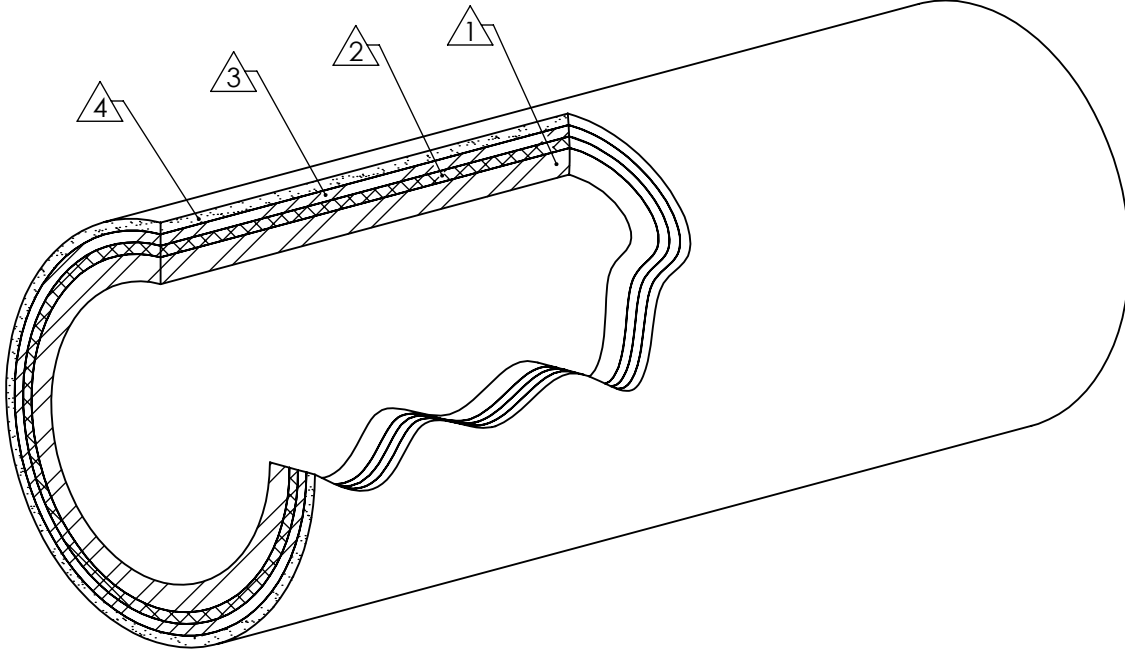


POWDER COAT SPECIFICATION STAINLESS SUBSTRATE



NOTE:

- 1 304 OR 316 SERIES STAINLESS STEEL
- 2 ZINC RICH PRIMER
- 3 POLYESTER TGIC POWDER COAT : CUSTOMER TO DETERMINE COLOR AT TIME OF ORDER.
- 4 CLEAR COAT

POWDER COATING PROCESS ON A STAINLESS STEEL SUBSTRATE SURFACE PREP

- PASSIVATE STAINLESS STEEL TO ASTM A967
- GRIT BLAST SUBSTRATE WITH NON FERROUS 80/20 GRIT CRUSHED GARNET
- OVEN BAKE ASSEMBLY TO OUTGAS THE SUBSTRATE, TIME DEPENDANT ON THICKNESS AND DIMENSION OF PRODUCT.

APPLY POWDER COAT

- APPLY ZINC RICH PRIMER (4-5 MILLS THICK) OVEN FLASH PRIMER FOR 8 TO 10 MINUTES
- APPLY COLOR POLYESTER TGIC POWDER (4-5 MILLS THICK) OVEN FLASH COLOR POWDER FOR 8 TO 10 MINUTES
- APPLY CLEAR PROTECTIVE POWDER (1 - 2 MILLS THICK) OVEN CURE POWDER COAT, TIME DEPENDANT ON THICKNESS AND DIMENSION OF PRODUCT.

SPECTRUM
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ENGINEERING DATA

PRODUCT:	POWDER COAT SPECIFICATION
PRODUCT #:	N/A
REVISION:	C
MATERIAL:	N/A