

Grounding

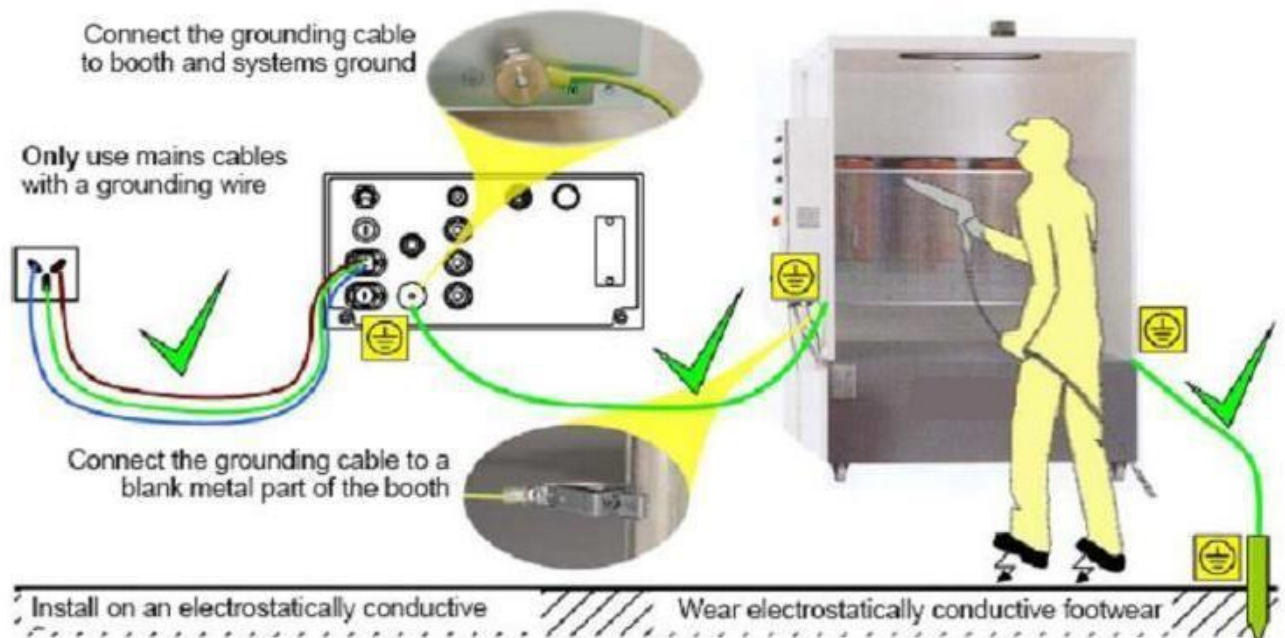
Get the most out of your powder coating gun by making sure you have a proper grounding. Most problems in powder coating can be related back to poor grounding.

- Your guns ground wire should always be connected to earth ground.
- Do not connect the guns ground directly to the part you are coating.
- The part you are coating should have a grounding wire that connects to earth ground.
- The grounding wire should always be touching clean bare metal on the part.
- Check grounding again on second coats when bare metal might be hard to find.
- Use clean hooks if you are using hooks as a grounding source.
- Use a multimeter to confirm your grounding by doing a continuity test. Touch one wire to earth ground and the other wire to the part your coating. the Meter will tell if your parts is properly grounded.

Conditions for good grounding as well as coating are:

- Good grounding of the workpiece to be coated and of conveyors and hangers.
- Ground the powder spray booth, conveyors and hangers with the installation of a minimum 16 mm² copper conductor to the system ground, without loops and knots and as short as possible.
- Regular cleaning of hangers from powder residues.
- The grounding resistance of the workpiece 1 M Ω (Mega Ohm) may not be exceeded

Ground the powder coating system as instructed:



Other key points

- Spray second coats with a lower KV than first coats.

-Try to Keep your distance between 6" to 8".

-Spraying your part with a low powder cloud and High KV will create a charge on the part, this will result in the part repelling the powder. You will need to dissipate that charge before trying to apply the powder again. You can do this by blowing the old powder off the part and placing it in the oven for 5-10 mins.

-Never wear gloves unless they are conductive gloves. Powder coating guns have metal handles or conductive plastic handles that help ground the operator to the gun.



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