

Powdr₂O Application Notes:

- 1) Do not apply too heavy a coat at a time this will trap water causing bubbling of the coating, or the coating will pull apart in corner areas.
- 2) Make sure the coating is completely dry before melting the coating, bubbling will occur if it is not completely dry, drying at just below the melt and flow temp of the coating will dry the fastest. Depending on the coating material and substrate this can be from 90° f. to 150° f.
- 3) While Powdr₂O does allow you to spray into a “box”, care should be used not to build up too much material in any one area with a single coat it would be better to apply multiple thin coats instead.
- 4) Apply to all hard to reach areas first so as to not build up too much material in any one area.
 - a) To spray as one wet coat on a larger part means spray an area of the part until it has the correct coverage (even wet coat) and then leave it. Then move on to another area and not come back to “wet out” a light spot in the previous area as this may have simply dried and has the correct amount of material for this coat.
- 5) Multiple coats can be applied for various effects.
 - a) Apply each coat as a solid wet coat trying not to build up too much material in any one area. Bake at a temp that will allow the coating to melt and flow, typically this will be at least 180° (f.).
 - b) If many coats (more than 3) are to be used it is best to fully cure a coat before applying the next coat, as this will not give it too much material to out gas through or when the top coat cures it may wrinkle.
 - c) Allow the part to cool to the touch and apply the next coat.
 - d) If there are imperfections in the coating you can wet sand the coating after baking but before the next coat to smooth out the coating surface. It is not necessary to sand between coats unless you want to correct a flaw or produce some other effect, the coatings will melt together when the next bake cycle is performed, this process can be used for multiple coats to achieve the desired effects.
- 6) While the powder from Powdr₂O will stay in place on the part much better than in electrostatic powder coating it can be damaged by physical contact. Care must be taken to avoid damaging the coated part before baking.
- 7) Powdr₂O can be used to touch-up areas on a part that has been powder coated (by electrostatic or other method), but has an area that was missed or was damaged in handling.
 - a) Repair of a damaged part can be accomplished by using a small touchup brush, toothpick, paperclip, etc... dipped into the Powdr₂O and lightly applied to the damaged area, allow to dry then bake. This process can be used to fill small holes in parts as well. If the part has been fully cured a light sanding of the damaged area is recommended to give the repair a surface to hang on to.
- 8) Any one of several issues can cause spitting of the coating during application.
 - a) Coating not properly dispersed: Use a high speed dispersing blade of the correct size for your container; use stainless steel ball bearings in smaller containers and ball mill them, a high speed blender is useful for redispersing quantities greater than 6 oz.. (Do not use the blender for an extended period of time as this will cause the coating to heat up and could prevent an even flow out during baking) etc...
 - b) Coating drying in gun; can be caused by using too small of a spray opening (1mm to 1.4 mm recommended); using too fine a setting for the material (not putting out enough material in the spray); not using a wide “fan” pattern; etc...
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