

APPLICATION TIP SHEET

Keeping powder feed hoses clear

Problem. Deposits form in the powder feed hoses, which sporadically are freed by delivery air and appear as powder puffs on parts. After curing, these powder puffs appear as faulty surface elevations.

Solutions. If the feed air pressure is too low or too high, either increase or decrease the pressure. Check the in-line filters and moisture traps to ensure the delivery air isn't moist and that oil isn't in the pressurized air.

The particle size distribution of the powder coating can be too fine. To correct this, note the appropriate particle size. You may need to optimize the virgin to reclaimed powder ratio to reduce agglomerating fines.

In addition to the powders, the equipment also needs to be inspected. If the hose is inappropriately mounted, establish an appropriate mounting without any kinks in the hose. If the feed hose has the wrong diameter, adjust it to get the right powder flow. If the feed hose is too long, shorten it. Agglomeration can also occur if the hose is made of the wrong materials. Change the hose and replace it with an appropriate type such as silicone, polyurethane or Teflon. If the venturi nozzle is worn, exchange it. PC

*Thanks to Tiger Drylac USA,
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