

Alsa Powder Coating FAQ



After curing the coating is chipping off the substrate.

A: Impact resistance will be poor if powder is not cured properly.

After curing the color looks different than the control panel.

A: If the color looks yellow, the oven temperature is too high or the dwell time is too long.

Check the oven exhaust fans to see if they are working properly.

Also check coating thickness to make sure you have applied the recommended thickness.

The coating seems to have an orange peel finish.

A: Most times this occurs when powder is applied too lightly or coating has been brought to temp too slow or too fast. The powder was applied too heavily. Try lowering voltage or spray time.

The coating has very little impact resistance.

A: The coating is under cured, had a poor pre-treatment, or the film thickness is too heavy.

Powder is contaminated.

A: Primary filter media is binding, final filters could be clogged, moisture or oil in the compressed air lines, or drafts causing dust or other powder to float through the shop.

How long will a powder coated part last?

A: There is no guarantee of life expectancy. Too many factors beyond our control dictate the life of coated parts. We warranty workmanship of powder only

What do I use as a base coat when a color swatch says-topcoat over brushed aluminum?

A: Our topcoats, including candies and transparent metallics, are sprayed over brushed aluminum. To achieve a likeness, a basecoat of super chrome or silver metallic will have to be used.

Why do we recommend expedited shipping during hot weather?

A: Some powders will start cross linking when temperatures exceed 100F for extended periods (I.E over weekends and holidays). To avoid lumpy powder, avoid weekend and holiday shipping, you are responsible for correct shipping.

Why do we recommend top coats over silver metallics and veins or leatherettes with silver?

A: Silver, if exposed to weather will oxidize. Super chrome also needs a topcoat.

Why is it dripping or sagging?

A: Because they shot hot.

How to get rid of orange peel?

A: Double coat base color.

What do I do if a part is cured and needs to recoated?

A: Scotchbright blow off and discharge. By placing back in the oven prior to recoating. Blowing air on the part to get any remaining media can create a charge on the part. Reducing attraction of the powder.

How long do I cure a Harley frame?

A: When metal reaches temperature part should be cured for 15 minutes. This will result in a total cure time of approximately 45 minutes at 400F.

Why am I getting fish eyes or circles in coating?

A: K.V. fry base coat 45 K.V. top coat drop down to 30 K.V. keep gun away from part on top coat. When shooting the base coat, the K.V. should be 45. On the top coat, drop to 45 K.V., this will vary based on powder gun system. Keep the gun further away from the part.

How do I get a transparent Top Coat even?

A: If you get a substrate that is hard to shoot, double coat the transparent by first putting down a light coat, and then putting down a second medium to heavy coat.

What can be powder coated?

A: Any metal that is able to withstand the curing temperatures involved with the powder coating process.

Generally 350 - 425 degrees

What are the advantages of powder coating?

A: Powder coated surfaces are more resistant to chipping, scratching, fading, and wearing than other finishes. Color selection is virtually unlimited with high and low gloss, metallic, textures, and clear finishes available. Colors stay bright and vibrant longer. Texture selections range from smooth surfaces to a wrinkled or matte finish, and rough textures designed for hiding surface imperfections.

How much does powder cost?

A: Prices vary according to item quantity and the desired color and finish. Considering it's advantages, powder coating is an excellent value when compared to conventional paint finishes.

What is powder coating?

A: Powder coating is a combination of pigment and resin that is ground into a powder form and is sprayed on an item to be coated. The powder is charged with high voltage which is then attracted to the electrically grounded item to be coated. The item is heated in a curing oven until the powder flows into a liquid form. After curing for a specific amount of time, the part is removed to cool, leaving a high quality, durable finish.