

AIR-ASSISTED AIRLESS																			Metric	
PART	COAT	TIP SIZE	AIR PRESSURE (bar)			FLUID PRESSURE (bar)			MIL THICKNESS (mil)			SPEED (cm/s)			DISTANCE TO PART (cm)			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	1 - Color	517	0.6	0.3	0.1	124.1	17.2	10.3	4.4	1.5	1.14	46	30	24	30.5	7.6	4.6	90	35	25
	2 - Clear	517	0.6	0.3	0.1	124.1	17.2	10.3	4.4	1.5	1.14	46	30	24	30.5	7.6	4.6	90	35	25
ACQPA Panel Cylinder	1 - Color	313	0.6	0.3	0.1	62.1	17.2	10.3	4.4	1.5	1.14	46	30	24	30.5	7.6	4.6	90	30	25
	2 - Clear	313	0.6	0.3	0.1	62.1	17.2	10.3	4.4	1.5	1.14	46	30	24	30.5	7.6	4.6	90	30	25
ACQPA Panel Horizontal	1 - Color	313	0.6	0.3	0.1	62.1	17.2	10.3	4.4	1.5	1.14	46	30	24	30.5	7.6	4.6	90	35	25
	2 - Clear	313	0.6	0.3	0.1	62.1	17.2	10.3	4.4	1.5	1.14	46	30	24	30.5	7.6	4.6	90	35	25
ACQPA Panel Vertical	1 - Color	313	0.6	0.3	0.1	62.1	17.2	10.3	4.4	1.5	1.14	46	30	24	30.5	7.6	4.6	90	30	25
	2 - Clear	313	0.6	0.3	0.1	62.1	17.2	10.3	4.4	1.5	1.14	46	30	24	30.5	7.6	4.6	90	30	25
ASTM Deep T	1 - Color	415	0.6	0.3	0.1	89.6	17.2	10.3	4.4	1.5	1.14	46	30	24	30.5	7.6	4.6	90	35	25
	2 - Clear	415	0.6	0.3	0.1	89.6	17.2	10.3	4.4	1.5	1.14	46	30	24	30.5	7.6	4.6	90	35	25
ASTM H Beam	1 - Color	415	0.6	0.3	0.1	89.6	17.2	10.3	4.4	1.5	1.14	46	30	24	30.5	7.6	4.6	90	30	25
	2 - Clear	415	0.6	0.3	0.1	89.6	17.2	10.3	4.4	1.5	1.14	46	30	24	30.5	7.6	4.6	90	30	25
ASTM Panel	1 - Color	415	0.6	0.3	0.1	89.6	17.2	10.3	4.4	1.5	1.14	46	30	24	30.5	7.6	4.6	90	35	25
	2 - Clear	415	0.6	0.3	0.1	89.6	17.2	10.3	4.4	1.5	1.14	46	30	24	30.5	7.6	4.6	90	35	25
ASTM Pipe	1 - Color	415	0.6	0.3	0.1	89.6	17.2	10.3	4.4	1.5	1.14	46	30	24	30.5	7.6	4.6	90	30	25
	2 - Clear	415	0.6	0.3	0.1	89.6	17.2	10.3	4.4	1.5	1.14	46	30	24	30.5	7.6	4.6	90	30	25
BookShelf	1 - Color	415	0.6	0.3	0.1	89.6	17.2	10.3	4.4	1.5	1.14	46	30	24	30.5	7.6	4.6	90	35	25
	2 - Clear	415	0.6	0.3	0.1	89.6	17.2	10.3	4.4	1.5	1.14	46	30	24	30.5	7.6	4.6	90	35	25
Bridge Section	1 - Color	415	0.6	0.3	0.1	89.6	17.2	10.3	4.4	1.5	1.14	46	30	24	30.5	7.6	4.6	90	35	25
	2 - Clear	415	0.6	0.3	0.1	89.6	17.2	10.3	4.4	1.5	1.14	46	30	24	30.5	7.6	4.6	90	35	25
Cabinet Door	1 - Color	415	0.6	0.3	0.1	89.6	17.2	10.3	4.4	1.36	1.01	46	30	23	30.5	7.6	4.2	90	30	22.5
	2 - Clear	415	0.6	0.3	0.1	89.6	17.2	10.3	4.4	1.36	1.01	46	30	23	30.5	7.6	4.2	90	30	22.5
Cabinet Drawer	1 - Color	415	0.6	0.3	0.1	89.6	17.2	10.3	4.4	1.36	1.01	46	30	23	30.5	7.6	4.2	90	30	22.5
	2 - Clear	415	0.6	0.3	0.1	89.6	17.2	10.3	4.4	1.36	1.01	46	30	23	30.5	7.6	4.2	90	30	22.5
Cabinet Frame Large	1 - Color	415	0.6	0.3	0.1	89.6	17.2	10.3	4.4	1.5	1.14	46	30	24	30.5	7.6	4.6	90	35	25
	2 - Clear	415	0.6	0.3	0.1	89.6	17.2	10.3	4.4	1.5	1.14	46	30	24	30.5	7.6	4.6	90	35	25
Cabinet Frame Medium	1 - Color	415	0.6	0.3	0.1	89.6	17.2	10.3	4.4	1.5	1.14	46	30	24	30.5	7.6	4.6	90	35	25
	2 - Clear	415	0.6	0.3	0.1	89.6	17.2	10.3	4.4	1.5	1.14	46	30	24	30.5	7.6	4.6	90	35	25
Cabinet Frame Small	1 - Color	415	0.6	0.3	0.1	89.6	17.2	10.3	4.4	1.5	1.14	46	30	24	30.5	7.6	4.6	90	35	25
	2 - Clear	415	0.6	0.3	0.1	89.6	17.2	10.3	4.4	1.5	1.14	46	30	24	30.5	7.6	4.6	90	35	25
Car Bumper	1 - Color	313	0.6	0.3	0.1	62.1	17.2	10.3	4.4	1.5	1.14	46	30	24	30.5	7.6	4.6	90	35	25
	2 - Clear	313	0.6	0.3	0.1	62.1	17.2	10.3	4.4	1.5	1.14	46	30	24	30.5	7.6	4.6	90	35	25
Car Door	1 - Color	313	0.6	0.3	0.1	62.1	17.2	10.3	4.4	1.23	0.88	46	30	21	30.5	7.6	3.8	90	25	17.5
	2 - Clear	313	0.6	0.3	0.1	62.1	17.2	10.3	4.4	1.23	0.88	46	30	21	30.5	7.6	3.8	90	25	17.5
Car Fender	1 - Color	313	0.6	0.3	0.1	62.1	17.2	10.3	4.4	1.36	1.01	46	30	23	30.5	7.6	4.2	90	30	22.5
	2 - Clear	313	0.6	0.3	0.1	62.1	17.2	10.3	4.4	1.36	1.01	46	30	23	30.5	7.6	4.2	90	30	22.5
Car Hood	1 - Color	415	0.6	0.3	0.1	89.6	17.2	10.3	4.4	1.23	0.88	46	30	21	30.5	7.6	3.8	90	25	17.5
	2 - Clear	415	0.6	0.3	0.1	89.6	17.2	10.3	4.4	1.23	0.88	46	30	21	30.5	7.6	3.8	90	25	17.5
Dining Chair	1 - Color	415	0.6	0.3	0.1	89.6	17.2	10.3	4.4	1.36	1.01	46	30	23	30.5	7.6	4.2	90	30	22.5
	2 - Clear	415	0.6	0.3	0.1	89.6	17.2	10.3	4.4	1.36	1.01	46	30	23	30.5	7.6	4.2	90	30	22.5
Dining Table	1 - Color	517	0.6	0.3	0.1	124.1	17.2	10.3	4.4	1.36	1.01	46	30	23	30.5	7.6	4.2	90	30	22.5
	2 - Clear	517	0.6	0.3	0.1	124.1	17.2	10.3	4.4	1.36	1.01	46	30	23	30.5	7.6	4.2	90	30	22.5

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PART	COAT	TIP SIZE	AIR PRESSURE (bar)			FLUID PRESSURE (bar)			MIL THICKNESS (mil)			SPEED (cm/s)			DISTANCE TO PART (cm)			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 (±)
Engine Cowling	1 - Color	415	0.6	0.3	0.1	89.6	17.2	10.3	4.4	1.23	0.88	46	30	21	30.5	7.6	3.8	90	25	17.5
	2 - Clear	415	0.6	0.3	0.1	89.6	17.2	10.3	4.4	1.23	0.88	46	30	21	30.5	7.6	3.8	90	25	17.5
Flat Panel	1 - Color	517	0.6	0.3	0.1	124.1	17.2	10.3	4.4	1.23	0.88	46	30	21	30.5	7.6	3.8	90	25	17.5
	2 - Clear	517	0.6	0.3	0.1	124.1	17.2	10.3	4.4	1.23	0.88	46	30	21	30.5	7.6	3.8	90	25	17.5
Fridge End Panel	1 - Color	517	0.6	0.3	0.1	124.1	17.2	10.3	4.4	1.23	0.88	46	30	21	30.5	7.6	3.8	90	25	17.5
	2 - Clear	517	0.6	0.3	0.1	124.1	17.2	10.3	4.4	1.23	0.88	46	30	21	30.5	7.6	3.8	90	25	17.5
Gas Tank	1 - Color	313	0.6	0.3	0.1	62.1	17.2	10.3	4.4	1.5	1.14	46	30	24	30.5	7.6	4.6	90	35	25
	2 - Clear	313	0.6	0.3	0.1	62.1	17.2	10.3	4.4	1.5	1.14	46	30	24	30.5	7.6	4.6	90	35	25
Half Barrel	1 - Color	415	0.6	0.3	0.1	89.6	17.2	10.3	4.4	1.36	1.01	46	30	23	30.5	7.6	4.2	90	30	22.5
	2 - Clear	415	0.6	0.3	0.1	89.6	17.2	10.3	4.4	1.36	1.01	46	30	23	30.5	7.6	4.2	90	30	22.5
H Beam	1 - Color	415	0.6	0.3	0.1	89.6	17.2	10.3	4.4	1.36	1.01	46	30	23	30.5	7.6	4.2	90	30	22.5
	2 - Clear	415	0.6	0.3	0.1	89.6	17.2	10.3	4.4	1.36	1.01	46	30	23	30.5	7.6	4.2	90	30	22.5
Headboard	1 - Color	517	0.6	0.3	0.1	124.1	17.2	10.3	4.4	1.23	0.88	46	30	21	30.5	7.6	3.8	90	25	17.5
	2 - Clear	517	0.6	0.3	0.1	124.1	17.2	10.3	4.4	1.23	0.88	46	30	21	30.5	7.6	3.8	90	25	17.5
Horizontal Car Hood	1 - Color	415	0.6	0.3	0.1	89.6	17.2	10.3	4.4	1.23	0.88	46	30	21	30.5	7.6	3.8	90	25	17.5
	2 - Clear	415	0.6	0.3	0.1	89.6	17.2	10.3	4.4	1.23	0.88	46	30	21	30.5	7.6	3.8	90	25	17.5
Horizontal Wagon Roof	1 - Color	415	0.6	0.3	0.1	89.6	17.2	10.3	4.4	1.23	0.88	46	30	21	30.5	7.6	3.8	90	25	17.5
	2 - Clear	415	0.6	0.3	0.1	89.6	17.2	10.3	4.4	1.23	0.88	46	30	21	30.5	7.6	3.8	90	25	17.5
HVLP H-Beam	1 - Color	313	0.6	0.3	0.1	62.1	17.2	10.3	4.4	1.36	1.01	46	30	23	30.5	7.6	4.2	90	30	22.5
	2 - Clear	313	0.6	0.3	0.1	62.1	17.2	10.3	4.4	1.36	1.01	46	30	23	30.5	7.6	4.2	90	30	22.5
HVLP I-Beam	1 - Color	313	0.6	0.3	0.1	62.1	17.2	10.3	4.4	1.36	1.01	46	30	23	30.5	7.6	4.2	90	30	22.5
	2 - Clear	313	0.6	0.3	0.1	62.1	17.2	10.3	4.4	1.36	1.01	46	30	23	30.5	7.6	4.2	90	30	22.5
I Beam	1 - Color	415	0.6	0.3	0.1	89.6	17.2	10.3	4.4	1.36	1.01	46	30	23	30.5	7.6	4.2	90	30	22.5
	2 - Clear	415	0.6	0.3	0.1	89.6	17.2	10.3	4.4	1.36	1.01	46	30	23	30.5	7.6	4.2	90	30	22.5
Large Set Panel	1 - Color	517	0.6	0.3	0.1	124.1	17.2	10.3	4.4	1.23	0.88	46	30	21	30.5	7.6	3.8	90	25	17.5
	2 - Clear	517	0.6	0.3	0.1	124.1	17.2	10.3	4.4	1.23	0.88	46	30	21	30.5	7.6	3.8	90	25	17.5
Lattice	1 - Color	313	0.6	0.3	0.1	62.1	17.2	10.3	4.4	1.5	1.14	46	30	24	30.5	7.6	4.6	90	35	25
	2 - Clear	313	0.6	0.3	0.1	62.1	17.2	10.3	4.4	1.5	1.14	46	30	24	30.5	7.6	4.6	90	35	25
Motorcycle Fender	1 - Color	313	0.6	0.3	0.1	62.1	17.2	10.3	4.4	1.36	1.01	46	30	23	30.5	7.6	4.2	90	30	22.5
	2 - Clear	313	0.6	0.3	0.1	62.1	17.2	10.3	4.4	1.36	1.01	46	30	23	30.5	7.6	4.2	90	30	22.5
Pylon Exterior	1 - Color	415	0.6	0.3	0.1	89.6	17.2	10.3	4.4	1.36	1.01	46	30	23	30.5	7.6	4.2	90	30	22.5
	2 - Clear	415	0.6	0.3	0.1	89.6	17.2	10.3	4.4	1.36	1.01	46	30	23	30.5	7.6	4.2	90	30	22.5
Pylon Interior	1 - Color	415	0.6	0.3	0.1	89.6	17.2	10.3	4.4	1.36	1.01	46	30	23	30.5	7.6	4.2	90	30	22.5
	2 - Clear	415	0.6	0.3	0.1	89.6	17.2	10.3	4.4	1.36	1.01	46	30	23	30.5	7.6	4.2	90	30	22.5
Strut Panel	1 - Color	415	0.6	0.3	0.1	89.6	17.2	10.3	4.4	1.23	0.88	46	30	21	30.5	7.6	3.8	90	25	17.5
	2 - Clear	415	0.6	0.3	0.1	89.6	17.2	10.3	4.4	1.23	0.88	46	30	21	30.5	7.6	3.8	90	25	17.5
Vertical Panel	1 - Color	517	0.6	0.3	0.1	124.1	17.2	10.3	4.4	1.23	0.88	46	30	21	30.5	7.6	3.8	90	25	17.5
	2 - Clear	517	0.6	0.3	0.1	124.1	17.2	10.3	4.4	1.23	0.88	46	30	21	30.5	7.6	3.8	90	25	17.5
Vertical Piece	1 - Color	517	0.6	0.3	0.1	124.1	17.2	10.3	4.4	1.23	0.88	46	30	21	30.5	7.6	3.8	90	25	17.5
	2 - Clear	517	0.6	0.3	0.1	124.1	17.2	10.3	4.4	1.23	0.88	46	30	21	30.5	7.6	3.8	90	25	17.5
Wavy Panel	1 - Color	313	0.6	0.3	0.1	62.1	17.2	10.3	4.4	1.23	0.88	46	30	21	30.5	7.6	3.8	90	25	17.5
	2 - Clear	313	0.6	0.3	0.1	62.1	17.2	10.3	4.4	1.23	0.88	46	30	21	30.5	7.6	3.8	90	25	17.5

AIR-ASSISTED AIRLESS																			Metric	
PART	COAT	TIP SIZE	AIR PRESSURE (bar)			FLUID PRESSURE (bar)			MIL THICKNESS (mil)			SPEED (cm/s)			DISTANCE TO PART (cm)			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 (±)
Wing Panel	1 - Color	517	0.6	0.3	0.1	124.1	17.2	10.3	4.4	1.23	0.88	46	30	21	30.5	7.6	3.8	90	25	17.5
	2 - Clear	517	0.6	0.3	0.1	124.1	17.2	10.3	4.4	1.23	0.88	46	30	21	30.5	7.6	3.8	90	25	17.5
Wood Panel	1 - Color	517	0.6	0.3	0.1	124.1	17.2	10.3	4.4	1.23	0.88	46	30	21	30.5	7.6	3.8	90	25	17.5
	2 - Clear	517	0.6	0.3	0.1	124.1	17.2	10.3	4.4	1.23	0.88	46	30	21	30.5	7.6	3.8	90	25	17.5
AIR-ASSISTED AIRLESS CONVEYOR																			Metric	
PART	COAT	TIP SIZE	AIR PRESSURE (bar)			FLUID PRESSURE (bar)			MIL THICKNESS (mil)			SPEED (cm/s)			DISTANCE TO PART (cm)			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 (±)
Bookshelf	1 - Color	415	0.6	0.3	0.1	89.6	17.2	10.3	4.4	1.5	1.14	46	30	24	30.5	7.6	4.6	90	35	25
Cabinet Door	1 - Color	415	0.6	0.3	0.1	89.6	17.2	10.3	4.4	1.36	1.01	46	30	23	30.5	7.6	4.2	90	30	22.5
Cabinet Drawer	1 - Color	415	0.6	0.3	0.1	89.6	17.2	10.3	4.4	1.36	1.01	46	30	23	30.5	7.6	4.2	90	30	22.5
Cabinet Frame Large	1 - Color	415	0.6	0.3	0.1	89.6	17.2	10.3	4.4	1.5	1.14	46	30	24	30.5	7.6	4.6	90	35	25
Cabinet Frame Medium	1 - Color	415	0.6	0.3	0.1	89.6	17.2	10.3	4.4	1.5	1.14	46	30	24	30.5	7.6	4.6	90	35	25
Cabinet Frame Small	1 - Color	415	0.6	0.3	0.1	89.6	17.2	10.3	4.4	1.5	1.14	46	30	24	30.5	7.6	4.6	90	35	25
Car Bumper	1 - Color	313	0.6	0.3	0.1	62.1	17.2	10.3	4.4	1.5	1.14	46	30	24	30.5	7.6	4.6	90	35	25
Car Door	1 - Color	313	0.6	0.3	0.1	62.1	17.2	10.3	4.4	1.23	0.88	46	30	21	30.5	7.6	3.8	90	25	17.5
Car Fender	1 - Color	313	0.6	0.3	0.1	62.1	17.2	10.3	4.4	1.23	0.88	46	30	21	30.5	7.6	3.8	90	25	17.5
Car Hood	1 - Color	415	0.6	0.3	0.1	89.6	17.2	10.3	4.4	1.23	0.88	46	30	21	30.5	7.6	3.8	90	25	17.5
Flat Panel	1 - Color	517	0.6	0.3	0.1	124.1	17.2	10.3	4.4	1.23	0.88	46	30	21	30.5	7.6	3.8	90	25	17.5
Fridge End Panel	1 - Color	517	0.6	0.3	0.1	124.1	17.2	10.3	4.4	1.23	0.88	46	30	21	30.5	7.6	3.8	90	25	17.5
Headboard	1 - Color	517	0.6	0.3	0.1	124.1	17.2	10.3	4.4	1.23	0.88	46	30	21	30.5	7.6	3.8	90	25	17.5
Lattice	1 - Color	313	0.6	0.3	0.1	124.1	17.2	10.3	4.4	1.5	1.14	46	30	24	30.5	7.6	4.6	90	35	25
Motorcycle Fender	1 - Color	313	0.6	0.3	0.1	62.1	17.2	10.3	4.4	1.36	1.01	46	30	23	30.5	7.6	4.2	90	30	22.5
Vertical Panel	1 - Color	517	0.6	0.3	0.1	124.1	17.2	10.3	4.4	1.23	0.88	46	30	21	30.5	7.6	3.8	90	25	17.5
Vertical Piece	1 - Color	517	0.6	0.3	0.1	124.1	17.2	10.3	4.4	1.23	0.88	46	30	21	30.5	7.6	3.8	90	25	17.5
Wavy Panel	1 - Color	313	0.6	0.3	0.1	62.1	17.2	10.3	4.4	1.23	0.88	46	30	21	30.5	7.6	3.8	90	25	17.5
Wood Panel	1 - Color	517	0.6	0.3	0.1	124.1	17.2	10.3	4.4	1.23	0.88	46	30	21	30.5	7.6	3.8	90	25	17.5

AIRLESS																			Metric	
PART	COAT	TIP SIZE	AIR PRESSURE (bar)			FLUID PRESSURE (bar)			MIL THICKNESS (mil)			SPEED (cm/s)			DISTANCE TO PART (cm)			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	1 - Color	517	N/A	N/A	N/A	144.8	17.2	10.3	6	2.04	1.56	46	30	24	30.5	7.6	4.6	90	35	25
	2 - Clear	517	N/A	N/A	N/A	144.8	17.2	10.3	6	2.04	1.56	46	30	24	30.5	7.6	4.6	90	35	25
ACQPA Panel Cylinder	1 - Color	313	N/A	N/A	N/A	82.7	17.2	10.3	6	2.04	1.56	46	30	24	30.5	7.6	4.2	90	35	25
	2 - Clear	313	N/A	N/A	N/A	82.7	17.2	10.3	6	2.04	1.56	46	30	24	30.5	7.6	4.2	90	35	25
ACQPA Panel Horizontal	1 - Color	313	N/A	N/A	N/A	82.7	17.2	10.3	6	2.04	1.56	46	30	24	30.5	7.6	4.6	90	35	25
	2 - Clear	313	N/A	N/A	N/A	82.7	17.2	10.3	6	2.04	1.56	46	30	24	30.5	7.6	4.6	90	35	25
ACQPA Panel Vertical	1 - Color	313	N/A	N/A	N/A	82.7	17.2	10.3	6	2.04	1.56	46	30	24	30.5	7.6	4.2	90	35	25
	2 - Clear	313	N/A	N/A	N/A	82.7	17.2	10.3	6	2.04	1.56	46	30	24	30.5	7.6	4.2	90	35	25
ASTM Deep T	1 - Color	415	N/A	N/A	N/A	103.4	17.2	10.3	6	2.04	1.56	46	30	24	30.5	7.6	4.6	90	35	25
	2 - Clear	415	N/A	N/A	N/A	103.4	17.2	10.3	6	2.04	1.56	46	30	24	30.5	7.6	4.6	90	35	25
ASTM H Beam	1 - Color	415	N/A	N/A	N/A	103.4	17.2	10.3	6	2.04	1.56	46	30	24	30.5	7.6	4.2	90	35	25
	2 - Clear	415	N/A	N/A	N/A	103.4	17.2	10.3	6	2.04	1.56	46	30	24	30.5	7.6	4.2	90	35	25
ASTM Panel	1 - Color	415	N/A	N/A	N/A	103.4	17.2	10.3	6	2.04	1.56	46	30	24	30.5	7.6	4.6	90	35	25
	2 - Clear	415	N/A	N/A	N/A	103.4	17.2	10.3	6	2.04	1.56	46	30	24	30.5	7.6	4.6	90	35	25
ASTM Pipe	1 - Color	415	N/A	N/A	N/A	103.4	17.2	10.3	6	2.04	1.56	46	30	24	30.5	7.6	4.2	90	35	25
	2 - Clear	415	N/A	N/A	N/A	103.4	17.2	10.3	6	2.04	1.56	46	30	24	30.5	7.6	4.2	90	35	25
Bookshelf	1 - Color	415	N/A	N/A	N/A	103.4	17.2	10.3	6	2.04	1.56	46	30	24	30.5	7.6	4.6	90	35	25
	2 - Clear	415	N/A	N/A	N/A	103.4	17.2	10.3	6	2.04	1.56	46	30	24	30.5	7.6	4.6	90	35	25
Bridge Section	1 - Color	415	N/A	N/A	N/A	103.4	17.2	10.3	6	2.04	1.56	46	30	24	30.5	7.6	4.6	90	35	25
	2 - Clear	415	N/A	N/A	N/A	103.4	17.2	10.3	6	2.04	1.56	46	30	24	30.5	7.6	4.6	90	35	25
Cabinet Door	1 - Color	415	N/A	N/A	N/A	103.4	17.2	10.3	6	1.86	1.38	46	30	23	30.5	7.6	4.2	90	30	22.5
	2 - Clear	415	N/A	N/A	N/A	103.4	17.2	10.3	6	1.86	1.38	46	30	23	30.5	7.6	4.2	90	30	22.5
Cabinet Drawer	1 - Color	415	N/A	N/A	N/A	103.4	17.2	10.3	6	1.86	1.38	46	30	23	30.5	7.6	4.2	90	30	22.5
	2 - Clear	415	N/A	N/A	N/A	103.4	17.2	10.3	6	1.86	1.38	46	30	23	30.5	7.6	4.2	90	30	22.5
Cabinet Frame Large	1 - Color	415	N/A	N/A	N/A	103.4	17.2	10.3	6	1.86	1.38	46	30	24	30.5	7.6	4.6	90	35	25
	2 - Clear	415	N/A	N/A	N/A	103.4	17.2	10.3	6	1.86	1.38	46	30	24	30.5	7.6	4.6	90	35	25
Cabinet Frame Medium	1 - Color	415	N/A	N/A	N/A	103.4	17.2	10.3	6	1.86	1.38	46	30	24	30.5	7.6	4.6	90	35	25
	2 - Clear	415	N/A	N/A	N/A	103.4	17.2	10.3	6	1.86	1.38	46	30	24	30.5	7.6	4.6	90	35	25
Cabinet Frame Small	1 - Color	415	N/A	N/A	N/A	103.4	17.2	10.3	6	1.86	1.38	46	30	24	30.5	7.6	4.6	90	35	25
	2 - Clear	415	N/A	N/A	N/A	103.4	17.2	10.3	6	1.86	1.38	46	30	24	30.5	7.6	4.6	90	35	25
Car Bumper	1 - Color	313	N/A	N/A	N/A	82.7	17.2	10.3	6	2.04	1.56	46	30	24	30.5	7.6	4.6	90	35	25
	2 - Clear	313	N/A	N/A	N/A	82.7	17.2	10.3	6	2.04	1.56	46	30	24	30.5	7.6	4.6	90	35	25
Car Door	1 - Color	313	N/A	N/A	N/A	82.7	17.2	10.3	6	1.68	1.2	46	30	21	30.5	7.6	3.8	90	25	17.5
	2 - Clear	313	N/A	N/A	N/A	82.7	17.2	10.3	6	1.68	1.2	46	30	21	30.5	7.6	3.8	90	25	17.5
Car Fender	1 - Color	313	N/A	N/A	N/A	82.7	17.2	10.3	6	1.86	1.38	46	30	23	30.5	7.6	4.2	90	30	22.5
	2 - Clear	313	N/A	N/A	N/A	82.7	17.2	10.3	6	1.86	1.38	46	30	23	30.5	7.6	4.2	90	30	22.5
Car Hood	1 - Color	415	N/A	N/A	N/A	103.4	17.2	10.3	6	1.68	1.2	46	30	21	30.5	7.6	3.8	90	25	17.5
	2 - Clear	415	N/A	N/A	N/A	103.4	17.2	10.3	6	1.68	1.2	46	30	21	30.5	7.6	3.8	90	25	17.5
Dining Chair	1 - Color	415	N/A	N/A	N/A	103.4	17.2	10.3	6	1.86	1.38	46	30	23	30.5	7.6	4.2	90	30	22.5
	2 - Clear	415	N/A	N/A	N/A	103.4	17.2	10.3	6	1.86	1.38	46	30	23	30.5	7.6	4.2	90	30	22.5
Dining Table	1 - Color	517	N/A	N/A	N/A	144.8	17.2	10.3	6	1.86	1.38	46	30	23	30.5	7.6	4.2	90	30	22.5
	2 - Clear	517	N/A	N/A	N/A	144.8	17.2	10.3	6	1.86	1.38	46	30	23	30.5	7.6	4.2	90	30	22.5

AIRLESS																			Metric	
PART	COAT	TIP SIZE	AIR PRESSURE (bar)			FLUID PRESSURE (bar)			MIL THICKNESS (mil)			SPEED (cm/s)			DISTANCE TO PART (cm)			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 (±)
Engine Cowling	1 - Color	415	N/A	N/A	N/A	103.4	17.2	10.3	6	1.68	1.2	46	30	21	30.5	7.6	3.8	90	25	17.5
	2 - Clear	415	N/A	N/A	N/A	103.4	17.2	10.3	6	1.68	1.2	46	30	21	30.5	7.6	3.8	90	25	17.5
Flat Panel	1 - Color	517	N/A	N/A	N/A	144.8	17.2	10.3	6	1.68	1.2	46	30	21	30.5	7.6	3.8	90	25	17.5
	2 - Clear	517	N/A	N/A	N/A	144.8	17.2	10.3	6	1.68	1.2	46	30	21	30.5	7.6	3.8	90	25	17.5
Fridge End Panel	1 - Color	517	N/A	N/A	N/A	144.8	17.2	10.3	6	1.68	1.2	46	30	21	30.5	7.6	3.8	90	25	17.5
	2 - Clear	517	N/A	N/A	N/A	144.8	17.2	10.3	6	1.68	1.2	46	30	21	30.5	7.6	3.8	90	25	17.5
Gas Tank	1 - Color	313	N/A	N/A	N/A	82.7	17.2	10.3	6	2.04	1.56	46	30	24	30.5	7.6	4.6	90	35	25
	2 - Clear	313	N/A	N/A	N/A	82.7	17.2	10.3	6	2.04	1.56	46	30	24	30.5	7.6	4.6	90	35	25
Half Barrel	1 - Color	415	N/A	N/A	N/A	103.4	17.2	10.3	6	1.86	1.38	46	30	23	30.5	7.6	4.2	90	30	22.5
	2 - Clear	415	N/A	N/A	N/A	103.4	17.2	10.3	6	1.86	1.38	46	30	23	30.5	7.6	4.2	90	30	22.5
H Beam	1 - Color	415	N/A	N/A	N/A	103.4	17.2	10.3	6	1.86	1.38	46	30	23	30.5	7.6	4.2	90	30	22.5
	2 - Clear	415	N/A	N/A	N/A	103.4	17.2	10.3	6	1.86	1.38	46	30	23	30.5	7.6	4.2	90	30	22.5
Headboard	1 - Color	517	N/A	N/A	N/A	144.8	17.2	10.3	6	1.68	1.2	46	30	21	30.5	7.6	3.8	90	25	17.5
	2 - Clear	517	N/A	N/A	N/A	144.8	17.2	10.3	6	1.68	1.2	46	30	21	30.5	7.6	3.8	90	25	17.5
Horizontal Car Hood	1 - Color	415	N/A	N/A	N/A	103.4	17.2	10.3	6	1.68	1.2	46	30	21	30.5	7.6	3.8	90	25	17.5
	2 - Clear	415	N/A	N/A	N/A	103.4	17.2	10.3	6	1.68	1.2	46	30	21	30.5	7.6	3.8	90	25	17.5
Horizontal Wagon Roof	1 - Color	415	N/A	N/A	N/A	103.4	17.2	10.3	6	1.68	1.2	46	30	21	30.5	7.6	3.8	90	25	17.5
	2 - Clear	415	N/A	N/A	N/A	103.4	17.2	10.3	6	1.68	1.2	46	30	21	30.5	7.6	3.8	90	25	17.5
HVLP H-Beam	1 - Color	313	N/A	N/A	N/A	82.7	17.2	10.3	6	1.86	1.38	46	30	23	30.5	7.6	4.2	90	30	22.5
	2 - Clear	313	N/A	N/A	N/A	82.7	17.2	10.3	6	1.86	1.38	46	30	23	30.5	7.6	4.2	90	30	22.5
HVLP I-Beam	1 - Color	313	N/A	N/A	N/A	82.7	17.2	10.3	6	1.86	1.38	46	30	23	30.5	7.6	4.2	90	30	22.5
	2 - Clear	313	N/A	N/A	N/A	82.7	17.2	10.3	6	1.86	1.38	46	30	23	30.5	7.6	4.2	90	30	22.5
I Beam	1 - Color	415	N/A	N/A	N/A	103.4	17.2	10.3	6	1.86	1.38	46	30	23	30.5	7.6	4.2	90	30	22.5
	2 - Clear	415	N/A	N/A	N/A	103.4	17.2	10.3	6	1.86	1.38	46	30	23	30.5	7.6	4.2	90	30	22.5
Large Set Panel	1 - Color	517	N/A	N/A	N/A	144.8	17.2	10.3	6	1.68	1.2	46	30	21	30.5	7.6	3.8	90	25	17.5
	2 - Clear	517	N/A	N/A	N/A	144.8	17.2	10.3	6	1.68	1.2	46	30	21	30.5	7.6	3.8	90	25	17.5
Lattice	1 - Color	313	N/A	N/A	N/A	82.7	17.2	10.3	6	1.86	1.38	46	30	24	30.5	7.6	4.6	90	35	25
	2 - Clear	313	N/A	N/A	N/A	82.7	17.2	10.3	6	1.86	1.38	46	30	24	30.5	7.6	4.6	90	35	25
Motorcycle Fender	1 - Color	313	N/A	N/A	N/A	82.7	17.2	10.3	6	1.86	1.38	46	30	23	30.5	7.6	4.2	90	30	22.5
	2 - Clear	313	N/A	N/A	N/A	82.7	17.2	10.3	6	1.86	1.38	46	30	23	30.5	7.6	4.2	90	30	22.5
Pylon Exterior	1 - Color	415	N/A	N/A	N/A	103.4	17.2	10.3	6	1.86	1.38	46	30	23	30.5	7.6	4.2	90	30	22.5
	2 - Clear	415	N/A	N/A	N/A	103.4	17.2	10.3	6	1.86	1.38	46	30	23	30.5	7.6	4.2	90	30	22.5
Pylon Interior	1 - Color	415	N/A	N/A	N/A	103.4	17.2	10.3	6	1.86	1.38	46	30	23	30.5	7.6	4.2	90	30	22.5
	2 - Clear	415	N/A	N/A	N/A	103.4	17.2	10.3	6	1.86	1.38	46	30	23	30.5	7.6	4.2	90	30	22.5
Strut Panel	1 - Color	415	N/A	N/A	N/A	103.4	17.2	10.3	6	1.68	1.2	46	30	21	30.5	7.6	3.8	90	25	17.5
	2 - Clear	415	N/A	N/A	N/A	103.4	17.2	10.3	6	1.68	1.2	46	30	21	30.5	7.6	3.8	90	25	17.5
Vertical Panel	1 - Color	517	N/A	N/A	N/A	144.8	17.2	10.3	6	1.68	1.2	46	30	21	30.5	7.6	3.8	90	25	17.5
	2 - Clear	517	N/A	N/A	N/A	144.8	17.2	10.3	6	1.68	1.2	46	30	21	30.5	7.6	3.8	90	25	17.5
Vertical Piece	1 - Color	517	N/A	N/A	N/A	144.8	17.2	10.3	6	1.68	1.2	46	30	21	30.5	7.6	3.8	90	25	17.5
	2 - Clear	517	N/A	N/A	N/A	144.8	17.2	10.3	6	1.68	1.2	46	30	21	30.5	7.6	3.8	90	25	17.5
Wavy Panel	1 - Color	313	N/A	N/A	N/A	82.7	17.2	10.3	6	1.68	1.2	46	30	21	30.5	7.6	3.8	90	25	17.5
	2 - Clear	313	N/A	N/A	N/A	82.7	17.2	10.3	6	1.68	1.2	46	30	21	30.5	7.6	3.8	90	25	17.5

AIRLESS																			Metric	
PART	COAT	TIP SIZE	AIR PRESSURE (bar)			FLUID PRESSURE (bar)			MIL THICKNESS (mil)			SPEED (cm/s)			DISTANCE TO PART (cm)			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 (±)
Wing Panel	1 - Color	517	N/A	N/A	N/A	144.8	17.2	10.3	6	1.68	1.2	46	30	21	30.5	7.6	3.8	90	25	17.5
	2 - Clear	517	N/A	N/A	N/A	144.8	17.2	10.3	6	1.68	1.2	46	30	21	30.5	7.6	3.8	90	25	17.5
Wood Panel	1 - Color	517	N/A	N/A	N/A	144.8	17.2	10.3	6	1.68	1.2	46	30	21	30.5	7.6	3.8	90	25	17.5
	2 - Clear	517	N/A	N/A	N/A	144.8	17.2	10.3	6	1.68	1.2	46	30	21	30.5	7.6	3.8	90	25	17.5
AIRLESS CONVEYOR																			Metric	
PART	COAT	TIP SIZE	AIR PRESSURE (bar)			FLUID PRESSURE (bar)			MIL THICKNESS (mil)			SPEED (cm/s)			DISTANCE TO PART (cm)			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 (±)
Bookshelf	1- Color	415	N/A	N/A	N/A	103.4	17.2	10.3	6	2.04	1.56	46	30	24	30.5	7.6	4.6	90	35	25
Cabinet Door	1- Color	415	N/A	N/A	N/A	103.4	17.2	10.3	6	1.86	1.38	46	30	23	30.5	7.6	4.2	90	30	22.5
Cabinet Drawer	1- Color	415	N/A	N/A	N/A	103.4	17.2	10.3	6	1.86	1.38	46	30	23	30.5	7.6	4.2	90	30	22.5
Cabinet Frame Large	1- Color	415	N/A	N/A	N/A	103.4	17.2	10.3	6	2.04	1.56	46	30	24	30.5	7.6	4.6	90	35	25
Cabinet Frame Medium	1- Color	415	N/A	N/A	N/A	103.4	17.2	10.3	6	2.04	1.56	46	30	24	30.5	7.6	4.6	90	35	25
Cabinet Frame Small	1- Color	415	N/A	N/A	N/A	103.4	17.2	10.3	6	2.04	1.56	46	30	24	30.5	7.6	4.6	90	35	25
Car Bumper	1 - Color	313	N/A	N/A	N/A	82.7	17.2	10.3	6	2.04	1.56	46	30	24	30.5	7.6	4.6	90	35	25
Car Door	1 - Color	313	N/A	N/A	N/A	82.7	17.2	10.3	6	1.68	1.2	46	30	21	30.5	7.6	3.8	90	25	17.5
Car Fender	1 - Color	313	N/A	N/A	N/A	82.7	17.2	10.3	6	1.68	1.2	46	30	21	30.5	7.6	3.8	90	25	17.5
Car Hood	1 - Color	415	N/A	N/A	N/A	103.4	17.2	10.3	6	1.68	1.2	46	30	21	30.5	7.6	3.8	90	25	17.5
Flat Panel	1 - Color	517	N/A	N/A	N/A	144.8	17.2	10.3	6	1.68	1.2	46	30	21	30.5	7.6	3.8	90	25	17.5
Fridge End Panel	1 - Color	517	N/A	N/A	N/A	144.8	17.2	10.3	6	1.68	1.2	46	30	21	30.5	7.6	3.8	90	25	17.5
Headboard	1 - Color	517	N/A	N/A	N/A	144.8	17.2	10.3	6	1.68	1.2	46	30	21	30.5	7.6	3.8	90	25	17.5
Lattice	1 - Color	313	N/A	N/A	N/A	82.7	17.2	10.3	6	2.04	1.56	46	30	24	30.5	7.6	4.6	90	35	25
Motorcycle Fender	1 - Color	313	N/A	N/A	N/A	82.7	17.2	10.3	6	1.86	1.38	46	30	23	30.5	7.6	4.2	90	30	22.5
Vertical Panel	1 - Color	517	N/A	N/A	N/A	144.8	17.2	10.3	6	1.68	1.2	46	30	21	30.5	7.6	3.8	90	25	17.5
Vertical Piece	1 - Color	517	N/A	N/A	N/A	144.8	17.2	10.3	6	1.68	1.2	46	30	21	30.5	7.6	3.8	90	25	17.5
Wavy Panel	1 - Color	313	N/A	N/A	N/A	82.7	17.2	10.3	6	1.68	1.2	46	30	21	30.5	7.6	3.8	90	25	17.5
Wood Panel	1 - Color	517	N/A	N/A	N/A	144.8	17.2	10.3	6	1.68	1.2	46	30	21	30.5	7.6	3.8	90	25	17.5

BLASTING														Metric
PART	COAT	MEDIA	AIR PRESSURE (bar)		FLUID PRESSURE (bar)		MIL THICKNESS (mil)		SPEED (cm/s)		DISTANCE TO PART (cm)		TRAVEL ANGLE (°)	
			Setting	Tolerance	Setting	Tolerance	Setting	Tolerance	Setting	Tolerance	Setting	Tolerance	Minimum	Maximum
ACQPA Panel	1 - Color	Sodium Bicarbonate	N/A	N/A	N/A	N/A	3.5	1.64	N/A	N/A	53.3	12.7	5	45
	1 - Color	Garnet	N/A	N/A	N/A	N/A	3.5	1.64	N/A	N/A	53.3	12.7	5	45
	1 - Color	Steel Grit	N/A	N/A	N/A	N/A	3.5	1.64	N/A	N/A	53.3	12.7	5	45
ACQPA Panel Cylinder	1 - Color	Sodium Bicarbonate	N/A	N/A	N/A	N/A	3.5	1.64	N/A	N/A	53.3	12.7	5	45
	1 - Color	Garnet	N/A	N/A	N/A	N/A	3.5	1.64	N/A	N/A	53.3	12.7	5	45
	1 - Color	Steel Grit	N/A	N/A	N/A	N/A	3.5	1.64	N/A	N/A	53.3	12.7	5	45
ACQPA Panel Horizontal	1 - Color	Sodium Bicarbonate	N/A	N/A	N/A	N/A	3.5	1.64	N/A	N/A	53.3	12.7	5	45
	1 - Color	Garnet	N/A	N/A	N/A	N/A	3.5	1.64	N/A	N/A	53.3	12.7	5	45
	1 - Color	Steel Grit	N/A	N/A	N/A	N/A	3.5	1.64	N/A	N/A	53.3	12.7	5	45
ACQPA Panel Vertical	1 - Color	Sodium Bicarbonate	N/A	N/A	N/A	N/A	3.5	1.64	N/A	N/A	53.3	12.7	5	45
	1 - Color	Garnet	N/A	N/A	N/A	N/A	3.5	1.64	N/A	N/A	53.3	12.7	5	45
	1 - Color	Steel Grit	N/A	N/A	N/A	N/A	3.5	1.64	N/A	N/A	53.3	12.7	5	45
ASTM Deep T	1 - Color	Sodium Bicarbonate	N/A	N/A	N/A	N/A	3.5	1.64	N/A	N/A	53.3	12.7	5	45
	1 - Color	Garnet	N/A	N/A	N/A	N/A	3.5	1.64	N/A	N/A	53.3	12.7	5	45
	1 - Color	Steel Grit	N/A	N/A	N/A	N/A	3.5	1.64	N/A	N/A	53.3	12.7	5	45
ASTM H Beam	1 - Color	Sodium Bicarbonate	N/A	N/A	N/A	N/A	3.5	1.64	N/A	N/A	53.3	12.7	5	45
	1 - Color	Garnet	N/A	N/A	N/A	N/A	3.5	1.64	N/A	N/A	53.3	12.7	5	45
	1 - Color	Steel Grit	N/A	N/A	N/A	N/A	3.5	1.64	N/A	N/A	53.3	12.7	5	45
ASTM Panel	1 - Color	Sodium Bicarbonate	N/A	N/A	N/A	N/A	3.5	1.64	N/A	N/A	53.3	12.7	5	45
	1 - Color	Garnet	N/A	N/A	N/A	N/A	3.5	1.64	N/A	N/A	53.3	12.7	5	45
	1 - Color	Steel Grit	N/A	N/A	N/A	N/A	3.5	1.64	N/A	N/A	53.3	12.7	5	45
ASTM Pipe	1 - Color	Sodium Bicarbonate	N/A	N/A	N/A	N/A	3.5	1.64	N/A	N/A	53.3	12.7	5	45
	1 - Color	Garnet	N/A	N/A	N/A	N/A	3.5	1.64	N/A	N/A	53.3	12.7	5	45
	1 - Color	Steel Grit	N/A	N/A	N/A	N/A	3.5	1.64	N/A	N/A	53.3	12.7	5	45
Bridge Section	1 - Color	Sodium Bicarbonate	N/A	N/A	N/A	N/A	3.5	1.64	N/A	N/A	53.3	12.7	5	45
	1 - Color	Garnet	N/A	N/A	N/A	N/A	3.5	1.64	N/A	N/A	53.3	12.7	5	45
	1 - Color	Steel Grit	N/A	N/A	N/A	N/A	3.5	1.64	N/A	N/A	53.3	12.7	5	45
Car Bumper	1 - Color	Sodium Bicarbonate	N/A	N/A	N/A	N/A	3.5	1.64	N/A	N/A	53.3	12.7	5	45
	1 - Color	Garnet	N/A	N/A	N/A	N/A	3.5	1.64	N/A	N/A	53.3	12.7	5	45
	1 - Color	Steel Grit	N/A	N/A	N/A	N/A	3.5	1.64	N/A	N/A	53.3	12.7	5	45
Car Door	1 - Color	Sodium Bicarbonate	N/A	N/A	N/A	N/A	3.5	1.37	N/A	N/A	53.3	7.6	5	45
	1 - Color	Garnet	N/A	N/A	N/A	N/A	3.5	1.37	N/A	N/A	53.3	7.6	5	45
	1 - Color	Steel Grit	N/A	N/A	N/A	N/A	3.5	1.37	N/A	N/A	53.3	7.6	5	45
Car Fender	1 - Color	Sodium Bicarbonate	N/A	N/A	N/A	N/A	3.5	1.5	N/A	N/A	53.3	10.2	5	45
	1 - Color	Garnet	N/A	N/A	N/A	N/A	3.5	1.5	N/A	N/A	53.3	10.2	5	45
	1 - Color	Steel Grit	N/A	N/A	N/A	N/A	3.5	1.5	N/A	N/A	53.3	10.2	5	45
Car Hood	1 - Color	Sodium Bicarbonate	N/A	N/A	N/A	N/A	3.5	1.37	N/A	N/A	53.3	7.6	5	45
	1 - Color	Garnet	N/A	N/A	N/A	N/A	3.5	1.37	N/A	N/A	53.3	7.6	5	45
	1 - Color	Steel Grit	N/A	N/A	N/A	N/A	3.5	1.37	N/A	N/A	53.3	7.6	5	45
Flat Panel	1 - Color	Sodium Bicarbonate	N/A	N/A	N/A	N/A	3.5	1.37	N/A	N/A	53.3	7.6	5	45
	1 - Color	Garnet	N/A	N/A	N/A	N/A	3.5	1.37	N/A	N/A	53.3	7.6	5	45
	1 - Color	Steel Grit	N/A	N/A	N/A	N/A	3.5	1.37	N/A	N/A	53.3	7.6	5	45

BLASTING														Metric
PART	COAT	MEDIA	AIR PRESSURE (bar)		FLUID PRESSURE (bar)		MIL THICKNESS (mil)		SPEED (cm/s)		DISTANCE TO PART (cm)		TRAVEL ANGLE (°)	
			Setting	Tolerance	Setting	Tolerance	Setting	Tolerance	Setting	Tolerance	Setting	Tolerance	Minimum	Maximum
Gas Tank	1 - Color	Sodium Bicarbonate	N/A	N/A	N/A	N/A	3.5	1.64	N/A	N/A	53.3	12.7	5	45
	1 - Color	Garnet	N/A	N/A	N/A	N/A	3.5	1.64	N/A	N/A	53.3	12.7	5	45
	1 - Color	Steel Grit	N/A	N/A	N/A	N/A	3.5	1.64	N/A	N/A	53.3	12.7	5	45
Half Barrel	1 - Color	Sodium Bicarbonate	N/A	N/A	N/A	N/A	3.5	1.5	N/A	N/A	53.3	10.2	5	45
	1 - Color	Garnet	N/A	N/A	N/A	N/A	3.5	1.5	N/A	N/A	53.3	10.2	5	45
	1 - Color	Steel Grit	N/A	N/A	N/A	N/A	3.5	1.5	N/A	N/A	53.3	10.2	5	45
H Beam	1 - Color	Sodium Bicarbonate	N/A	N/A	N/A	N/A	3.5	1.5	N/A	N/A	53.3	10.2	5	45
	1 - Color	Garnet	N/A	N/A	N/A	N/A	3.5	1.5	N/A	N/A	53.3	10.2	5	45
	1 - Color	Steel Grit	N/A	N/A	N/A	N/A	3.5	1.5	N/A	N/A	53.3	10.2	5	45
Horizontal Car Hood	1 - Color	Sodium Bicarbonate	N/A	N/A	N/A	N/A	3.5	1.37	N/A	N/A	53.3	7.6	5	45
	1 - Color	Garnet	N/A	N/A	N/A	N/A	3.5	1.37	N/A	N/A	53.3	7.6	5	45
	1 - Color	Steel Grit	N/A	N/A	N/A	N/A	3.5	1.37	N/A	N/A	53.3	7.6	5	45
Horizontal Wagon Roof	1 - Color	Sodium Bicarbonate	N/A	N/A	N/A	N/A	3.5	1.37	N/A	N/A	53.3	7.6	5	45
	1 - Color	Garnet	N/A	N/A	N/A	N/A	3.5	1.37	N/A	N/A	53.3	7.6	5	45
	1 - Color	Steel Grit	N/A	N/A	N/A	N/A	3.5	1.37	N/A	N/A	53.3	7.6	5	45
HVLP H Beam	1 - Color	Sodium Bicarbonate	N/A	N/A	N/A	N/A	3.5	1.5	N/A	N/A	53.3	10.2	5	45
	1 - Color	Garnet	N/A	N/A	N/A	N/A	3.5	1.5	N/A	N/A	53.3	10.2	5	45
	1 - Color	Steel Grit	N/A	N/A	N/A	N/A	3.5	1.5	N/A	N/A	53.3	10.2	5	45
HVLP I Beam	1 - Color	Sodium Bicarbonate	N/A	N/A	N/A	N/A	3.5	1.5	N/A	N/A	53.3	10.2	5	45
	1 - Color	Garnet	N/A	N/A	N/A	N/A	3.5	1.5	N/A	N/A	53.3	10.2	5	45
	1 - Color	Steel Grit	N/A	N/A	N/A	N/A	3.5	1.5	N/A	N/A	53.3	10.2	5	45
I Beam	1 - Color	Sodium Bicarbonate	N/A	N/A	N/A	N/A	3.5	1.5	N/A	N/A	53.3	10.2	5	45
	1 - Color	Garnet	N/A	N/A	N/A	N/A	3.5	1.5	N/A	N/A	53.3	10.2	5	45
	1 - Color	Steel Grit	N/A	N/A	N/A	N/A	3.5	1.5	N/A	N/A	53.3	10.2	5	45
Large Set Panel	1 - Color	Sodium Bicarbonate	N/A	N/A	N/A	N/A	3.5	1.37	N/A	N/A	53.3	7.6	5	45
	1 - Color	Garnet	N/A	N/A	N/A	N/A	3.5	1.37	N/A	N/A	53.3	7.6	5	45
	1 - Color	Steel Grit	N/A	N/A	N/A	N/A	3.5	1.37	N/A	N/A	53.3	7.6	5	45
Motorcycle Fender	1 - Color	Sodium Bicarbonate	N/A	N/A	N/A	N/A	3.5	1.5	N/A	N/A	53.3	10.2	5	45
	1 - Color	Garnet	N/A	N/A	N/A	N/A	3.5	1.5	N/A	N/A	53.3	10.2	5	45
	1 - Color	Steel Grit	N/A	N/A	N/A	N/A	3.5	1.5	N/A	N/A	53.3	10.2	5	45
Vertical Panel	1 - Color	Sodium Bicarbonate	N/A	N/A	N/A	N/A	3.5	1.37	N/A	N/A	53.3	7.6	5	45
	1 - Color	Garnet	N/A	N/A	N/A	N/A	3.5	1.37	N/A	N/A	53.3	7.6	5	45
	1 - Color	Steel Grit	N/A	N/A	N/A	N/A	3.5	1.37	N/A	N/A	53.3	7.6	5	45
Vertical Piece	1 - Color	Sodium Bicarbonate	N/A	N/A	N/A	N/A	3.5	1.37	N/A	N/A	53.3	7.6	5	45
	1 - Color	Garnet	N/A	N/A	N/A	N/A	3.5	1.37	N/A	N/A	53.3	7.6	5	45
	1 - Color	Steel Grit	N/A	N/A	N/A	N/A	3.5	1.37	N/A	N/A	53.3	7.6	5	45
Wavy Panel	1 - Color	Sodium Bicarbonate	N/A	N/A	N/A	N/A	3.5	1.37	N/A	N/A	53.3	7.6	5	45
	1 - Color	Garnet	N/A	N/A	N/A	N/A	3.5	1.37	N/A	N/A	53.3	7.6	5	45
	1 - Color	Steel Grit	N/A	N/A	N/A	N/A	3.5	1.37	N/A	N/A	53.3	7.6	5	45



HVLP																			Metric	
PART	COAT	TIP SIZE	AIR PRESSURE (bar)			FLUID PRESSURE (bar)			MIL THICKNESS (mil)			SPEED (cm/s)			DISTANCE TO PART (cm)			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	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	1.6	0.54	0.42	46	30	24	20.3	7.6	4.6	90	35	25
	2 - Clear	1.2	2.4	0.7	0.6	N/A	N/A	N/A	1.6	0.54	0.42	46	30	24	20.3	7.6	4.6	90	35	25
ACQPA Panel Cylinder	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	1.6	0.54	0.42	46	30	24	20.3	7.6	4.6	90	35	25
	2 - Clear	1.2	2.4	0.7	0.6	N/A	N/A	N/A	1.6	0.54	0.42	46	30	24	20.3	7.6	4.6	90	35	25
ACQPA Panel Horizontal	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	1.6	0.54	0.42	46	30	24	20.3	7.6	4.6	90	35	25
	2 - Clear	1.2	2.4	0.7	0.6	N/A	N/A	N/A	1.6	0.54	0.42	46	30	24	20.3	7.6	4.6	90	35	25
ACQPA Panel Vertical	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	1.6	0.54	0.42	46	30	24	20.3	7.6	4.6	90	35	25
	2 - Clear	1.2	2.4	0.7	0.6	N/A	N/A	N/A	1.6	0.54	0.42	46	30	24	20.3	7.6	4.6	90	35	25
ASTM Deep T	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	1.6	0.54	0.42	46	30	24	20.3	7.6	4.6	90	35	25
	2 - Clear	1.2	2.4	0.7	0.6	N/A	N/A	N/A	1.6	0.54	0.42	46	30	24	20.3	7.6	4.6	90	35	25
ASTM H Beam	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	1.6	0.54	0.42	46	30	24	20.3	7.6	4.6	90	35	25
	2 - Clear	1.2	2.4	0.7	0.6	N/A	N/A	N/A	1.6	0.54	0.42	46	30	24	20.3	7.6	4.6	90	35	25
ASTM Panel	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	1.6	0.54	0.42	46	30	24	20.3	7.6	4.6	90	35	25
	2 - Clear	1.2	2.4	0.7	0.6	N/A	N/A	N/A	1.6	0.54	0.42	46	30	24	20.3	7.6	4.6	90	35	25
ASTM Pipe	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	1.6	0.54	0.42	46	30	24	20.3	7.6	4.6	90	35	25
	2 - Clear	1.2	2.4	0.7	0.6	N/A	N/A	N/A	1.6	0.54	0.42	46	30	24	20.3	7.6	4.6	90	35	25
Bookshelf	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	1.6	0.54	0.42	46	30	24	20.3	7.6	4.6	90	35	25
	2 - Clear	1.2	2.4	0.7	0.6	N/A	N/A	N/A	1.6	0.54	0.42	46	30	24	20.3	7.6	4.6	90	35	25
Bridge Section	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	1.6	0.54	0.42	46	30	24	20.3	7.6	4.6	90	35	25
	2 - Clear	1.2	2.4	0.7	0.6	N/A	N/A	N/A	1.6	0.54	0.42	46	30	24	20.3	7.6	4.6	90	35	25
Cabinet Door	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	1.6	0.5	0.37	46	30	23	20.3	7.6	4.2	90	30	22.5
	2 - Clear	1.2	2.4	0.7	0.6	N/A	N/A	N/A	1.6	0.5	0.37	46	30	23	20.3	7.6	4.2	90	30	22.5
Cabinet Drawer	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	1.6	0.5	0.37	46	30	23	20.3	7.6	4.2	90	30	22.5
	2 - Clear	1.2	2.4	0.7	0.6	N/A	N/A	N/A	1.6	0.5	0.37	46	30	23	20.3	7.6	4.2	90	30	22.5
Cabinet Frame Large	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	1.6	0.54	0.42	46	30	24	20.3	7.6	4.6	90	35	25
	2 - Clear	1.2	2.4	0.7	0.6	N/A	N/A	N/A	1.6	0.54	0.42	46	30	24	20.3	7.6	4.6	90	35	25
Cabinet Frame Medium	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	1.6	0.54	0.42	46	30	24	20.3	7.6	4.6	90	35	25
	2 - Clear	1.2	2.4	0.7	0.6	N/A	N/A	N/A	1.6	0.54	0.42	46	30	24	20.3	7.6	4.6	90	35	25
Cabinet Frame Small	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	1.6	0.54	0.42	46	30	24	20.3	7.6	4.6	90	35	25
	2 - Clear	1.2	2.4	0.7	0.6	N/A	N/A	N/A	1.6	0.54	0.42	46	30	24	20.3	7.6	4.6	90	35	25
Car Bumper	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	1.6	0.54	0.42	46	30	24	20.3	7.6	4.6	90	35	25
	2 - Clear	1.2	2.4	0.7	0.6	N/A	N/A	N/A	1.6	0.54	0.42	46	30	24	20.3	7.6	4.6	90	35	25
Car Door	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	1.6	0.45	0.32	46	30	21	20.3	7.6	3.8	90	25	17.5
	2 - Clear	1.2	2.4	0.7	0.6	N/A	N/A	N/A	1.6	0.45	0.32	46	30	21	20.3	7.6	3.8	90	25	17.5
Car Fender	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	1.6	0.5	0.37	46	30	23	20.3	7.6	4.2	90	30	22.5
	2 - Clear	1.2	2.4	0.7	0.6	N/A	N/A	N/A	1.6	0.5	0.37	46	30	23	20.3	7.6	4.2	90	30	22.5
Car Hood	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	1.6	0.45	0.32	46	30	21	20.3	7.6	3.8	90	25	17.5
	2 - Clear	1.2	2.4	0.7	0.6	N/A	N/A	N/A	1.6	0.45	0.32	46	30	21	20.3	7.6	3.8	90	25	17.5
Dining Chair	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	1.6	0.5	0.37	46	30	23	20.3	7.6	4.2	90	30	22.5
	2 - Clear	1.2	2.4	0.7	0.6	N/A	N/A	N/A	1.6	0.5	0.37	46	30	23	20.3	7.6	4.2	90	30	22.5
Dining Table	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	1.6	0.5	0.37	46	30	23	20.3	7.6	4.2	90	30	22.5
	2 - Clear	1.2	2.4	0.7	0.6	N/A	N/A	N/A	1.6	0.5	0.37	46	30	23	20.3	7.6	4.2	90	30	22.5

HVLP																				Metric
PART	COAT	TIP SIZE	AIR PRESSURE (bar)			FLUID PRESSURE (bar)			MIL THICKNESS (mil)			SPEED (cm/s)			DISTANCE TO PART (cm)			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 (±)
Engine Cowling	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	1.6	0.45	0.32	46	30	21	20.3	7.6	3.8	90	25	17.5
	2 - Clear	1.2	2.4	0.7	0.6	N/A	N/A	N/A	1.6	0.45	0.32	46	30	21	20.3	7.6	3.8	90	25	17.5
Flat Panel	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	1.6	0.45	0.32	46	30	21	20.3	7.6	3.8	90	25	17.5
	2 - Clear	1.2	2.4	0.7	0.6	N/A	N/A	N/A	1.6	0.45	0.32	46	30	21	20.3	7.6	3.8	90	25	17.5
Fridge End Panel	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	1.6	0.45	0.32	46	30	21	20.3	7.6	3.8	90	25	17.5
	2 - Clear	1.2	2.4	0.7	0.6	N/A	N/A	N/A	1.6	0.45	0.32	46	30	21	20.3	7.6	3.8	90	25	17.5
Gas Tank	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	1.6	0.54	0.42	46	30	24	20.3	7.6	4.6	90	35	25
	2 - Clear	1.2	2.4	0.7	0.6	N/A	N/A	N/A	1.6	0.54	0.42	46	30	24	20.3	7.6	4.6	90	35	25
Half Barrel	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	1.6	0.5	0.37	46	30	23	20.3	7.6	4.2	90	30	22.5
	2 - Clear	1.2	2.4	0.7	0.6	N/A	N/A	N/A	1.6	0.5	0.37	46	30	23	20.3	7.6	4.2	90	30	22.5
H Beam	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	1.6	0.5	0.37	46	30	23	20.3	7.6	4.2	90	30	22.5
	2 - Clear	1.2	2.4	0.7	0.6	N/A	N/A	N/A	1.6	0.5	0.37	46	30	23	20.3	7.6	4.2	90	30	22.5
Headboard	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	1.6	0.45	0.32	46	30	21	20.3	7.6	3.8	90	25	17.5
	2 - Clear	1.2	2.4	0.7	0.6	N/A	N/A	N/A	1.6	0.45	0.32	46	30	21	20.3	7.6	3.8	90	25	17.5
Horizontal Car Hood	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	1.6	0.45	0.32	46	30	21	20.3	7.6	3.8	90	25	17.5
	2 - Clear	1.2	2.4	0.7	0.6	N/A	N/A	N/A	1.6	0.45	0.32	46	30	21	20.3	7.6	3.8	90	25	17.5
Horizontal Wagon Roof	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	1.6	0.45	0.32	46	30	21	20.3	7.6	3.8	90	25	17.5
	2 - Clear	1.2	2.4	0.7	0.6	N/A	N/A	N/A	1.6	0.45	0.32	46	30	21	20.3	7.6	3.8	90	25	17.5
HVLP H-Beam	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	1.6	0.5	0.37	46	30	23	20.3	7.6	4.2	90	30	22.5
	2 - Clear	1.2	2.4	0.7	0.6	N/A	N/A	N/A	1.6	0.5	0.37	46	30	23	20.3	7.6	4.2	90	30	22.5
HVLP I-Beam	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	1.6	0.5	0.37	46	30	23	20.3	7.6	4.2	90	30	22.5
	2 - Clear	1.2	2.4	0.7	0.6	N/A	N/A	N/A	1.6	0.5	0.37	46	30	23	20.3	7.6	4.2	90	30	22.5
I Beam	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	1.6	0.5	0.37	46	30	23	20.3	7.6	4.2	90	30	22.5
	2 - Clear	1.2	2.4	0.7	0.6	N/A	N/A	N/A	1.6	0.5	0.37	46	30	23	20.3	7.6	4.2	90	30	22.5
Large Set Panel	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	1.6	0.45	0.32	46	30	21	20.3	7.6	3.8	90	25	17.5
	2 - Clear	1.2	2.4	0.7	0.6	N/A	N/A	N/A	1.6	0.45	0.32	46	30	21	20.3	7.6	3.8	90	25	17.5
Lattice	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	1.6	0.54	0.42	46	30	24	20.3	7.6	4.6	90	35	25
	2 - Clear	1.2	2.4	0.7	0.6	N/A	N/A	N/A	1.6	0.54	0.42	46	30	24	20.3	7.6	4.6	90	35	25
Motorcycle Fender	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	1.6	0.5	0.37	46	30	23	20.3	7.6	4.2	90	30	22.5
	2 - Clear	1.2	2.4	0.7	0.6	N/A	N/A	N/A	1.6	0.5	0.37	46	30	23	20.3	7.6	4.2	90	30	22.5
Pylon Exterior	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	1.6	0.5	0.37	46	30	23	20.3	7.6	4.2	90	30	22.5
	2 - Clear	1.2	2.4	0.7	0.6	N/A	N/A	N/A	1.6	0.5	0.37	46	30	23	20.3	7.6	4.2	90	30	22.5
Pylon Interior	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	1.6	0.5	0.37	46	30	23	20.3	7.6	4.2	90	30	22.5
	2 - Clear	1.2	2.4	0.7	0.6	N/A	N/A	N/A	1.6	0.5	0.37	46	30	23	20.3	7.6	4.2	90	30	22.5
Strut Panel	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	1.6	0.45	0.32	46	30	21	20.3	7.6	3.8	90	25	17.5
	2 - Clear	1.2	2.4	0.7	0.6	N/A	N/A	N/A	1.6	0.45	0.32	46	30	21	20.3	7.6	3.8	90	25	17.5
Vertical Panel	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	1.6	0.45	0.32	46	30	21	20.3	7.6	3.8	90	25	17.5
	2 - Clear	1.2	2.4	0.7	0.6	N/A	N/A	N/A	1.6	0.45	0.32	46	30	21	20.3	7.6	3.8	90	25	17.5
Vertical Piece	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	1.6	0.45	0.32	46	30	21	20.3	7.6	3.8	90	25	17.5
	2 - Clear	1.2	2.4	0.7	0.6	N/A	N/A	N/A	1.6	0.45	0.32	46	30	21	20.3	7.6	3.8	90	25	17.5
Wavy Panel	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	1.6	0.45	0.32	46	30	21	20.3	7.6	3.8	90	25	17.5
	2 - Clear	1.2	2.4	0.7	0.6	N/A	N/A	N/A	1.6	0.45	0.32	46	30	21	20.3	7.6	3.8	90	25	17.5

HVLP																			Metric	
PART	COAT	TIP SIZE	AIR PRESSURE (bar)			FLUID PRESSURE (bar)			MIL THICKNESS (mil)			SPEED (cm/s)			DISTANCE TO PART (cm)			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 (±)
Wing Panel	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	1.6	0.45	0.32	46	30	21	20.3	7.6	3.8	90	25	17.5
	2 - Clear	1.2	2.4	0.7	0.6	N/A	N/A	N/A	1.6	0.45	0.32	46	30	21	20.3	7.6	3.8	90	25	17.5
Wood Panel	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	1.6	0.45	0.32	46	30	21	20.3	7.6	3.8	90	25	17.5
	2 - Clear	1.2	2.4	0.7	0.6	N/A	N/A	N/A	1.6	0.45	0.32	46	30	21	20.3	7.6	3.8	90	25	17.5
HVLP CONVEYOR																			Metric	
PART	COAT	TIP SIZE	AIR PRESSURE (bar)			FLUID PRESSURE (bar)			MIL THICKNESS (mil)			SPEED (cm/s)			DISTANCE TO PART (cm)			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 (±)
Bookshelf	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	1.6	0.54	0.42	46	30	24	20.3	7.6	4.6	90	35	25
Cabinet Door	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	1.6	0.5	0.37	46	30	23	20.3	7.6	4.2	90	30	22.5
Cabinet Drawer	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	1.6	0.5	0.37	46	30	23	20.3	7.6	4.2	90	30	22.5
Cabinet Frame Large	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	1.6	0.54	0.42	46	30	24	20.3	7.6	4.6	90	35	25
Cabinet Frame Medium	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	1.6	0.54	0.42	46	30	24	20.3	7.6	4.6	90	35	25
Cabinet Frame Small	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	1.6	0.54	0.42	46	30	24	20.3	7.6	4.6	90	35	25
Car Bumper	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	1.6	0.54	0.42	46	30	24	20.3	7.6	4.6	90	35	25
Car Door	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	1.6	0.45	0.32	46	30	21	20.3	7.6	3.8	90	25	17.5
Car Fender	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	1.6	0.45	0.32	46	30	21	20.3	7.6	3.8	90	25	17.5
Car Hood	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	1.6	0.45	0.32	46	30	21	20.3	7.6	3.8	90	25	17.5
Flat Panel	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	1.6	0.45	0.32	46	30	21	20.3	7.6	3.8	90	25	17.5
Fridge End Panel	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	1.6	0.45	0.32	46	30	21	20.3	7.6	3.8	90	25	17.5
Headboard	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	1.6	0.45	0.32	46	30	21	20.3	7.6	3.8	90	25	17.5
Lattice	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	1.6	0.54	0.42	46	30	24	20.3	7.6	4.6	90	35	25
Motorcycle Fender	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	1.6	0.5	0.37	46	30	23	20.3	7.6	4.2	90	30	22.5
Vertical Panel	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	1.6	0.45	0.32	46	30	21	20.3	7.6	3.8	90	25	17.5
Vertical Piece	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	1.6	0.45	0.32	46	30	21	20.3	7.6	3.8	90	25	17.5
Wavy Panel	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	1.6	0.45	0.32	46	30	21	20.3	7.6	3.8	90	25	17.5
Wood Panel	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	1.6	0.45	0.32	46	30	21	20.3	7.6	3.8	90	25	17.5
HVLP EDGE BLENDING																			Metric	
PART	COAT	TIP SIZE	AIR PRESSURE (bar)			FLUID PRESSURE (bar)			MIL THICKNESS (mil)			SPEED (cm/s)			DISTANCE TO PART (cm)			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 Hood	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	1.6	0.45	0.35	46	30	21	20.3	7.6	N/A	90	25	17.5
Repair Car Door-Fender	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	1.6	0.45	0.35	46	30	21	20.3	7.6	N/A	90	25	17.5
Repair Vertical Panel	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	1.6	0.45	0.35	46	30	21	20.3	7.6	N/A	90	25	17.5

POWDER COATING																				Metric			
PART	COAT	TIP	CURRENT (µA)			POWDER DELIVERY (%)			TOTAL AIR (Nm <sup>3</sup> /h)			VOLTAGE (kV)			MIL THICKNESS (mil)			DISTANCE TO PART (cm)			TRAVEL ANGLE (°)		
			Setting	Tolerance		Setting	Tolerance		Setting	Tolerance		Setting	Tolerance		Setting	Tolerance		Setting	Tolerance		Setting	Tolerance	
				Easy (±)	Hard (±)		Easy (±)	Hard (±)		Easy (±)	Hard (±)		Easy (±)	Hard (±)		Easy (±)	Hard (±)		Easy (±)	Hard (±)		Easy (±)	Hard (±)
Acute Crease	1 - Color	Flat 45	60	10	10	50	10	10	50	10	10	65	15	15	2.55	1.5	1.5	20.3	7.6	7.6	90	25	25
Flat Panel	1 - Color	Flat 65	60	10	10	50	10	10	50	10	10	65	15	15	2.55	1.5	1.5	20.3	7.6	7.6	90	25	25
L Channels	1 - Color	Deflector	60	10	10	50	10	10	50	10	10	65	15	15	2.55	1.5	1.5	20.3	7.6	7.6	90	25	25
Panel Sampler	1 - Color	Flat 30	60	10	10	50	10	10	50	10	10	65	15	15	2.55	1.5	1.5	20.3	7.6	7.6	90	25	25
Propeller	1 - Color	Flat 50	60	10	10	50	10	10	50	10	10	65	15	15	2.55	1.5	1.5	20.3	7.6	7.6	90	25	25
Quarter Box Back	1 - Color	Flat 50	60	10	10	50	10	10	50	10	10	65	15	15	2.55	1.5	1.5	20.3	7.6	7.6	90	25	25
Quarter Box Front	1 - Color	Flat 50	60	10	10	50	10	10	50	10	10	65	15	15	2.55	1.5	1.5	20.3	7.6	7.6	90	25	25
U Channels Large	1 - Color	Deflector	60	10	10	50	10	10	50	10	10	65	15	15	2.55	1.5	1.5	20.3	7.6	7.6	90	25	25
U Channels Small	1 - Color	Deflector	60	10	10	50	10	10	50	10	10	65	15	15	2.55	1.5	1.5	20.3	7.6	7.6	90	25	25
Vertical Panel With Holes	1 - Color	Flat 65	60	10	10	50	10	10	50	10	10	65	15	15	2.55	1.5	1.5	20.3	7.6	7.6	90	25	25
Wavy Panel	1 - Color	Flat 50	60	10	10	50	10	10	50	10	10	65	15	15	2.55	1.5	1.5	20.3	7.6	7.6	90	25	25
POWDER COATING CONVEYOR																				Metric			
PART	COAT	TIP	CURRENT (µA)			POWDER DELIVERY (%)			TOTAL AIR (Nm <sup>3</sup> /h)			VOLTAGE (kV)			MIL THICKNESS (mil)			DISTANCE TO PART (cm)			TRAVEL ANGLE (°)		
			Setting	Tolerance		Setting	Tolerance		Setting	Tolerance		Setting	Tolerance		Setting	Tolerance		Setting	Tolerance		Setting	Tolerance	
				Easy (±)	Hard (±)		Easy (±)	Hard (±)		Easy (±)	Hard (±)		Easy (±)	Hard (±)		Easy (±)	Hard (±)		Easy (±)	Hard (±)		Easy (±)	Hard (±)
Acute Crease	1 - Color	Flat 50	60	10	10	50	10	10	50	10	10	65	15	15	2.55	1.5	1.5	20.3	7.6	7.6	90	25	25
Flat Panel	1 - Color	Fat 65	60	10	10	50	10	10	50	10	10	65	15	15	2.55	1.5	1.5	20.3	7.6	7.6	90	25	25
L Channels	1 - Color	Deflector	60	10	10	50	10	10	50	10	10	65	15	15	2.55	1.5	1.5	20.3	7.6	7.6	90	25	25
Panel Sampler	1 - Color	Flat 30	60	10	10	50	10	10	50	10	10	65	15	15	2.55	1.5	1.5	20.3	7.6	7.6	90	25	25
Propeller	1 - Color	Flat 50	60	10	10	50	10	10	50	10	10	65	15	15	2.55	1.5	1.5	20.3	7.6	7.6	90	25	25
Quarter Box Back	1 - Color	Flat 50	60	10	10	50	10	10	50	10	10	65	15	15	2.55	1.5	1.5	20.3	7.6	7.6	90	25	25
Quarter Box Front	1 - Color	Flat 50	60	10	10	50	10	10	50	10	10	65	15	15	2.55	1.5	1.5	20.3	7.6	7.6	90	25	25
U Channels Large	1 - Color	Deflector	60	10	10	50	10	10	50	10	10	65	15	15	2.55	1.5	1.5	20.3	7.6	7.6	90	25	25
U Channels Small	1 - Color	Deflector	60	10	10	50	10	10	50	10	10	65	15	15	2.55	1.5	1.5	20.3	7.6	7.6	90	25	25
Vertical Panel With Holes	1 - Color	Fat 65	60	10	10	50	10	10	50	10	10	65	15	15	2.55	1.5	1.5	20.3	7.6	7.6	90	25	25
Wavy Panel	1 - Color	Flat 50	60	10	10	50	10	10	50	10	10	65	15	15	2.55	1.5	1.5	20.3	7.6	7.6	90	25	25