



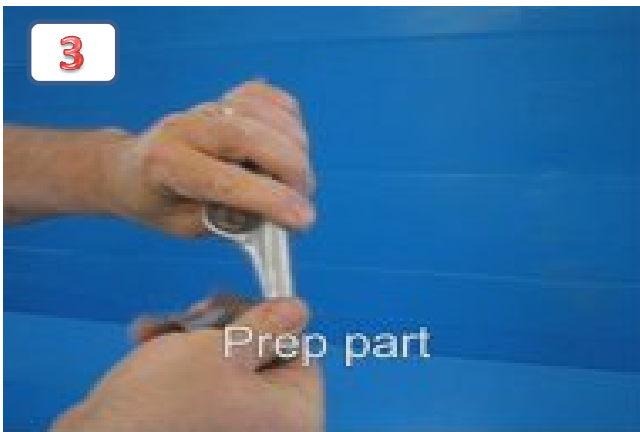
Fill the cup half way up with powder.

Make sure your remaining powder is kept in an air tight container or sealed bag.



Screw the cup on to the gun.

Note make sure the rubber seal in the mating part of the gun is seated correctly.



Thoroughly clean the part, removing any rust/corrosion.



Degrease the part making sure the all all fluid dries off prior to applying the powder.

Popular degreasing products are methylated spirits or panel wipe.



Mask off all areas that don't require powder coating.

High temperature masking tapes are available (but expensive) normal diy masking tape can be used if removed when still warm.

Note leave masking tape on when curing (heating) the part.



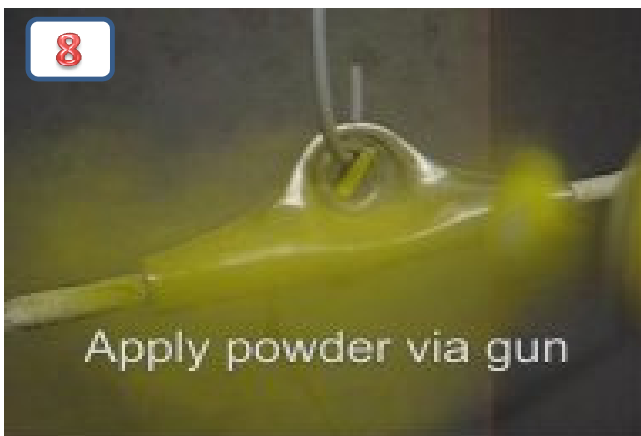
Attach the earth lead (negative) if possible to an area that does not require powder coating, however if this is not possible attach it to a convenient area to coat over later.

Note the key to the powder attracting is a good earth attached to a bare metal area of the part.



Before you apply the powder the gun needs setting up.

Turn the flow screw clockwise to close shut, then while pulling the trigger all the way in slowly open the flow screw to achieve a cloud of powder approx 8" (20cm) diameter.



To spray the part pull the trigger and depress the foot pedal at the same time.

While spraying the part try to keep the surface of the part mid way through the cloud of powder and move the gun in small circles.

When the part is covered touch the tip of the gun on the earth lead to discharge it.

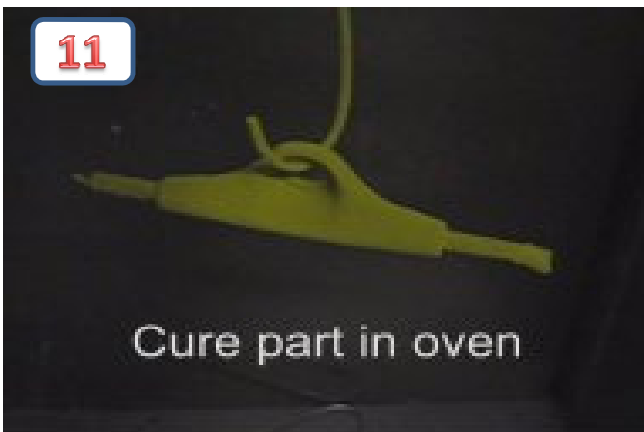


Remove the earth from the part, this may leave an uncoated area.



To cover the uncoated area where the earth clamp was simply pull the gun trigger (do not depress the pedal) and coat over the remaining area.

Because there is some charge left in the barrel of the gun it will attract naturally on the small remaining area without depressing the pedal.



Now carefully transfer the part to a heat source.

Note if some powder rubs off simply blow the area with an air gun then attach the earth and repeat step 10.

Note the powder will not shake off as it is held in suspension electrostatically!



To fully cure the part the surface needs to reach 180 deg c +/- 20 degrees.

When it reaches temperature leave it there for 10 minutes.

As a rule of thumb when the powder turns glossy it has reached 180 deg c.

Note thicker section parts due to their mass take longer to reach temperature.

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Remove part from  
oven

When the part has reached 180 deg c and been held at that temperature for 10 minutes remove it from the heat.

Note the powder will be soft while cooling down so make sure you don't let it touch anything.

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Remove masking tape.  
Let part cool down.....

Part is now complete!

While the part is cooling down, remove any masking tape, let it cool down fully then if there is any tacky residue left from the masking tape degrease with a degreasing agent like methylated spirits.

## Methods of Curing



Most types of oven that can achieve 180 deg c are suitable for curing powder coating finishes and generally the preferred choice, however there are many other methods of curing powder coating of which some are listed below:-



Infrared or patio heaters work well where the part is too large to fit in an oven, simply cure individual areas one after the other making sure you overlap the heat.

It can also be convenient to suspend parts in front of the heater .



Paint stripping guns are as simple and cost effective as it gets, simply use the gun approximately 3" from the part going back and forth until the part goes glossy, then continue for a further 10 minutes.

### **NOTE**

**Please refer to supplied manual for safety related information**