

AIR-ASSISTED AIRLESS																					
PART	CATEGORY	COAT	TIP SIZE	AIR PRESSURE (psi)			FLUID PRESSURE (psi)			MIL THICKNESS (mil)			SPEED (ft/s)			DISTANCE TO PART (in)			TRAVEL ANGLE (-)		
				Setting	Tolerance (±)		Setting	Tolerance (±)		Setting	Tolerance (±)		Setting	Tolerance (±)		Setting	Tolerance (±)		Setting	Tolerance (±)	
					Easy	Hard		Easy	Hard		Easy	Hard		Easy	Hard		Easy	Hard		Easy	Hard
ACQPA Panel	Testing Panels	1 - Color	415	9	4	2	1300	250	150	4.2	2.1	1.575	1.5	1	0.85	12	3	1.9	90	27.5	25
		2 - Clear	415	9	4	2	1300	250	150	4.6	2.3	1.725	1.5	1	0.85	12	3	1.9	90	27.5	25
ASTM Panel	Testing Panels	1 - Color	415	9	4	2	1300	250	150	4.2	2.1	1.575	1.5	1	0.75	12	3	1.9	90	35	22.5
		2 - Clear	415	9	4	2	1300	250	150	4.6	2.3	1.725	1.5	1	0.75	12	3	1.9	90	35	22.5
Bridge Section	Construction	1 - Color	415	9	4	2	1300	250	150	4.2	2.1	1.575	1.5	1	0.85	12	3	1.75	90	35	22.5
		2 - Clear	415	9	4	2	1300	250	150	4.6	2.3	1.725	1.5	1	0.85	12	3	1.75	90	35	22.5
Car Door	Transportation	1 - Color	313	9	4	2	900	250	150	4.2	2.1	1.575	1.5	1	0.5	12	3	1.5	90	25	17.5
		2 - Clear	313	9	4	2	900	250	150	4.6	2.3	1.725	1.5	1	0.5	12	3	1.5	90	25	17.5
Car Fender	Transportation	1 - Color	313	9	4	2	900	250	150	4.2	2.1	1.575	1.5	1	0.5	12	3	2.1	90	30	22.5
		2 - Clear	313	9	4	2	900	250	150	4.6	2.3	1.725	1.5	1	0.5	12	3	2.1	90	30	22.5
Car Hood	Transportation	1 - Color	415	9	4	2	1300	250	150	4.2	2.1	1.575	1.5	1	0.5	12	3	1.5	90	25	17.5
		2 - Clear	415	9	4	2	1300	250	150	4.6	2.3	1.725	1.5	1	0.5	12	3	1.5	90	25	17.5
Engine Cowling	Aerospace	1 - Color	415	9	4	2	1300	250	150	4.2	2.1	1.575	1.5	1	0.5	12	3	2	90	25	17.5
		2 - Clear	415	9	4	2	1300	250	150	4.6	2.3	1.725	1.5	1	0.5	12	3	2	90	25	17.5
Flat Panel	Practice Panels	1 - Color	517	9	4	2	1800	250	150	4.2	2.1	1.575	1.5	1	0.5	12	3	1.5	90	25	17.5
		2 - Clear	517	9	4	2	1800	250	150	4.6	2.3	1.725	1.5	1	0.5	12	3	1.5	90	25	17.5
Gas Tank	Transportation	1 - Color	313	9	4	2	900	250	150	4.2	2.6	2.1	1.5	1	0.75	12	3	2.1	90	50	37.5
		2 - Clear	313	9	4	2	900	250	150	4.6	2.8	2.3	1.5	1	0.75	12	3	2.1	90	50	37.5
Half Barrel	Heavy	1 - Color	415	9	4	2	1300	250	150	4.2	2.1	1.575	1.5	1	0.85	12	3	1.5	90	35	17.5
		2 - Clear	415	9	4	2	1300	250	150	4.6	2.3	1.725	1.5	1	0.85	12	3	1.5	90	35	17.5
H-Beam	Construction	1 - Color	415	9	4	2	1300	250	150	4.2	2.1	1.575	1.5	1	0.5	12	3	1.5	90	35	17.5
		2 - Clear	415	9	4	2	1300	250	150	4.6	2.3	1.725	1.5	1	0.5	12	3	1.5	90	35	17.5
I-Beam	Construction	1 - Color	415	9	4	2	1300	250	150	4.2	2.1	1.575	1.5	1	0.5	12	3	1.5	90	35	17.5
		2 - Clear	415	9	4	2	1300	250	150	4.6	2.3	1.725	1.5	1	0.5	12	3	1.5	90	35	17.5
Large Set Panel	Testing Panels	1 - Color	517	9	4	2	1800	250	150	4.2	2.1	1.575	1.5	1	0.5	12	3	1.5	90	25	17.5
		2 - Clear	517	9	4	2	1800	250	150	4.6	2.3	1.725	1.5	1	0.5	12	3	1.5	90	25	17.5
Pylon Exterior	Aerospace	1 - Color	415	9	4	2	1300	250	150	4.2	2.1	1.575	1.5	1	0.5	12	3	2	90	30	25
		2 - Clear	415	9	4	2	1300	250	150	4.6	2.3	1.725	1.5	1	0.5	12	3	2	90	30	25
Pylon Interior	Aerospace	1 - Color	415	9	4	2	1300	250	150	4.2	2.1	1.575	1.5	1	0.5	12	3	2	90	30	25
		2 - Clear	415	9	4	2	1300	250	150	4.6	2.3	1.725	1.5	1	0.5	12	3	2	90	30	25
Strut Panel	Aerospace	1 - Color	415	9	4	2	1300	250	150	4.2	2.1	1.575	1.5	1	0.5	12	3	2	90	25	17.5
		2 - Clear	415	9	4	2	1300	250	150	4.6	2.3	1.725	1.5	1	0.5	12	3	2	90	25	17.5
Vertical Panel	Practice Panels	1 - Color	517	9	4	2	1800	250	150	4.2	2.1	1.575	1.5	1	0.5	12	3	1.5	90	25	17.5
		2 - Clear	517	9	4	2	1800	250	150	4.6	2.3	1.725	1.5	1	0.5	12	3	1.5	90	25	17.5
Vertical Piece	Practice Panels	1 - Color	517	9	4	2	1800	250	150	4.2	2.1	1.575	1.5	1	0.5	12	3	1.5	90	25	17.5
		2 - Clear	517	9	4	2	1800	250	150	4.6	2.3	1.725	1.5	1	0.5	12	3	1.5	90	25	17.5
Wavy Panel	Practice Panels	1 - Color	313	9	4	2	900	250	150	4.2	2.1	1.575	1.5	1	0.5	12	3	1.5	90	25	17.5
		2 - Clear	313	9	4	2	900	250	150	4.6	2.3	1.725	1.5	1	0.5	12	3	1.5	90	25	17.5
Wing Panel	Aerospace	1 - Color	517	9	4	2	1800	250	150	4.2	2.1	1.575	1.5	1	0.5	12	3	2	90	25	17.5
		2 - Clear	517	9	4	2	1800	250	150	4.6	2.3	1.725	1.5	1	0.5	12	3	2	90	25	17.5

AIR-ASSISTED AIRLESS CONVEYOR																					
PART	CATEGORY	COAT	TIP SIZE	AIR PRESSURE (psi)			FLUID PRESSURE (psi)			MIL THICKNESS (mil)			SPEED (ft/s)			DISTANCE TO PART (in)			TRAVEL ANGLE (-)		
				Setting	Tolerance (±)		Setting	Tolerance (±)		Setting	Tolerance (±)		Setting	Tolerance (±)		Setting	Tolerance (±)		Setting	Tolerance (±)	
					Easy	Hard		Easy	Hard		Easy	Hard		Easy	Hard		Easy	Hard		Easy	Hard
Car Door	Transportation	1 - Color	313	9	4	2	900	250	150	4.2	2.1	1.575	1.5	1	0.5	12	3	1.5	90	25	17.5
Car Fender	Transportation	1 - Color	313	9	4	2	900	250	150	4.2	2.1	1.575	1.5	1	0.5	12	3	1.5	90	30	22.5
Car Hood	Transportation	1 - Color	415	9	4	2	1300	250	150	4.2	2.3	1.725	1.5	1	0.5	12	3	1.5	90	25	17.5
Flat Panel	Practice Panels	1 - Color	517	9	4	2	1800	250	150	4.2	2.3	1.725	1.5	1	0.5	12	3	1.5	90	25	17.5
Wavy Panel	Practice Panels	1 - Color	313	9	4	2	900	250	150	4.2	2.1	1.575	1.5	1	0.5	12	3	1.5	90	25	17.5

AIRLESS																					
PART	CATEGORY	COAT	TIP SIZE	AIR PRESSURE (psi)			FLUID PRESSURE (psi)			MIL THICKNESS (mil)			SPEED (ft/s)			DISTANCE TO PART (in)			TRAVEL ANGLE (-)		
				Setting	Tolerance (±)		Setting	Tolerance (±)		Setting	Tolerance (±)		Setting	Tolerance (±)		Setting	Tolerance (±)		Setting	Tolerance (±)	
					Easy	Hard		Easy	Hard		Easy	Hard		Easy	Hard		Easy	Hard		Easy	Hard
ACQPA Panel	Testing Panels	1 - Color	517	N/A	N/A	N/A	2100	250	150	5	2.5	1.875	1.5	1	0.85	12	3	1.9	90	35	25
		2 - Clear	517	N/A	N/A	N/A	2100	250	150	5.4	2.7	2.025	1.5	1	0.85	12	3	1.9	90	35	25
ASTM Panel	Testing Panels	1 - Color	517	N/A	N/A	N/A	2100	250	150	5	2.5	1.875	1.5	1	0.75	12	3	1.9	90	35	22.5
		2 - Clear	517	N/A	N/A	N/A	2100	250	150	5.4	2.7	2.025	1.5	1	0.75	12	3	1.9	90	35	24.5
Bridge Section	Construction	1 - Color	415	N/A	N/A	N/A	1500	250	150	5	2.5	1.875	1.5	1	0.75	12	3	1.9	90	35	25
		2 - Clear	415	N/A	N/A	N/A	1500	250	150	5.4	2.7	2.025	1.5	1	0.75	12	3	1.9	90	35	25
Engine Cowling	Aerospace	1 - Color	415	N/A	N/A	N/A	1500	250	150	5	2.5	1.875	1.5	1	0.5	12	3	2	90	25	17.5
		2 - Clear	415	N/A	N/A	N/A	1500	250	150	5.4	2.7	2.025	1.5	1	0.5	12	3	2	90	25	17.5
Flat Panel	Practice Panels	1 - Color	517	N/A	N/A	N/A	2100	250	150	5	2.5	1.875	1.5	1	0.5	12	3	1.5	90	25	17.5
		2 - Clear	517	N/A	N/A	N/A	2100	250	150	5.4	2.7	2.025	1.5	1	0.5	12	3	1.5	90	25	17.5
Half Barrel	Heavy	1 - Color	415	N/A	N/A	N/A	1500	250	150	5	2.5	1.875	1.5	1	0.85	12	3	2	90	35	20.5
		2 - Clear	415	N/A	N/A	N/A	1500	250	150	5.4	2.7	2.025	1.5	1	0.85	12	3	2	90	35	20.5
H-Beam	Construction	1 - Color	415	N/A	N/A	N/A	1500	250	150	5	2.5	1.875	1.5	1	0.6	12	3	2.1	90	35	18.5
		2 - Clear	415	N/A	N/A	N/A	1500	250	150	5.4	2.7	2.025	1.5	1	0.6	12	3	2.1	90	35	18.5
I-Beam	Construction	1 - Color	415	N/A	N/A	N/A	1500	250	150	5	2.5	1.875	1.5	1	0.6	12	3	2.1	90	35	18.5
		2 - Clear	415	N/A	N/A	N/A	1500	250	150	5.4	2.7	2.025	1.5	1	0.6	12	3	2.1	90	35	18.5
Large Set Panel	Testing Panels	1 - Color	517	N/A	N/A	N/A	2100	250	150	5	2.5	1.875	1.5	1	0.5	12	3	1.5	90	25	17.5
		2 - Clear	517	N/A	N/A	N/A	2100	250	150	5.4	2.7	2.025	1.5	1	0.5	12	3	1.5	90	25	17.5
Pylon Exterior	Aerospace	1 - Color	415	N/A	N/A	N/A	1500	250	150	5	2.5	1.875	1.5	1	0.5	12	3	2	90	30	25
		2 - Clear	415	N/A	N/A	N/A	1500	250	150	5.4	2.7	2.025	1.5	1	0.5	12	3	2	90	30	25
Pylon Interior	Aerospace	1 - Color	415	N/A	N/A	N/A	1500	250	150	5	2.5	1.875	1.5	1	0.5	12	3	2	90	30	25
		2 - Clear	415	N/A	N/A	N/A	1500	250	150	5.4	2.7	2.025	1.5	1	0.5	12	3	2	90	30	25
Strut Panel	Aerospace	1 - Color	415	N/A	N/A	N/A	1500	250	150	5	2.5	1.875	1.5	1	0.5	12	3	2	90	25	17.5
		2 - Clear	415	N/A	N/A	N/A	1500	250	150	5.4	2.7	2.025	1.5	1	0.5	12	3	2	90	25	17.5
Vertical Panel	Practice Panels	1 - Color	517	N/A	N/A	N/A	2100	250	150	5	2.5	1.875	1.5	1	0.5	12	3	1.5	90	25	17.5
		2 - Clear	517	N/A	N/A	N/A	2100	250	150	5.4	2.7	2.025	1.5	1	0.5	12	3	1.5	90	25	17.5
Vertical Piece	Practice Panels	1 - Color	517	N/A	N/A	N/A	2100	250	150	5	2.5	1.875	1.5	1	0.5	12	3	1.5	90	25	17.5
		2 - Clear	517	N/A	N/A	N/A	2100	250	150	5.4	2.7	2.025	1.5	1	0.5	12	3	1.5	90	25	17.5
Wavy Panel	Practice Panels	1 - Color	415	N/A	N/A	N/A	1500	250	150	5	2.5	1.875	1.5	1	0.75	12	3	2.1	90	25	17.5
		2 - Clear	415	N/A	N/A	N/A	1500	250	150	5.4	2.7	2.025	1.5	1	0.75	12	3	2.1	90	25	17.5
Wing Panel	Aerospace	1 - Color	517	N/A	N/A	N/A	2100	250	150	5	2.5	1.875	1.5	1	0.5	12	3	2	90	25	17.5
		2 - Clear	517	N/A	N/A	N/A	2100	250	150	5.4	2.7	2.025	1.5	1	0.5	12	3	2	90	25	17.5
AIRLESS CONVEYOR																					
PART	CATEGORY	COAT	TIP SIZE	AIR PRESSURE (psi)			FLUID PRESSURE (psi)			MIL THICKNESS (mil)			SPEED (ft/s)			DISTANCE TO PART (in)			TRAVEL ANGLE (-)		
				Setting	Tolerance (±)		Setting	Tolerance (±)		Setting	Tolerance (±)		Setting	Tolerance (±)		Setting	Tolerance (±)		Setting	Tolerance (±)	
					Easy	Hard		Easy	Hard		Easy	Hard		Easy	Hard		Easy	Hard		Easy	Hard
Flat Panel	Practice Panels	1 - Color	517	N/A	N/A	N/A	2100	250	150	5	2.5	1.875	1.5	1	0.5	12	3	1.5	90	25	17.5
Wavy Panel	Practice Panels	1 - Color	415	N/A	N/A	N/A	1500	250	150	5	2.5	1.875	1.5	1	0.5	12	3	1.5	90	25	17.5

BLASTING								
PART	CATEGORY	COAT	DIFFICULTY (MEDIA)	BLAST AND DAMAGE RATE	MIL THICKNESS (mil)		DISTANCE TO PART (in)	
					Setting	Tolerance (±)	Setting	Tolerance (±)
ACQPA Panel	Testing Panels	1	Easy (Sodium Bicarbonate), Medium (Garnet), or Hard (Steel Grit)	Low, Medium, and High, respectively per Difficulty	3.375	1.875	21	3
ASTM Panel	Testing Panels	1	Easy (Sodium Bicarbonate), Medium (Garnet), or Hard (Steel Grit)	Low, Medium, and High, respectively per Difficulty	3.375	1.875	21	3
Bridge Section	Construction	1	Easy (Sodium Bicarbonate), Medium (Garnet), or Hard (Steel Grit)	Low, Medium, and High, respectively per Difficulty	3.375	1.875	21	3
Flat Panel	Practice Panels	1	Easy (Sodium Bicarbonate), Medium (Garnet), or Hard (Steel Grit)	Low, Medium, and High, respectively per Difficulty	3.375	1.875	21	3
I-Beam	Construction	1	Easy (Sodium Bicarbonate), Medium (Garnet), or Hard (Steel Grit)	Low, Medium, and High, respectively per Difficulty	3.375	1.875	21	3
Vertical Panel	Practice Panels	1	Easy (Sodium Bicarbonate), Medium (Garnet), or Hard (Steel Grit)	Low, Medium, and High, respectively per Difficulty	3.375	1.875	21	3
Vertical Piece	Practice Panels	1	Easy (Sodium Bicarbonate), Medium (Garnet), or Hard (Steel Grit)	Low, Medium, and High, respectively per Difficulty	3.375	1.875	21	3
Wavy Panel	Practice Panels	1	Easy (Sodium Bicarbonate), Medium (Garnet), or Hard (Steel Grit)	Low, Medium, and High, respectively per Difficulty	3.375	1.875	21	3

HVLP																					
PART	CATEGORY	COAT	TIP SIZE	AIR PRESSURE (psi)			FLUID PRESSURE (psi)			MIL THICKNESS (mil)			SPEED (ft/s)			DISTANCE TO PART (in)			TRAVEL ANGLE (-)		
				Setting	Tolerance (±)		Setting	Tolerance (±)		Setting	Tolerance (±)		Setting	Tolerance (±)		Setting	Tolerance (±)		Setting	Tolerance (±)	
					Easy	Hard		Easy	Hard		Easy	Hard		Easy	Hard		Easy	Hard		Easy	Hard
ACQPA Panel Cylinder	Testing Panels	1 - Color	1.2	35	10	5	N/A	N/A	N/A	1.8	0.9	0.675	1.5	1	0.5	8	3	1.5	90	25	17.5
		2 - Clear	1.2	35	10	10	N/A	N/A	N/A	1.6	0.8	0.6	1.5	1	0.5	8	3	1.5	90	25	17.5
ACQPA Panel Horizontal	Testing Panels	1 - Color	1.2	35	10	5	N/A	N/A	N/A	1.8	0.9	0.675	1.5	1	0.5	8	3	1.9	90	50	37.5
		2 - Clear	1.2	35	10	10	N/A	N/A	N/A	1.6	0.8	0.6	1.5	1	0.5	8	3	1.9	90	50	37.5
ACQPA Panel Vertical	Testing Panels	1 - Color	1.2	35	10	5	N/A	N/A	N/A	1.8	0.9	0.675	1.5	1	0.5	8	3	1.5	90	25	17.5
		2 - Clear	1.2	35	10	10	N/A	N/A	N/A	1.6	0.8	0.6	1.5	1	0.5	8	3	1.5	90	25	17.5
ASTM Deep T	Construction	1 - Color	1.2	35	10	10	N/A	N/A	N/A	1.8	0.9	0.675	1.5	1	0.5	8	3	1.5	90	25	17.5
		2 - Clear	1.2	35	10	10	N/A	N/A	N/A	1.6	0.8	0.6	1.5	1	0.5	8	3	1.5	90	25	17.5
ASTM H-Beam	Construction	1 - Color	1.2	35	10	10	N/A	N/A	N/A	1.8	0.9	0.675	1.5	1	0.75	8	3	1.5	90	35	17.5
		2 - Clear	1.2	35	10	10	N/A	N/A	N/A	1.6	0.8	0.6	1.5	1	0.75	8	3	1.5	90	35	17.5
ASTM Pipe	Construction	1 - Color	1.2	35	10	10	N/A	N/A	N/A	1.8	0.9	0.675	1.5	1	0.75	8	3	1.5	90	35	17.5
		2 - Clear	1.2	35	10	10	N/A	N/A	N/A	1.6	0.8	0.6	1.5	1	0.75	8	3	1.5	90	35	17.5
Car Bumper	Transportation	1 - Color	1.2	35	10	10	N/A	N/A	N/A	1.8	0.9	0.675	1.5	1	0.75	8	3	1.9	90	35	22.5
		2 - Clear	1.2	35	10	10	N/A	N/A	N/A	1.6	0.8	0.6	1.5	1	0.75	8	3	1.9	90	35	22.5
Car Door	Transportation	1 - Color	1.2	35	10	10	N/A	N/A	N/A	1.8	0.9	0.675	1.5	1	0.5	8	3	1.5	90	25	17.5
		2 - Clear	1.2	35	10	10	N/A	N/A	N/A	1.6	0.8	0.6	1.5	1	0.5	8	3	1.5	90	25	17.5
Car Fender	Transportation	1 - Color	1.2	35	10	10	N/A	N/A	N/A	1.8	0.9	0.675	1.5	1	0.5	8	3	2.1	90	30	22.5
		2 - Clear	1.2	35	10	10	N/A	N/A	N/A	1.6	0.8	0.6	1.5	1	0.5	8	3	2.1	90	30	22.5
Car Hood	Transportation	1 - Color	1.2	35	10	10	N/A	N/A	N/A	1.8	0.9	0.675	1.5	1	0.5	8	3	1.5	90	25	17.5
		2 - Clear	1.2	35	10	10	N/A	N/A	N/A	1.6	0.8	0.6	1.5	1	0.5	8	3	1.5	90	25	17.5
Engine Cowling	Aerospace	1 - Color	1.2	35	10	10	N/A	N/A	N/A	1.8	0.9	0.675	1.5	1	0.5	8	3	1.5	90	25	17.5
		2 - Clear	1.2	35	10	10	N/A	N/A	N/A	1.6	0.8	0.6	1.5	1	0.5	8	3	1.5	90	25	17.5
Flat Panel	Practice Panels	1 - Color	1.2	35	10	10	N/A	N/A	N/A	1.8	0.9	0.675	1.5	1	0.5	8	3	1.5	90	25	17.5
		2 - Clear	1.2	35	10	10	N/A	N/A	N/A	1.6	0.8	0.6	1.5	1	0.5	8	3	1.5	90	25	17.5
Gas Tank	Transportation	1 - Color	1.2	35	10	10	N/A	N/A	N/A	1.8	1.1	0.9	1.5	1	0.75	8	3	2.1	90	50	37.5
		2 - Clear	1.2	35	10	10	N/A	N/A	N/A	1.6	1	0.8	1.5	1	0.75	8	3	2.1	90	50	37.5
Half Barrel	Heavy	1 - Color	1.2	35	10	5	N/A	N/A	N/A	1.8	0.9	0.675	1.5	1	0.85	8	3	1.5	90	35	17.5
		2 - Clear	1.2	35	10	10	N/A	N/A	N/A	1.6	0.8	0.6	1.5	1	0.85	8	3	1.5	90	35	17.5
Horizontal Car Hood	Transportation	1 - Color	1.2	35	10	10	N/A	N/A	N/A	1.8	0.9	0.675	1.5	1	0.85	8	3	1.5	90	27.5	25
		2 - Clear	1.2	35	10	10	N/A	N/A	N/A	1.6	0.8	0.6	1.5	1	0.85	8	3	1.5	90	27.5	25
Horizontal Wagon Roof	Heavy	1 - Color	1.2	35	10	10	N/A	N/A	N/A	1.8	0.9	0.675	1.5	1	0.5	8	3	1.5	90	25	17.5
		2 - Clear	1.2	35	10	10	N/A	N/A	N/A	1.6	0.8	0.6	1.5	1	0.5	8	3	1.5	90	25	17.5
HVLP H-Beam	Construction	1 - Color	1.2	35	10	10	N/A	N/A	N/A	1.8	0.9	0.675	1.5	1	0.6	8	3	1.65	90	35	18.5
		2 - Clear	1.2	35	10	10	N/A	N/A	N/A	1.6	0.8	0.6	1.5	1	0.6	8	3	1.65	90	35	18.5
HVLP I-Beam	Construction	1 - Color	1.2	35	10	10	N/A	N/A	N/A	1.8	0.9	0.675	1.5	1	0.6	8	3	1.65	90	35	18.5
		2 - Clear	1.2	35	10	10	N/A	N/A	N/A	1.6	0.8	0.6	1.5	1	0.6	8	3	1.65	90	35	18.5
Motorcycle Fender	Transportation	1 - Color	1.2	30	10	10	N/A	N/A	N/A	1.8	0.9	0.675	1.5	1	0.85	8	3	2.1	90	35	22.5
		2 - Clear	1.2	30	10	10	N/A	N/A	N/A	1.6	0.8	0.6	1.5	1	0.85	8	3	2.1	90	35	22.5
Pylon Exterior	Aerospace	1 - Color	1.2	35	10	10	N/A	N/A	N/A	1.8	0.9	0.675	1.5	1	0.5	8	3	1.5	90	30	25
		2 - Clear	1.2	35	10	10	N/A	N/A	N/A	1.6	0.8	0.6	1.5	1	0.5	8	3	1.5	90	30	25
Pylon Interior	Aerospace	1 - Color	1.2	35	10	10	N/A	N/A	N/A	1.8	0.9	0.675	1.5	1	0.5	8	3	1.5	90	30	25
		2 - Clear	1.2	35	10	10	N/A	N/A	N/A	1.6	0.8	0.6	1.5	1	0.5	8	3	1.5	90	30	25
Strut panel	Aerospace	1 - Color	1.2	35	10	10	N/A	N/A	N/A	1.8	0.9	0.675	1.5	1	0.5	8	3	1.5	90	25	17.5
		2 - Clear	1.2	35	10	10	N/A	N/A	N/A	1.6	0.8	0.6	1.5	1	0.5	8	3	1.5	90	25	17.5
Vertical Panel	Practice Panels	1 - Color	1.2	35	10	10	N/A	N/A	N/A	1.8	0.9	0.675	1.5	1	0.5	8	3	1.5	90	25	17.5
		2 - Clear	1.2	35	10	10	N/A	N/A	N/A	1.6	0.8	0.6	1.5	1	0.5	8	3	1.5	90	25	17.5
Wavy Panel	Practice Panels	1 - Color	1.2	35	10	10	N/A	N/A	N/A	1.8	0.9	0.675	1.5	1	0.75	8	3	1.5	90	25	17.5
		2 - Clear	1.2	35	10	10	N/A	N/A	N/A	1.6	0.8	0.6	1.5	1	0.75	8	3	1.5	90	25	17.5
Wing panel	Aerospace	1 - Color	1.2	35	10	10	N/A	N/A	N/A	1.8	0.9	0.675	1.5	1	0.5	8	3	1.5	90	25	17.5
		2 - Clear	1.2	35	10	10	N/A	N/A	N/A	1.6	0.8	0.6	1.5	1	0.5	8	3	1.5	90	25	17.5

HVLP EDGE BLENDING																					
PART	CATEGORY	COAT	TIP SIZE	AIR PRESSURE (psi)			FLUID PRESSURE (psi)			MIL THICKNESS (mil)			SPEED (ft/s)			DISTANCE TO PART (in)			TRAVEL ANGLE (°)		
				Setting	Tolerance (±)		Setting	Tolerance (±)		Setting	Tolerance (±)		Setting	Tolerance (±)		Setting	Tolerance (±)		Setting	Tolerance (±)	
					Easy	Hard		Easy	Hard		Easy	Hard		Easy	Hard		Easy	Hard		Easy	Hard
Repair Car Door Fender	- N/A -	1 - Color	1.2	35	10	N/A	N/A	N/A	N/A	1.8	0.9	N/A	1.5	1	N/A	8	3	N/A	90	30	N/A
Repair Car Hood	- N/A -	1 - Color	1.2	35	10	N/A	N/A	N/A	N/A	1.8	0.9	N/A	1.5	1	N/A	8	3	N/A	90	30	N/A
Repair Vertical Panel	- N/A -	1 - Color	1.2	35	10	N/A	N/A	N/A	N/A	1.8	0.9	N/A	1.5	1	N/A	8	3	N/A	90	30	N/A

POWDER COATING																				
PART	CATEGORY	COAT	TIP SIZE	POWDER DELIVERY (%)		TOTAL AIR (Nm ³ /h)		Current (uA)		Voltage (kV)		MIL TARGET (mil)			DISTANCE TO PART (in)			ANGLE (-)		
				Setting	Tolerance (±)	Setting	Tolerance (±)	Setting	Tolerance (±)	Setting	Tolerance (±)	Setting	Easy	Hard	Setting	Easy	Hard	Setting	Easy	Hard
Acute Crease	Industrial Parts	1 - Color	Any	50	10	50	10	60	10	65	15	2.55	1.5	0.75	8	3	2	90	25	15
Flat Panel	Practice Panels	1 - Color	Any	50	10	50	10	50	10	65	15	2.55	1.5	0.75	8	3	2	90	25	15
L Channels	Channels	1 - Color	Any	50	10	50	10	50	10	65	15	2.55	1.5	0.75	8	3	2	90	25	15
Panel Sampler	Practice Panels	1 - Color	Any	50	10	50	10	50	10	65	15	2.55	1.5	0.75	8	3	2	90	25	15
Propeller	Industrial Parts	1 - Color	Any	50	10	50	10	50	10	65	15	2.55	1.5	0.75	8	3	2	90	25	15
Quarter Box Front	Industrial Parts	1 - Color	Any	50	10	50	10	50	10	65	15	2.55	1.5	0.75	8	3	2	90	25	15
U Channels Large	Channels	1 - Color	Any	50	10	50	10	50	10	65	15	2.55	1.5	0.75	8	3	2	90	25	15
U Channels Small	Channels	1 - Color	Any	50	10	50	10	50	10	65	15	2.55	1.5	0.75	8	3	2	90	25	15
Vertical Panel with Holes	Practice Panels	1 - Color	Any	50	10	50	10	50	10	65	15	2.55	1.5	0.75	8	3	2	90	25	15
Wavy Panel	Practice Panels	1 - Color	Any	50	10	50	10	50	10	65	15	2.55	1.5	0.75	8	3	2	90	25	15
POWDER COATING CONVEYOR																				
PART	CATEGORY	COAT	TIP SIZE	POWDER DELIVERY (%)		TOTAL AIR (Nm ³ /h)		Current (uA)		Voltage (kV)		MIL TARGET (mil)			DISTANCE TO PART (in)			ANGLE (-)		
				Setting	Tolerance (±)	Setting	Tolerance (±)	Setting	Tolerance (±)	Setting	Tolerance (±)	Setting	Easy	Hard	Setting	Easy	Hard	Setting	Easy	Hard
Acute Crease	Industrial Parts	1 - Color	Any	50	10	50	10	60	10	65	15	2.55	1.5	0.75	8	3	2	90	25	15
Flat Panel	Practice Panels	1 - Color	Any	50	10	50	10	50	10	65	15	2.55	1.5	0.75	8	3	2	90	25	15
L Channels	Channels	1 - Color	Any	50	10	50	10	50	10	65	15	2.55	1.5	0.75	8	3	2	90	25	15
Panel Sampler	Practice Panels	1 - Color	Any	50	10	50	10	50	10	65	15	2.55	1.5	0.75	8	3	2	90	25	15
Quarter Box Back	Industrial Parts	1 - Color	Any	50	10	50	10	50	10	65	15	2.55	1.5	0.75	8	3	2	90	25	15
Quarter Box Front	Industrial Parts	1 - Color	Any	50	10	50	10	50	10	65	15	2.55	1.5	0.75	8	3	2	90	25	15
U Channels Large	Channels	1 - Color	Any	50	10	50	10	50	10	65	15	2.55	1.5	0.75	8	3	2	90	25	15
U Channels Small	Channels	1 - Color	Any	50	10	50	10	50	10	65	15	2.55	1.5	0.75	8	3	2	90	25	15
Vertical Panel with Holes	Practice Panels	1 - Color	Any	50	10	50	10	50	10	65	15	2.55	1.5	0.75	8	3	2	90	25	15
Wavy Panel	Practice Panels	1 - Color	Any	50	10	50	10	50	10	65	15	2.55	1.5	0.75	8	3	2	90	25	15