

## **THE DIFFERENCE BETWEEN POWDERCOAT AND WET SPRAY**

Powder coating is done with a specialist spray gun that electrostatically charges the dry powder particles which then makes it stick to the surface being coated. Once coated, the part is heat treated in a curing oven and the particle's chemical reaction in the heat creates a high density thermal bond within the compound forming a hard "shell" over the item being coated. The temperature in the curing oven is on average between 200 and 230°C.

Wet Spray is a technique where by using a spray gun the liquid paint is atomised in a flow of compressed air onto the product surface and has to be allowed to dry like any other paint. The end finish is not as hard as powdercoat and can be more easily damaged.

## **SPECIAL COLOURS**

We are a small manufacturer, not a specialist powdercoat or painting company. While we are more than happy to try and help our customers wherever possible, there are some limitations. We have a range of standard powder coat colours which have been developed in line with our customer's requirements. The cost of using these colours is included in any pricing you have received either in the form of a price list, or a written quote.

Our Standard Powdercoat Colour Range:

<http://www.elettra.com.au/lighting/STANDARD%20COLOUR%20RANGE.pdf>

If your project requires a different colour to those on our standard list, you can choose from the powdercoat colours offered by Dulux or Interpon on their websites (not their physical colour charts as these are often out of date). The cost of obtaining these powders will be passed directly to our customer and will be included on your invoice. Dependant on the colour choice, the costs vary from \$300 to over \$1000 per 20kg box. This does not include powder coats marked as "made to order" or "custom" on their sites as these often have minimum order quantities far in excess of 1 box..

Other Powdercoat Colours Available From Dulux or Interpon:  
(Please note additional costs above will apply)

<http://duluxpowders.com.au/find-an-applicator/colour/>

<http://www.interpon.com.au/our-coatings/powder-finder/>

If the special colour you require cannot be found in powdercoat, we can on occasion wet spray the item. However, there are a few things to be noted:

- We do not have the equipment to colour match, the colour must be specified by the customer
- We will only wet spray one colour per item i.e. the interior and exterior of reflectors all the one colour. For dual colours you must chose powder coats
- The paint you specify must be an enamel paint, able to be used in a spray gun, and must be a satin or gloss finish – matt finishes not available
- You must specify the paint using Manufacturer name, colour and code
- The paint must be available in Australia, and if not a major manufacturer, the details of where we can purchase it supplied
- The item will be left to air dry and will require more than one coat so extra time must be allowed. We will not attempt to hurry this part of the process for fear of burning or bubbling the paint and hence compromising the final product..

As with the special powdercoat, any additional costs involved in obtaining the special wet paint colour for you will be added to your invoice, along with a labour charge commensurate with the additional work required to coat your items.

## **COATING CUSTOMER SUPPLIED ITEMS**

While we take care when coating supplied items, we cannot always guarantee the finish. It is not always clear what the item may have already been coated with, what material it is manufactured from, or any flaws already in the surface of the item. When coating supplied items, we prefer that the customer fully disassembles the item and only sends us the components that need coating.

If we are required to disassemble the item for you, or remove an existing coating, there will be a labour charge for the time and consumables involved in doing so. Please be aware that lampholders, wiring, plastic or rubber parts cannot go through the powdercoat curing oven due to the extreme temperatures, nor can they go through the chemical process to remove any existing coatings. In addition, if parts have been glued in place, we will not break the glue to disassemble them and we will not open any sealed junction boxes or driver casings. If these parts cannot be removed, a wet spray finish is the only option.