

POWDER COATING PROCEDURE



Summary: This document is to present the process and the steps for powder coating of insulated aluminum sandwich panels with thermoplastic foam.

READY-TO-COAT TECHNOLOGY

The surface of aluminum used for the panels is **already prepared for powder coating** by:

- Alkaline degreasing,
- Sulfochromic stripping
- 0.2mil liquid epoxy primer

The color of the epoxy primer can be either transparent or brown. This **liquid primer enables powder coating of the panels without any prior chemical treatment.**

After removing the PVC protective film, **powder coat the panel's surface without prior treatment.** The product are delivered with the protective film to ensure a healthy surface without any pollution during production and transport.

The epoxy primer **ensures the adhesion of powder.** This technique has been used for many decades in the aeronautical industry. For instance, all aluminum parts of AIRBUS aircrafts follow the same process.



APPLICATION AND CURING OF POWDER

The hanging of the panels for curing is realized on the edges of the panel at a distance lower than 1/2".

The recommendations regarding the temperature of the oven and the curing time were validated with our partners and allowed coating of several million square feet of panels.

RECOMMENDED TEMPERATURE

347°F
Max : 360°F

RECOMMENDED CURING TIME*

20
MIN

*Curing time may vary depending on powder references, contact your supplier.

Note: Since the oven control system often rises to higher temperatures before stabilizing on the set point, we recommend that you set the temperature at 347°F in order not to exceed 360°F

COATED PANELS

