PECO-5685-SP

ETFE Powder Electrostatic Spraying Process

1. Substrate Treatment

1. Completely remove oil, stains and dust from the substrate surface.
2. Surface roughening: Perform uniform sandblasting with 36-80 mesh brown corundum sand, to achieve surface roughness Ra 2.0-3.5 μm.
3. Blow off residues from substrate surface using compressed air.
4. Mask non-spray areas with high-temperature tape or aluminum foil.

2. Apply Primer (Optional)

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1. Shake the primer thoroughly before spraying with spray gun.
2. Use W101 spray gun, nozzle caliber 1.3-2.0 mm, increase paint output.
3. If the paint is too viscous, dilute appropriately with 5% mineral water.
4. Keep gun-to-workpiece distance 10-30 cm during spraying.
5. Spray to obtain a wet, glossy primer film without sagging.

3. ETFE Powder Spraying

1. After priming, heat workpiece in oven at 300 °C for 20-50 min.
2. Apply ETFE powder onto workpiece through electrostatic spraying gun
3. Cure at 280-300 °C for 20-50 min. The cured surface shall be smooth and glossy.
4. Repeat powder spraying and curing cycles until target coating thickness is obtained。