

Title (en)

Method for manufacturing a component part and component part

Title (de)

Verfahren zur Herstellung eines Bauteils sowie Bauteil

Title (fr)

Procédé destiné à la fabrication d'une composant ainsi que composant

Publication

EP 2048265 A1 20090415 (DE)

Application

EP 07019699 A 20071009

Priority

EP 07019699 A 20071009

Abstract (en)

The method for producing a sanitary component part (1), comprises applying a predetermined masking color by pressure on a metallic surface layer (2), which comprises two surface sections with a different appearance for forming an inscription and/or a decoration design, recessing a free area of a surface layer (3, 4) or an intermediate layer associating a color marking means by a masking color, removing the free area under formation of a recess through galvanization or with a colored marking means, and applying a metal layer as colored marking means in the recess and/or the free area. The method for producing a sanitary component part (1), comprises applying a predetermined masking color by pressure on a metallic surface layer (2), which comprises two surface sections with a different appearance for the formation of an inscription and/or a decoration design, recessing a free area of a surface layer (3, 4) or an intermediate layer associating a color marking means by a masking color, removing the surface layer or intermediate layer under the formation of a recess through galvanization or with a colored marking means, applying a metal layer as colored marking means in the uncovered recess and/or the free area, and removing the masking color from the surface layer and/or the intermediate layer. The masking color is applied through screen printings on the continuous, non-galvanizable surface layer or the non-galvanizable intermediate layer. The metal layer or metal alloy layer is introduced into the recess. A semi-finished material provided with the masking color is immersed in an acid bath, so that the uncovered surface layer or the uncovered intermediate layer is removed. The surface of the semi-finished material is washed after removing the uncovered surface layer or intermediate layer. A metallic carrier of the component is manufactured as a galvanizable pulled sheet metal or as a galvanizable plastic before the masking color is applied on the surface layer and/or the intermediate layer, and incorporates the surface layer and/or another intermediate layer. The metallic carrier of the semi-finished material is coated with a copper layer and/or nickel layer after the die casting process, and then coated with the chromium layer by galvanically applying process. An independent claim is included for a die casting component.

Abstract (de)

Die Erfindung betrifft ein Verfahren zur Herstellung eines Bauteils, insbesondere eines sanitären Bauteils, mit einer verchromten Oberflächenschicht, die mindestens zwei Oberflächenabschnitte mit einem unterschiedlichen Erscheinungsbild aufweist zur Bildung einer Beschriftung und/oder eines Dekorationsmusters, dadurch gekennzeichnet, dass eine vorgegebene Maskierungsfarbe mittels Drucken aufgebracht wird, wobei ein ein farbig abgesetzte Mittel aufzunehmender freier Bereich der Oberflächenschicht oder einer Zwischenschicht von der Maskierungsfarbe ausgespart wird, dass die Oberflächenschicht oder die Zwischenschicht in dem freien Bereich unter Ausbildung einer Vertiefung (durch Galvanisieren entfernt oder mit einem farbig abgesetzten Mittel wird, dass als farbig abgesetztes Mittel eine Metallschicht in die freigelegte Vertiefung bzw. den freien Bereich eingebracht wird und dass die Maskierungsfarbe von der Oberflächenschicht bzw. der Zwischenschicht entfernt wird.

IPC 8 full level

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CPC (source: EP US)

B44C 1/227 (2013.01 - EP); **B44C 3/02** (2013.01 - EP US); **C25D 5/022** (2013.01 - EP); **C25D 5/14** (2013.01 - EP US); **C25D 5/627** (2020.08 - EP US)

Citation (applicant)

- EP 0405006 A2 19910102 - BIRKENMEIER PETER [DE]
- JP 2006291275 A 20061026 - KAYOH TECHNICAL INDUSTRY CO LT
- CH 554756 A 19741015 - OXY METAL FINISHING CORP
- DE 19710623 A1 19971106 - GROHE KG HANS [DE]

Citation (search report)

- [XY] CH 554756 A 19741015 - OXY METAL FINISHING CORP
- [DYA] DE 19710623 A1 19971106 - GROHE KG HANS [DE]
- [X] EP 0405006 A2 19910102 - BIRKENMEIER PETER [DE]
- [X] JP 2006291275 A 20061026 - KAYOH TECHNICAL INDUSTRY CO LT

Citation (examination)

US 1996187 A 19350402 - BARNHART GEORGE E

Cited by

CN103806047A; EP2724818A1; EP2840168A3; CN111185719A; US2017362730A1; DE102010043046A1; DE102010043046B4; US2014087204A1; EP3575447A1; US11499242B2; US10557209B2; WO2019228902A1; WO2016098087A3; US9017775B2; DE102012008544A1; WO2013164165A1; WO2011023798A1

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