

COST CALCULATION OF POWDERS

Formula: = Price per M2

$$\frac{\mathbf{A \times B \times C}}{\mathbf{1000}}$$

1000

A = Coating Thickness in Microns

B=Specific Gravity in Grams per M3

C= Price per kilo

At 100% utilization Polyester Powder coating will usually cover approximately 13 M2 per kg @ 60 microns film thickness but will vary with density, uniformity and colour.

A 60 micron coating of White Polyester powder with a Specific Gravity of 1.6 (SG) purchased @ \$8.00 per kilo will show a material cost of 0.77 cents per M2.

Note.

Powders are generally applied within a thickness range of 50-80 microns cured film build. Low film build is appropriate for Dark or High Opacity colours whilst some organic pigmented colours (brights) will require a higher film build to develop full cover and or coverage. Textured, low gloss and special effect finishes generally require higher film builds. Most colours however give satisfactory results at 50-60 microns.

COVERAGE OF POWDERS

Coverage is related to the Specific Gravity (density) of the powder

Calculation can be made using the following formula:

Area (M2 per kilo) =

$$\frac{1000}{\text{SG} \times \text{Coating Thickness (microns)}}$$

Allowance must be made for application losses. Most colored powders have an SG of 1.5-1.6.

Pretreatment:

Pretreatment of the metal surface is mandatory. Reference should be made to our quality control data information and /or your pretreatment supplier.

Recoating:

Polyesters will generally adhere satisfactorily to previously coated work pieces whereas a lightly abraded and solvent wiped powder surface prior to recoating will give superior adhesion.

Recoat ability will depend on the type of powder being applied, the initial coats film thickness and voltage used in the second application. Generally a lower voltage will give better results.

Note:

Electrostatic deposition over previously coated surfaces is significantly reduced, especially if the first coat is of a high film build.