

# POWDER COATING TIP SHEET

## Troubleshooting poor powder wrap

**Problem.** You're having problems with powder coverage because of inadequate wrapping of the coating on the part. With one-sided gun positioning only minimal film thickness can be achieved on the opposite side.

**Solutions.** The powder flow may be too high. Optimize your system parameters and adjust your airflow. Insufficient ground may also cause poor wrapping. Use clean hooks, and test transfer resistance. It should be less than

1.0 megohm. Also check the hook diameter.

The supplemental airflow may be too high or too low. If this is the problem, adjust the air speed and powder cloud. In addition, check to make sure the gun voltage isn't too high. If so, adjust it to suit the part geometry.

Insufficient charging of the powder because of a defective gun can also cause poor wrap. Adjust high voltage, or consult with

your equipment manufacturer. You also could be positioning your parts incorrectly for application. Make sure they are hanging properly for adequate wrap. If you still have inadequate wrap, you may have a powder coating with unsuitable particle size distribution. In that case, consult with your powder coatings manufacturer. PC

*Thanks to TIGER Drylac USA, Ontario, Calif.; 909/930-9100 [www.tigerdrylac.com].*

