

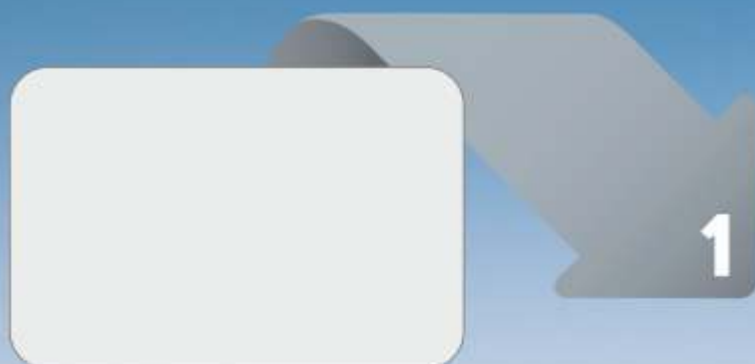


CRUISE & YACHTS INDUSTRY

COATING AND DECORATION ON METALS



DECORAL® SUBLIMATION PROCESS - STEP BY STEP



1

METALLIC SUBSTRATE

RAW ALUMINIUM

All treatments prior to coating (powder coating) must include a phase of attack on aluminum. Such attack consists of one or more phases, the last of which, made before chemical conversion, must be acid. The total degree of attack must be at least 2 g/m².

The chemical conversion pre-treatment (chromate conversion) must be carried out according to ISO 10546 norm. After pre-treatment, the final wash must be made with demineralized water. In case of yellow chromate chemical conversion, the weight of the layer must fall between 0.6 and 1.2 g/m².



2

METAL PRE-TREATMENT



3

POWDER COATING

Polyurethane coating Powders, specially formulated for the sublimation process by Decoral System, are Qualicoat approved.

Pre-treatment and coating are undertaken by Verniciatura Industriale Veneta, a Qualicoat licensed coater (licence nr 704).



DECORATED ALUMINIUM

The sublimation film, printed with special inks, must adhere perfectly to the coated substrate that should be decorated.

Moreover, the temperature must reach 195-210°C. The sublimation films ("Heat transfer film") used are produced by Decoral System (in accordance with Qualideco) and are applied by Viv Decoral, a Qualideco licensed decorator (licence IT-003F).



Licence nr. IT-003F

POLYURETHANIC DECORAL® COATING



Thanks to the powder coating process, it is possible to get Polyurethanic Decoral® Coating finish in various colours (RAL, NCS, Pantone, sample matching). The production cycle consists of a number of specific pre-treatments, followed by coating with special polyurethane Powders (Decoral System polyurethane powder coating). The Powders used comply with the requirements of Qualicoat international specification with approvals P-0506, P-0617, P-0832 and P-0865.



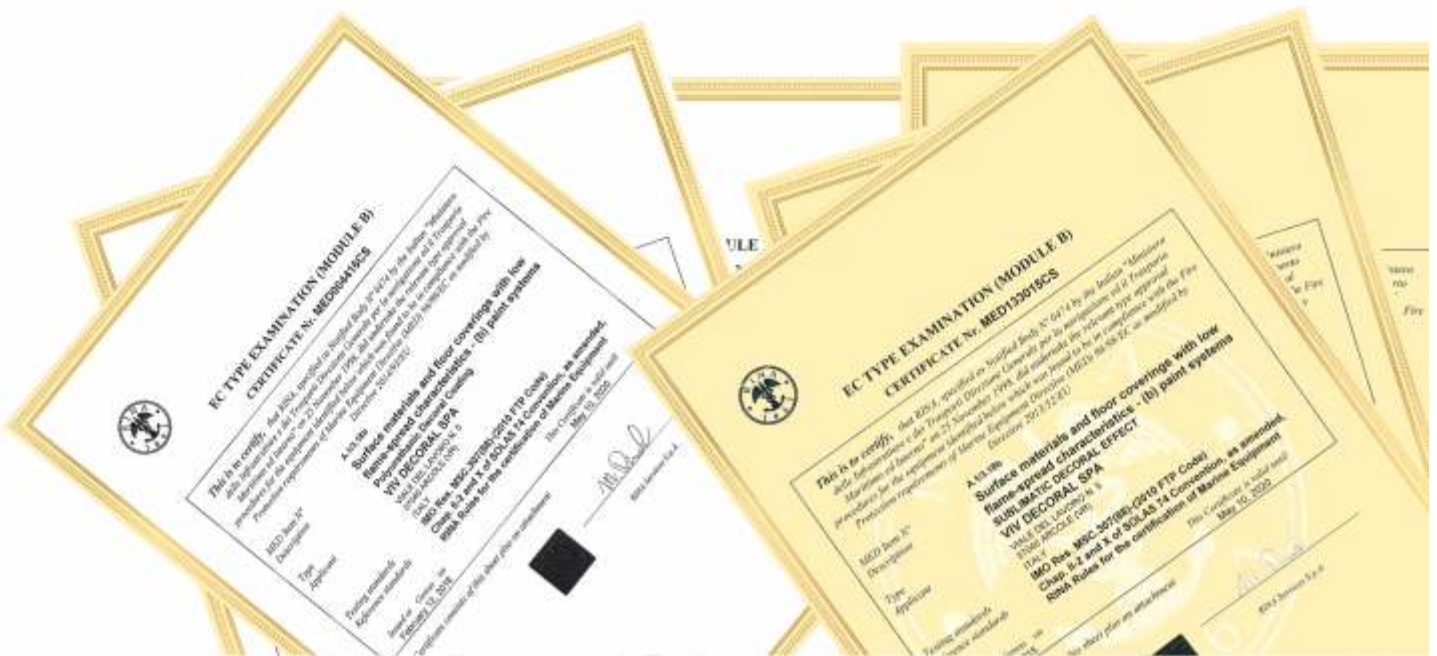
SUBLIMATIC DECORAL® EFFECT



The wood finish Sublimatic Decoral® Effect is obtained through the sublimation process. The production cycle is divided into several steps, including coating with special polyurethane Powders (Decoral System polyurethane powder coating) and heat transfer, which requires sublimation Films (Decoral System heat transfer films). Such Films are a faithful reproduction of real wood, showing flames, knots, light and dark areas.

The raw materials used for manufacturing Powders and Films are produced in accordance with the standards set by Qualideco international specification. Licences are as follows:

- Decoral System polyurethane powder coating, produced under Qualideco Powder Supplier PS-001 licence
- Decoral System heat transfer PET film, produced under Qualideco Film Supplier FS-001 licence





RESTORANTSHIP IN MOSCOW



Finishing:
Copper 523/222R

Sublimatic Decoral® Effect



COSTA DIADEMA

Spencer Contract, High Quality Interiors



Sublimatic Decoral® Effect



Finishing:
Teak 451-203R



ROYAL PRINCESS

Spencer Contract, High Quality Interiors



Sublimatic Decoral® Effect



Finishing:
Wengé 462/206R



YACHTS INTERIOR



Sublimatic Decoral[®] Effect



Finishing:
Ulivo 592/154

