

Metal Factory Powder Coating (AE02)

Work Instructions

SCOPE: Powder Coating Procedure	Prepared on: 11.09.2017	Ref. No: METAL-PC-WI: 01:00
	Revised on:	Page No. 1 OF 2

1.0 Responsibility & Authority: The Manager of production will have overall responsibility and specific with production foreman and production coordinator.

2.0 Safety Instructions:

2.1 employees should wear their safety uniforms, shoes, hand gloves, N95 mask and safety helmet etc., as per occupational safety requirement.

3.0 Pre-Treatment and Powder Coating:

3.1 The steel parts/components are hanged in the conveyor and it goes for cleaning and iron phosphating process to remove dusts, stains, grease, oil, etc., this will produce a good abrasive surface on the components/parts to give the powder base for good holding properties.

3.2 The steel parts/components are cleaned with chemical Astoline 1892 as a degreaser and Astophos 3821 ST as iron phosphating.

3.3 The steel parts/components are the cleaned by fresh water at room temperature.

3.4 Then the parts/components are moved via conveyor through an electronically controlled oven at temperature of 100-130° C to dry the parts/components.

3.5 Then the parts/components are move into automatic powder coating chamber where it is sprayed with powder by automatic spry guns.

3.6 Manual spray guns used to spray powder as touch up and finishing to the parts/components if required.

3.7 The powder coated parts are passed through a curing oven where the parts/components are heated at temperature between 190-220°C for around 10 mins.

3.8 The parts/components are unloaded from conveyor in the unloading area.

3.9 The coated parts/components are inspected for adhesion, coating thickness and impact resistance and corrosion test on random sampling.

DEPT.: Metal Powder Coating	Prepared by: Shahabuddin	Approved by: Dhulasiraman
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S Ashworth



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