



**SHADE
CARD**

APPLICATION GUIDELINES

POWDER COATING

General Information

Please refer powder coating product TDS for:

- Product chemistry
- Basic performance characteristic
- Surface preparation
- Curing schedule

Substrates & Surface Preparation

| Type of Substrates | Surface Preparation |
|--------------------|--|
| Aluminum | Chromatization |
| Steel | Iron phosphating / Low weight zinc phosphate |

Ensure guidelines as per pretreatment chemical supplier are followed.

Observe the components after pretreatment process for:

- Uniform layer
- No rust
- Free of any foreign particles
- It is completely dry

Powder Application Parameters & Booth Set Up

| Application Parameters | STD Range | Unit of Measure |
|-------------------------------------|-----------|--------------------|
| Recommended Gun Voltage | 70-90 | KV |
| Recommended Gun Air Pressure | 1-1.5 | bar |
| Recommended Fluidizing Air Pressure | 1-1.5 | kg/cm ² |
| Recommended Powder Output | 60-80 | microns |

- Ensure hopper is clean, dry and free from any contamination
- Ensure hooks, hanger or component holder are clean and clear, otherwise there can be repulsion of powder
- Ensure proper earthing otherwise there may be no proper deposition of powder on the component
- Ensure compressed air passes through moisture trap so air is clean and dry
- Ensure appropriate distance between gun and component

Powder Paint Preparation

- Remove powder bag from sealed corrugated box
- Ensure product name, shade and batch number from label
- Shake the powder bag for minimum 5 -10 minutes
- Ensure powder is free from any lump

Powder Application

- Ensure application gun parameters are in line with product requirement
- Transfer well mixed powder into clean and dry hopper
- Ensure constant fluidisation for 5-10 minutes in the hopper
- Apply powder uniformly ensuring it completely cover the component

Baking Oven Set Up

- Ensure correct curing temperature requirement as per product type
- Maintain oven temperature depending upon oven type and thickness of component to achieve desired EMT as per product requirement
- Ensure achievement of EMT by conducting TTR
- Ensure oven is free from dust or any contaminant

Curing of Coated Component

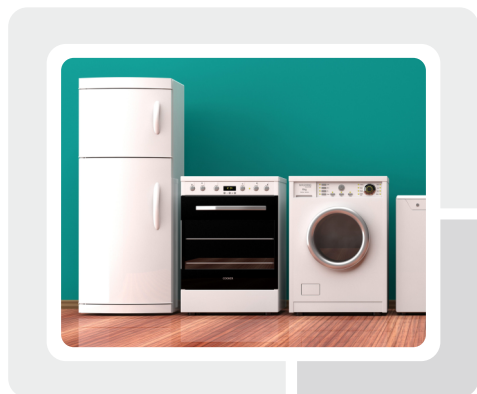
- Insert coated component into pre heated oven
- Ensure desired EMT is maintained for specified curing time
- Allow component to cool after removal from oven

Observation of Coated Component

- Observe the component after it has cooled
- Ensure shade, finish and gloss is as per the product requirement
- Check adhesion

NOTE

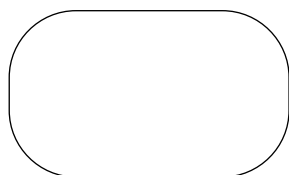
- 1) Ensure proper PPE and all safety guidelines are followed as per MSDS
- 2) Above is for guideline purpose, actual SOP is to be derived after successful trial



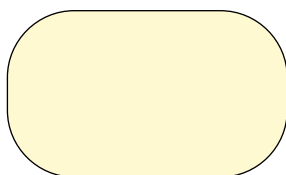
**Download a digital copy of our shade card.
Visit the last page to scan.**

** The shades shown in the document are indicative.
For physical shade card requirement email us at marketing@grandpolycoats.com*

24 GLOSSY FINISH



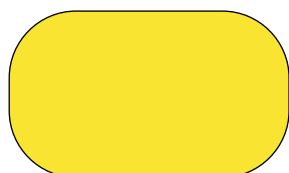
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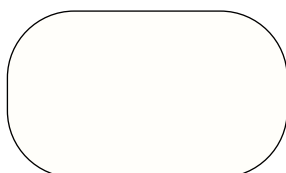
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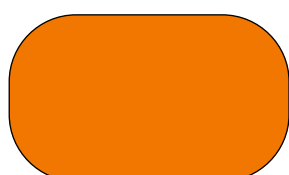
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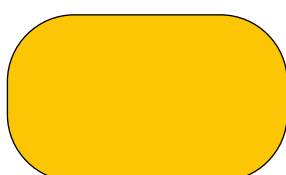
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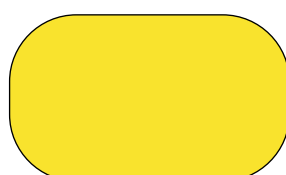
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RAL 2000 (1032000)



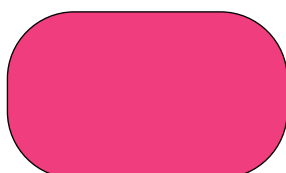
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LEMON YELLOW (0960421)



IS 538 P O RED (0610538)



MAJENTHA (1260011)



ORANGE (1060329)



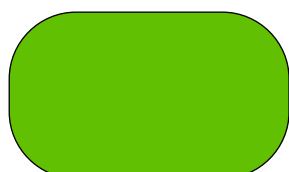
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RAL 3000 (0633000)



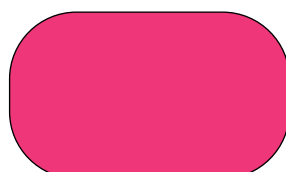
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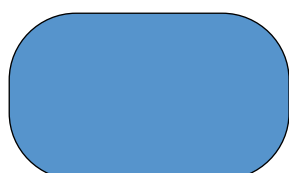
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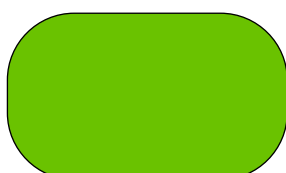
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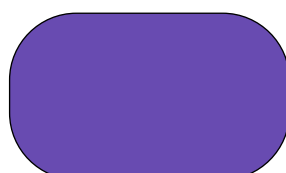
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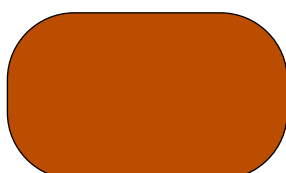
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WILD LILAC (0760001)



COFFEE BROWN (1360313)



GOLDEN BROWN (1360311)



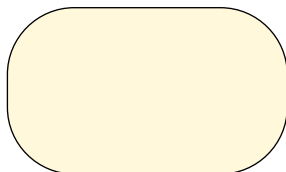
SUPER BLACK (0240001)

The shades represented in this card are for reference purpose only

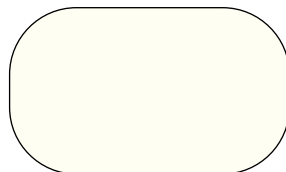
24 SEMI GLOSSY



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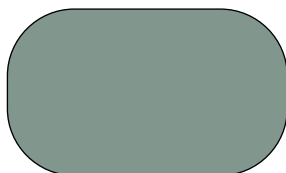
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RAL 9016 (0139016)



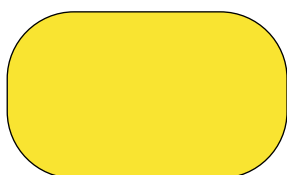
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IS 631 LT GREY (0510631)



GREY (0560557)



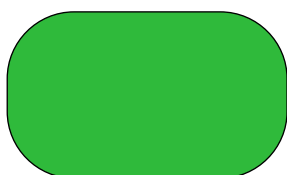
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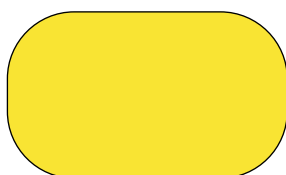
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RAL 1028 (0931028)



ST GREEN (0460417)



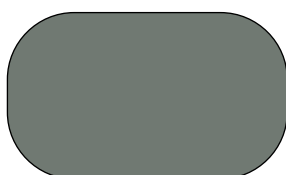
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RAL 3020 (0633020)



RAL 5017 (0335017)



RAL 7042 (0560556)



BLUE (0360487)



NAVY BLUE (0360397)



RAL 5010 (0360407)



RAL 7024 (0537024)



AZURE BLUE (0360439)



RAL 7016 (0560548)



MUNSHELL BLUE (0360472)



BCB BROWN (1360315)

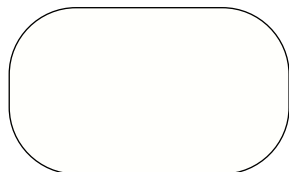


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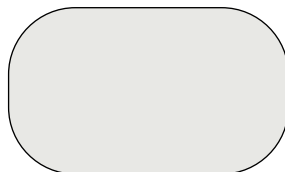
12 MATT



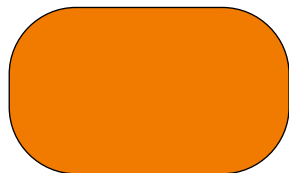
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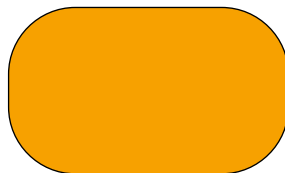
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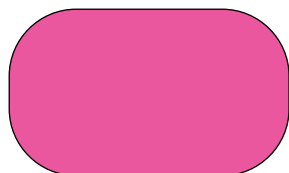
ORANGE (1060331)



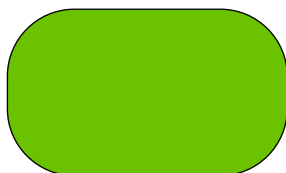
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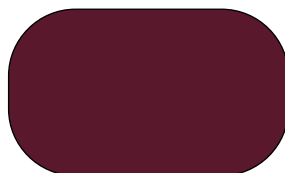
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PINK (1260013)



RAL 6018 (0436018)



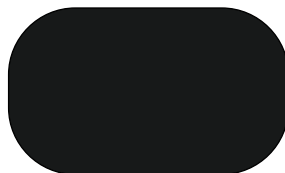
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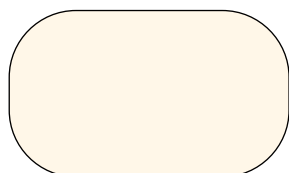


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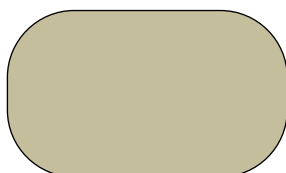


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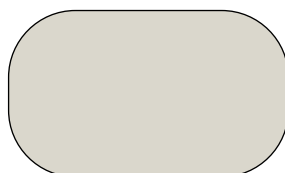
12 TEXTURE



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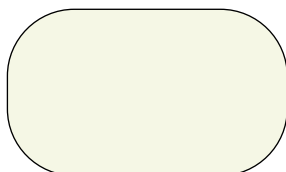
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MIDAS GREY (0560470)



GREY (0560454)



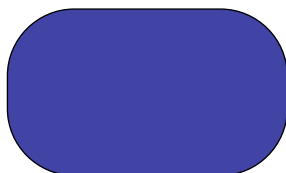
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MUN GREY (0560449)



RAL 7040 (0537040)



VIP BLUE (0360408)



RAL 7006 (0537006)



RAL 7037 (0537037)



PINK (1260005)

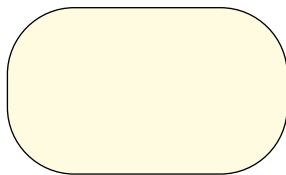


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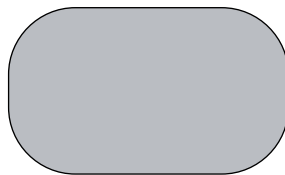
24 STRUCTURE



BROKEN WHITE (0160453)



IVORY (0960401)



RAL 7035 (0537035)



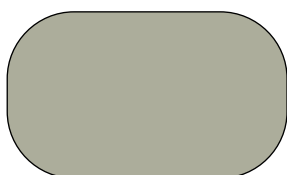
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IS 697 LA GREY (0510697)



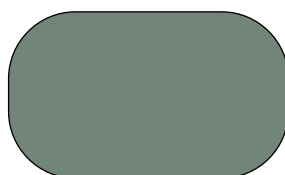
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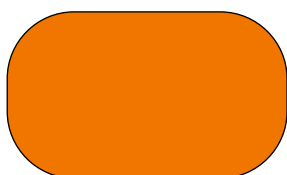
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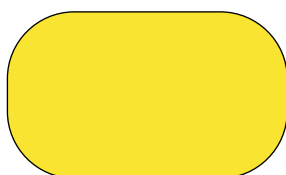
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IS 631 LT GREY (0510631)



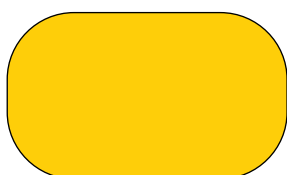
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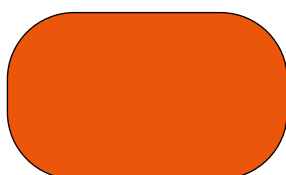
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RAL 6011 (0436011)



RAL 1003 (0931003)



RAL 2009 (1032009)



KANGAROO BLUE (0360498)



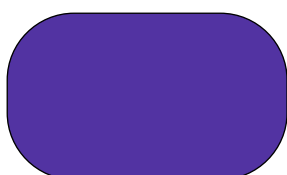
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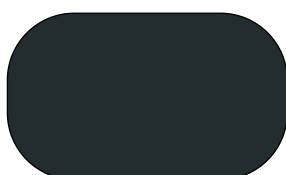
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LP BLUE (0360399)



LILAC (0760013)



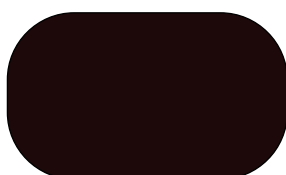
RAL 7016 (0537016)



SBI BLUE (0360499)



IS 632 DA GREY (0510632)



IS 541 MAROON (0610541)



BLACK (0240001)



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