

Powder Coating Procedures

Powder Coating procedures for exterior and interior structural components.

1. Inspect product for defects or imperfections, repair as required
2. Blast product (galvanized or bare steel) to 0.75 – 1.5 mil. Profile in accordance with SSPC-SP-10 (NACE 2 – near white metal blast) for bare steel, SSPC-SP-7 (NACE 4 – Brush off blast) for galvanized steel.
3. Pre heat oven to 450° F.
4. Mask off threads, machined surfaces, and anywhere else required.
5. Blow off product with compressed air.
6. Put product in oven for pre-bake.
7. Pre-bake product at 450 F. Verify product temperature is 375 F across entire product before applying primer.
8. Remove product from oven and apply 2.5 — 3.5 mils. of Zinc rich epoxy primer as per powder manufactures specifications onto the hot product so it melts on contact.
9. Let product cool between 125° F and 175° F
10. Apply 2.5 — 3.5 mil. Topcoat as per powder manufactures specifications.
11. Put product in oven at 425° – 435° F until entire substrate has fallen into the specified curing window as per powder manufacturer.
12. Remove from oven for cool down, inspection, de-masking and unloading.
13. Wrap and bundle product.
14. All procedures and work will be done in-house in a controlled environment. This will safeguard against any out side contamination. (Flash rusting, road contaminants etc. caused by transportation and weather).