source: EP)

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Cited by

CN110863229A; DE102015121349A1; CN103741195A; CN112226755A

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EP 0987350 A2 20000322; EP 0987350 A3 20040324; EP 0987350 B1 20060628; AT 405947 B 19991227; AT A136398 A 19990515; CZ 271099 A3 20000315; CZ 295733 B6 20051012; DE 59913624 D1 20060810; ES 2268846 T3 20070316

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