TECHNICAL TOOLS

Laboratory Tests and Technical Documentation

MRK-012-0159

DOUBLE LAYER

POWDER COATING

Powders A + Powders B

Information:

DOUBLE LAYER POWDER COATING

Powders A + Powders B

1. TECHNICAL INFORMATION

- **PRODUCT FEATURES**

The incredible colours of this new GiColor series, seemingly obtained with a single coat, are the result of a double layer powder coating process, which means applying a second layer of powder, different from the first one. Customers can choose any of our GiColor powders to create breath-taking effects.

FIRST LAYER > GiColor powder (*Powder A*).

SECOND LAYER > GiColor powder (*Powder B*).

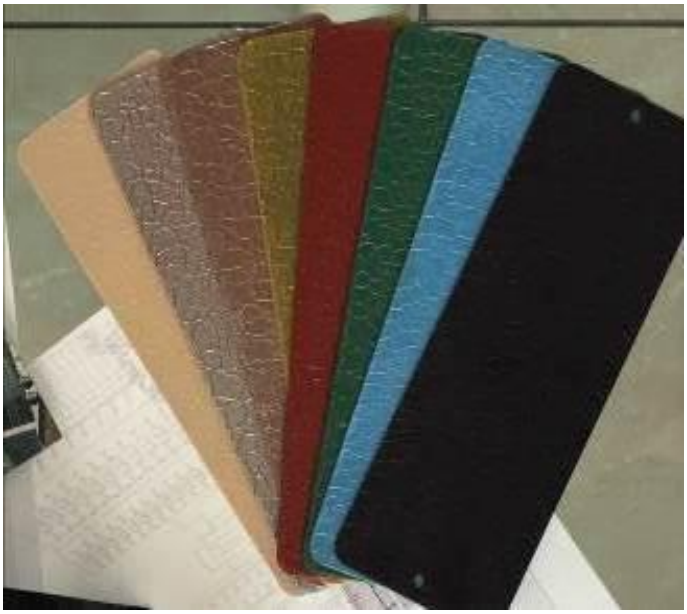

Figure 1: Samples with double-layer powder coating

- **APPLICATION METHOD AND CURING CYCLE**

FIRST LAYER: Powder A

- The application method, curing cycle, chemical nature and resistance class are listed on the technical data sheet of the chosen coating powder.

SECOND LAYER: Powder B

- The application method, curing cycle, chemical nature and resistance class are listed on the technical data sheet of the chosen coating powder.

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2. POWDER COATING

1. The object is placed inside the coating booth, where the first layer of powder is sprayed. The powder sticks to the surface thanks to the electrostatic principle.

Figure 2: Application of the first layer of powder

2. Once coated, the object is put inside the oven, where the powder undergoes the cross-linking process. Temperature and time specifications are indicated on the technical data sheet of the chosen powder.

Figure 3: Sample inside the oven for the cross-linking process.

DOUBLE CYCLE POWDER COATING

Powders A + Powders B

3. Once completed the cross-linking process, the object is removed from the oven and left to cool. It is then moved again inside the coating booth where the second layer of powder is applied.

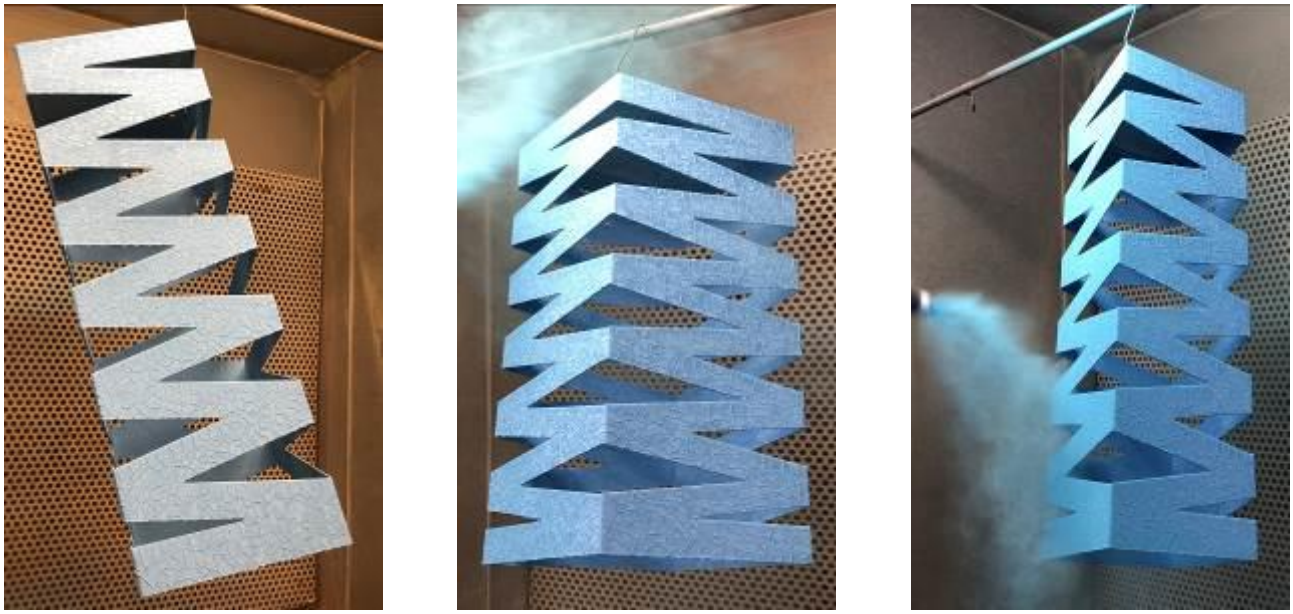

Figure 4: Application of the second layer of powder

4. Once coated, the object is placed inside the oven, where it undergoes the cross-linking process for the second time. Temperature and time requirements are indicated on the tecnical data sheet of the powder used.

Figure 5: Object inside the oven for the cross-linking process.

DOUBLE CYCLE POWDER COATING

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Figure 6: Double-coated finished product

3. POSSIBLE USAGE

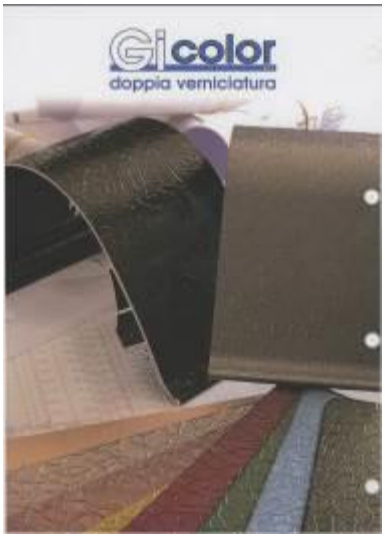
The double layer powder coating process gives incredible decorative effects through the combination of two completely different GiColor powders: we can combine the extraordinary surface effect of powders such as *Saltlake-005* with that of, for instance, metallized powders like *Artico-02*, creating a final product that sums up the effects of both powders.

Figure 7: Example of an object double coated with Saltlake-005 + Artico-02

N.B. – To enhance the effect of the first layer, it is better to use powders with low hiding power as second coat.

Dedicated Marketing Presentation:

- MRK-005-0970



GICOLOR SRL

Sede legale: Viale del Lavoro, 5 - 37040 Arcole (VR)

Sede operativa: Via Tagliamento, 4 - 36056 Belvedere di Tezze sul Brenta (VI)

Tel. +39 0424 560208 - Fax +39 0424 564601