



Overview

The facilities at Corby comprise some of the most modern, clean and flexible powder coating equipment in the UK. We have a policy of continual improvement in both plant and people and have completely renewed our key facilities on a 10-year rolling replacement programme.

This ensures that plant and processes are in line with current industry best practice.

Powder application

Both lines are manufactured by GEMA and have the same features and operation which enables transfer of capacity without any loss of function and efficiency. Each booth is plastic for easy clean-down with 2 pairs of opposing reciprocating spray guns. There is a manual touch-in gun at either end of the booth.

At the entrance to the booth is a "magic eye" curtain which reads the profile of the work and automatically adjusts the stroke and distance of the guns from the work.

Clean-down is semi-automatic to reduce down time and increase powder recovery.

Powder is applied from the powder station, through the guns and recirculated through a powder classifying filter and back to the powder station – this closed loop system ensures optimum powder usage efficiency, maintains a consistent particle size distribution (PSD) and reduces contamination.

Curing

Each powder line has 2 gas-fired recirculating ovens. One oven is a drying / degassing and the second is the main curing oven although the layout is such that capacity can be expanded by bringing both ovens into the curing sequence.

All ovens are monitored and their temperature profile recorded on a regular basis.

The curing times and temperatures are set according to the powder manufacturers recommendations and the profile of the material. Cooling down and oven shut-off is automatic to avoid over curing.

Key Points

- 2 independent powder coating lines
- Chrome-free pre-treatment
- Power and free overhead conveyor
- 4 gas-fired recirculating curing ovens
- Paint stripping facility
- 2 x Fork Lift Trucks, 3500kg capacity
- 1 x 18.5t curtain side lorry
- 24 hour CCTV

Pre-treatment

Commissioned in January 2017 the pre-treatment system consists of 11 chemically resistant plastic tanks into which the material is immersed whilst in stainless steel baskets or open cantilever racks. The dipping sequence, immersion time and drain times are pre-set and processed by a CNC controlled overhead transporter system.

Each tank is 6700mm long with an effective length of 6500mm and 700mm maximum width and a working depth of 1600mm, an effective height of 2200mm.

The water rinses are a combination of town water and de-mineralised water and all de-mineralised water is made on-site.

The pre-treatment system is monitored and adjusted daily for chemical and water quality.

Refer to "Pre-treatment" data sheet for more detailed information

Final Inspection and packaging

Final Inspection

Each coating line has its dedicated final inspection area which is illuminated by daylight overhead LED's that exceeds 400 lux.

All work is inspected in accordance with BS EN 12206-1 or as per agreed customer requirements.

Packaging

The standard process is to protect work with bubble wrap before palletising and over-wrapping in heat shrink plastic. Identification labels are on every package.

Standard packaging materials: corrugated card, bubble film, card or foam wrapped wood for heavy items, foam tube and "C" section, acid-free tissue paper, pallet wrap, heat shrink plastic and Powdertech branded packing tape.

Customer specific packaging can be accommodated.

Physical capacity

Length: 6500mm. Height: 2200mm. Depth: 700mm.

For items that are chemically pre-treated, aluminium or galvanized steel.

Length: 6700mm. Height: 2200mm. Depth: 1200mm.

For items that have shot blast pre-treatment or no pre-treatment.

Maximum weight is 1000kg uniformly distributed over 6000mm – 150kg/m

Please note:

Whilst every care has been taken to provide accurate information this document is for guidance only and should be read in conjunction with other data sheets where applicable.

This document forms no part of a contract. Any warranty is subject to individual review.