

## Wet-on-wet application of agglomerate markings

With some types of agglomerate markings, the agglomerates consisting of highly viscous marking material are applied to a low-viscosity marking material that has been sprayed on shortly before (wet-on-wet process).

This can be done in two successive steps using two machines, or in a single step using just one machine on which both application systems are installed.

Maintaining the application quantity of a marking material is much more difficult with manual control than with path-dependent control, because changes in marking speed, marking material viscosity (temperature), and spray pressure have a direct influence on the application quantity and thus on the layer thickness.

These are usually corrected by changing the speed when deviations from the target are detected.

If both application systems are installed on one machine, manual control of the marking application is not just twice as difficult, but many times more difficult.

While the marking material application can be adjusted to the desired size by making appropriate changes to the marking speed in a single installation, the possibility of correction by changing the speed is limited when both application systems are installed on one machine.

This is because changing the speed to correct the incorrect application of one marking material also changes the previously correct application of the other marking material in the same way. Its application then deviates from the target.

Other measures must therefore be taken to eliminate the deviation in application quantities, e.g., by changing the application pressures or pump delivery rates.

In contrast, with the distance-dependent method using two metering pumps, the previously set application quantities of both marking materials are always automatically kept constant when the speed changes. And, as is well known, this also applies to changes in marking speed and marking material viscosity.

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