

AIR-ASSISTED AIRLESS																			Metric	
PART	COAT	TIPSIZE	AIR PRESSURE (bar)			FLUID PRESSURE (bar)			DRY FILM THICKNESS (µm)			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	112	38	29	45	30	24	30	8	5	90	35.0	25.0
	2 - Clear	517	0.6	0.3	0.1	124.1	17.2	10.3	112	38	29	45	30	24	30	8	5	90	35.0	25.0
ACQPA Panel Cylinder	1 - Color	313	0.6	0.3	0.1	62.1	17.2	10.3	112	38	29	45	30	24	30	8	5	90	30.0	25.0
	2 - Clear	313	0.6	0.3	0.1	62.1	17.2	10.3	112	38	29	45	30	24	30	8	5	90	30.0	25.0
ACQPA Panel Horizontal	1 - Color	313	0.6	0.3	0.1	62.1	17.2	10.3	112	38	29	45	30	24	30	8	5	90	35.0	25.0
	2 - Clear	313	0.6	0.3	0.1	62.1	17.2	10.3	112	38	29	45	30	24	30	8	5	90	35.0	25.0
ACQPA Panel Vertical	1 - Color	313	0.6	0.3	0.1	62.1	17.2	10.3	112	38	29	45	30	24	30	8	5	90	30.0	25.0
	2 - Clear	313	0.6	0.3	0.1	62.1	17.2	10.3	112	38	29	45	30	24	30	8	5	90	30.0	25.0
ASTM Deep T	1 - Color	415	0.6	0.3	0.1	89.6	17.2	10.3	112	38	29	45	30	24	30	8	5	90	35.0	25.0
	2 - Clear	415	0.6	0.3	0.1	89.6	17.2	10.3	112	38	29	45	30	24	30	8	5	90	35.0	25.0
ASTM H Beam	1 - Color	415	0.6	0.3	0.1	89.6	17.2	10.3	112	38	29	45	30	24	30	8	5	90	30.0	25.0
	2 - Clear	415	0.6	0.3	0.1	89.6	17.2	10.3	112	38	29	45	30	24	30	8	5	90	30.0	25.0
ASTM Panel	1 - Color	415	0.6	0.3	0.1	89.6	17.2	10.3	112	38	29	45	30	24	30	8	5	90	35.0	25.0
	2 - Clear	415	0.6	0.3	0.1	89.6	17.2	10.3	112	38	29	45	30	24	30	8	5	90	35.0	25.0
ASTM Pipe	1 - Color	415	0.6	0.3	0.1	89.6	17.2	10.3	112	38	29	45	30	24	30	8	5	90	30.0	25.0
	2 - Clear	415	0.6	0.3	0.1	89.6	17.2	10.3	112	38	29	45	30	24	30	8	5	90	30.0	25.0
BookShelf	1 - Color	415	0.6	0.3	0.1	89.6	17.2	10.3	112	38	29	45	30	24	30	8	5	90	35.0	25.0
	2 - Clear	415	0.6	0.3	0.1	89.6	17.2	10.3	112	38	29	45	30	24	30	8	5	90	35.0	25.0
Box	1 - Color	517	0.6	0.3	0.1	124.1	17.2	10.3	112	31	22	45	30	21	30	8	4	90	25.0	17.5
	2 - Clear	517	0.6	0.3	0.1	124.1	17.2	10.3	112	31	22	45	30	21	30	8	4	90	25.0	17.5
Bridge Section	1 - Color	415	0.6	0.3	0.1	89.6	17.2	10.3	112	38	29	45	30	24	30	8	5	90	35.0	25.0
	2 - Clear	415	0.6	0.3	0.1	89.6	17.2	10.3	112	38	29	45	30	24	30	8	5	90	35.0	25.0
Cabinet Door	1 - Color	415	0.6	0.3	0.1	89.6	17.2	10.3	112	35	26	45	30	23	30	8	4	90	30.0	22.5
	2 - Clear	415	0.6	0.3	0.1	89.6	17.2	10.3	112	35	26	45	30	23	30	8	4	90	30.0	22.5
Cabinet Drawer	1 - Color	415	0.6	0.3	0.1	89.6	17.2	10.3	112	35	26	45	30	23	30	8	4	90	30.0	22.5
	2 - Clear	415	0.6	0.3	0.1	89.6	17.2	10.3	112	35	26	45	30	23	30	8	4	90	30.0	22.5
Cabinet Frame Large	1 - Color	415	0.6	0.3	0.1	89.6	17.2	10.3	112	38	29	45	30	24	30	8	5	90	35.0	25.0
	2 - Clear	415	0.6	0.3	0.1	89.6	17.2	10.3	112	38	29	45	30	24	30	8	5	90	35.0	25.0
Cabinet Frame Medium	1 - Color	415	0.6	0.3	0.1	89.6	17.2	10.3	112	38	29	45	30	24	30	8	5	90	35.0	25.0
	2 - Clear	415	0.6	0.3	0.1	89.6	17.2	10.3	112	38	29	45	30	24	30	8	5	90	35.0	25.0
Cabinet Frame Small	1 - Color	415	0.6	0.3	0.1	89.6	17.2	10.3	112	38	29	45	30	24	30	8	5	90	35.0	25.0
	2 - Clear	415	0.6	0.3	0.1	89.6	17.2	10.3	112	38	29	45	30	24	30	8	5	90	35.0	25.0
Car Bumper	1 - Color	313	0.6	0.3	0.1	62.1	17.2	10.3	112	38	29	45	30	24	30	8	5	90	35.0	25.0
	2 - Clear	313	0.6	0.3	0.1	62.1	17.2	10.3	112	38	29	45	30	24	30	8	5	90	35.0	25.0
Car Door	1 - Color	313	0.6	0.3	0.1	62.1	17.2	10.3	112	31	22	45	30	21	30	8	4	90	25.0	17.5
	2 - Clear	313	0.6	0.3	0.1	62.1	17.2	10.3	112	31	22	45	30	21	30	8	4	90	25.0	17.5
Car Fender	1 - Color	313	0.6	0.3	0.1	62.1	17.2	10.3	112	35	26	45	30	23	30	8	4	90	30.0	22.5
	2 - Clear	313	0.6	0.3	0.1	62.1	17.2	10.3	112	35	26	45	30	23	30	8	4	90	30.0	22.5
Car Hood	1 - Color	415	0.6	0.3	0.1	89.6	17.2	10.3	112	31	22	45	30	21	30	8	4	90	25.0	17.5
	2 - Clear	415	0.6	0.3	0.1	89.6	17.2	10.3	112	31	22	45	30	21	30	8	4	90	25.0	17.5
Corner	1 - Color	517	0.6	0.3	0.1	124.1	17.2	10.3	112	31	22	45	30	21	30	8	4	90	25.0	17.5
	2 - Clear	517	0.6	0.3	0.1	124.1	17.2	10.3	112	31	22	45	30	21	30	8	4	90	25.0	17.5
Corners Interior	1 - Color	517	0.6	0.3	0.1	124.1	17.2	10.3	112	31	22	45	30	21	30	8	4	90	25.0	17.5
	2 - Clear	517	0.6	0.3	0.1	124.1	17.2	10.3	112	31	22	45	30	21	30	8	4	90	25.0	17.5
Cylinder Horizontal	1 - Color	313	0.6	0.3	0.1	62.1	17.2	10.3	112	35	26	45	30	23	30	8	4	90	30.0	22.5
	2 - Clear	313	0.6	0.3	0.1	62.1	17.2	10.3	112	35	26	45	30	23	30	8	4	90	30.0	22.5
Cylinder Large	1 - Color	517	0.6	0.3	0.1	124.1	17.2	10.3	112	31	22	45	30	21	30	8	4	90	25.0	17.5
	2 - Clear	517	0.6	0.3	0.1	124.1	17.2	10.3	112	31	22	45	30	21	30	8	4	90	25.0	17.5
Cylinder Vertical	1 - Color	313	0.6	0.3	0.1	62.1	17.2	10.3	112	35	26	45	30	23	30	8	4	90	30.0	22.5
	2 - Clear	313	0.6	0.3	0.1	62.1	17.2	10.3	112	35	26	45	30	23	30	8	4	90	30.0	22.5
Cylinders Combined	1 - Color	313	0.6	0.3	0.1	62.1	17.2	10.3	112	35	26	45	30	23	30	8	4	90	30.0	22.5
	2 - Clear	313	0.6	0.3	0.1	62.1	17.2	10.3	112	35	26	45	30	23	30	8	4	90	30.0	22.5
Dining Chair	1 - Color	415	0.6	0.3	0.1	89.6	17.2	10.3	112	35	26	45	30	23	30	8	4	90	30.0	22.5
	2 - Clear	415	0.6	0.3	0.1	89.6	17.2	10.3	112	35	26	45	30	23	30	8	4	90	30.0	22.5
Dining Table	1 - Color	517	0.6	0.3	0.1	124.1	17.2	10.3	112	35	26	45	30	23	30	8	4	90	30.0	22.5
	2 - Clear	517	0.6	0.3	0.1	124.1	17.2	10.3	112	35	26	45	30	23	30	8	4	90	30.0	22.5
Engine Cowling	1 - Color	415	0.6	0.3	0.1	89.6	17.2	10.3	112	31	22	45	30	21	30	8	4	90	25.0	17.5
	2 - Clear	415	0.6	0.3	0.1	89.6	17.2	10.3	112	31	22	45	30	21	30	8	4	90	25.0	17.5
Flat Panel	1 - Color	517	0.6	0.3	0.1	124.1	17.2	10.3	112	31	22	45	30	21	30	8	4	90	25.0	17.5
	2 - Clear	517	0.6	0.3	0.1	124.1	17.2	10.3	112	31	22	45	30	21	30	8	4	90	25.0	17.5

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PART	COAT	TIPSIZE	AIR PRESSURE (bar)			FLUID PRESSURE (bar)			DRY FILM THICKNESS (µm)			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
Fridge End Panel	1 - Color	517	0.6	0.3	0.1	124.1	17.2	10.3	112	31	22	45	30	21	30	8	4	90	25.0	17.5
	2 - Clear	517	0.6	0.3	0.1	124.1	17.2	10.3	112	31	22	45	30	21	30	8	4	90	25.0	17.5
Gas Tank	1 - Color	313	0.6	0.3	0.1	62.1	17.2	10.3	112	38	29	45	30	24	30	8	5	90	35.0	25.0
	2 - Clear	313	0.6	0.3	0.1	62.1	17.2	10.3	112	38	29	45	30	24	30	8	5	90	35.0	25.0
Half Barrel	1 - Color	415	0.6	0.3	0.1	89.6	17.2	10.3	112	35	26	45	30	23	30	8	4	90	30.0	22.5
	2 - Clear	415	0.6	0.3	0.1	89.6	17.2	10.3	112	35	26	45	30	23	30	8	4	90	30.0	22.5
H Beam	1 - Color	415	0.6	0.3	0.1	89.6	17.2	10.3	112	35	26	45	30	23	30	8	4	90	30.0	22.5
	2 - Clear	415	0.6	0.3	0.1	89.6	17.2	10.3	112	35	26	45	30	23	30	8	4	90	30.0	22.5
Headboard	1 - Color	517	0.6	0.3	0.1	124.1	17.2	10.3	112	31	22	45	30	21	30	8	4	90	25.0	17.5
	2 - Clear	517	0.6	0.3	0.1	124.1	17.2	10.3	112	31	22	45	30	21	30	8	4	90	25.0	17.5
Horizontal Car Hood	1 - Color	415	0.6	0.3	0.1	89.6	17.2	10.3	112	31	22	45	30	21	30	8	4	90	25.0	17.5
	2 - Clear	415	0.6	0.3	0.1	89.6	17.2	10.3	112	31	22	45	30	21	30	8	4	90	25.0	17.5
Horizontal Wagon Roof	1 - Color	415	0.6	0.3	0.1	89.6	17.2	10.3	112	31	22	45	30	21	30	8	4	90	25.0	17.5
	2 - Clear	415	0.6	0.3	0.1	89.6	17.2	10.3	112	31	22	45	30	21	30	8	4	90	25.0	17.5
HVLP H-Beam	1 - Color	313	0.6	0.3	0.1	62.1	17.2	10.3	112	35	26	45	30	23	30	8	4	90	30.0	22.5
	2 - Clear	313	0.6	0.3	0.1	62.1	17.2	10.3	112	35	26	45	30	23	30	8	4	90	30.0	22.5
HVLP I-Beam	1 - Color	313	0.6	0.3	0.1	62.1	17.2	10.3	112	35	26	45	30	23	30	8	4	90	30.0	22.5
	2 - Clear	313	0.6	0.3	0.1	62.1	17.2	10.3	112	35	26	45	30	23	30	8	4	90	30.0	22.5
I Beam	1 - Color	415	0.6	0.3	0.1	89.6	17.2	10.3	112	35	26	45	30	23	30	8	4	90	30.0	22.5
	2 - Clear	415	0.6	0.3	0.1	89.6	17.2	10.3	112	35	26	45	30	23	30	8	4	90	30.0	22.5
Large Set Panel	1 - Color	517	0.6	0.3	0.1	124.1	17.2	10.3	112	31	22	45	30	21	30	8	4	90	25.0	17.5
	2 - Clear	517	0.6	0.3	0.1	124.1	17.2	10.3	112	31	22	45	30	21	30	8	4	90	25.0	17.5
Lattice	1 - Color	313	0.6	0.3	0.1	62.1	17.2	10.3	112	38	29	45	30	24	30	8	5	90	35.0	25.0
	2 - Clear	313	0.6	0.3	0.1	62.1	17.2	10.3	112	38	29	45	30	24	30	8	5	90	35.0	25.0
Motorcycle Fender	1 - Color	313	0.6	0.3	0.1	62.1	17.2	10.3	112	35	26	45	30	23	30	8	4	90	30.0	22.5
	2 - Clear	313	0.6	0.3	0.1	62.1	17.2	10.3	112	35	26	45	30	23	30	8	4	90	30.0	22.5
Panel Curve	1 - Color	517	0.6	0.3	0.1	124.1	17.2	10.3	112	35	26	45	30	23	30	8	4	90	30.0	22.5
	2 - Clear	517	0.6	0.3	0.1	124.1	17.2	10.3	112	35	26	45	30	23	30	8	4	90	30.0	22.5
Panel Curve Complex	1 - Color	517	0.6	0.3	0.1	124.1	17.2	10.3	112	35	26	45	30	23	30	8	4	90	30.0	22.5
	2 - Clear	517	0.6	0.3	0.1	124.1	17.2	10.3	112	35	26	45	30	23	30	8	4	90	30.0	22.5
Panel Horizontal	1 - Color	517	0.6	0.3	0.1	124.1	17.2	10.3	112	31	22	45	30	21	30	8	4	90	25.0	17.5
	2 - Clear	517	0.6	0.3	0.1	124.1	17.2	10.3	112	31	22	45	30	21	30	8	4	90	25.0	17.5
Panel Vertical	1 - Color	517	0.6	0.3	0.1	124.1	17.2	10.3	112	31	22	45	30	21	30	8	4	90	25.0	17.5
	2 - Clear	517	0.6	0.3	0.1	124.1	17.2	10.3	112	31	22	45	30	21	30	8	4	90	25.0	17.5
Panel with Cutouts	1 - Color	415	0.6	0.3	0.1	89.6	17.2	10.3	112	35	26	45	30	23	30	8	4	90	30.0	22.5
	2 - Clear	415	0.6	0.3	0.1	89.6	17.2	10.3	112	35	26	45	30	23	30	8	4	90	30.0	22.5
Panel with Grooves	1 - Color	415	0.6	0.3	0.1	89.6	17.2	10.3	112	38	29	45	30	24	30	8	5	90	35.0	25.0
	2 - Clear	415	0.6	0.3	0.1	89.6	17.2	10.3	112	38	29	45	30	24	30	8	5	90	35.0	25.0
Panel with Shapes	1 - Color	415	0.6	0.3	0.1	89.6	17.2	10.3	112	35	26	45	30	23	30	8	4	90	30.0	22.5
	2 - Clear	415	0.6	0.3	0.1	89.6	17.2	10.3	112	35	26	45	30	23	30	8	4	90	30.0	22.5
Pylon Exterior	1 - Color	415	0.6	0.3	0.1	89.6	17.2	10.3	112	35	26	45	30	23	30	8	4	90	30.0	22.5
	2 - Clear	415	0.6	0.3	0.1	89.6	17.2	10.3	112	35	26	45	30	23	30	8	4	90	30.0	22.5
Pylon Interior	1 - Color	415	0.6	0.3	0.1	89.6	17.2	10.3	112	35	26	45	30	23	30	8	4	90	30.0	22.5
	2 - Clear	415	0.6	0.3	0.1	89.6	17.2	10.3	112	35	26	45	30	23	30	8	4	90	30.0	22.5
Sphere Half	1 - Color	415	0.6	0.3	0.1	89.6	17.2	10.3	112	38	29	45	30	24	30	8	5	90	35.0	25.0
	2 - Clear	415	0.6	0.3	0.1	89.6	17.2	10.3	112	38	29	45	30	24	30	8	5	90	35.0	25.0
Strut Panel	1 - Color	415	0.6	0.3	0.1	89.6	17.2	10.3	112	31	22	45	30	21	30	8	4	90	25.0	17.5
	2 - Clear	415	0.6	0.3	0.1	89.6	17.2	10.3	112	31	22	45	30	21	30	8	4	90	25.0	17.5
Vertical Panel	1 - Color	517	0.6	0.3	0.1	124.1	17.2	10.3	112	31	22	45	30	21	30	8	4	90	25.0	17.5
	2 - Clear	517	0.6	0.3	0.1	124.1	17.2	10.3	112	31	22	45	30	21	30	8	4	90	25.0	17.5
Vertical Piece	1 - Color	517	0.6	0.3	0.1	124.1	17.2	10.3	112	31	22	45	30	21	30	8	4	90	25.0	17.5
	2 - Clear	517	0.6	0.3	0.1	124.1	17.2	10.3	112	31	22	45	30	21	30	8	4	90	25.0	17.5
Wavy Panel	1 - Color	313	0.6	0.3	0.1	62.1	17.2	10.3	112	31	22	45	30	21	30	8	4	90	25.0	17.5
	2 - Clear	313	0.6	0.3	0.1	62.1	17.2	10.3	112	31	22	45	30	21	30	8	4	90	25.0	17.5
Wing Panel	1 - Color	517	0.6	0.3	0.1	124.1	17.2	10.3	112	31	22	45	30	21	30	8	4	90	25.0	17.5
	2 - Clear	517	0.6	0.3	0.1	124.1	17.2	10.3	112	31	22	45	30	21	30	8	4	90	25.0	17.5
Wood Panel	1 - Color	517	0.6	0.3	0.1	124.1	17.2	10.3	112	31	22	45	30	21	30	8	4	90	25.0	17.5
	2 - Clear	517	0.6	0.3	0.1	124.1	17.2	10.3	112	31	22	45	30	21	30	8	4	90	25.0	17.5

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			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	112	38	29	45	30	24	30	8	5	90	35.0	25.0
Box	1 - Color	517	0.6	0.3	0.1	124.1	17.2	10.3	112	31	22	45	30	21	30	8	4	90	25.0	17.5
Cabinet Door	1 - Color	415	0.6	0.3	0.1	89.6	17.2	10.3	112	35	26	45	30	23	30	8	4	90	30.0	22.5
Cabinet Drawer	1 - Color	415	0.6	0.3	0.1	89.6	17.2	10.3	112	35	26	45	30	23	30	8	4	90	30.0	22.5
Cabinet Frame Large	1 - Color	415	0.6	0.3	0.1	89.6	17.2	10.3	112	38	29	45	30	24	30	8	5	90	35.0	25.0
Cabinet Frame Medium	1 - Color	415	0.6	0.3	0.1	89.6	17.2	10.3	112	38	29	45	30	24	30	8	5	90	35.0	25.0
Cabinet Frame Small	1 - Color	415	0.6	0.3	0.1	89.6	17.2	10.3	112	38	29	45	30	24	30	8	5	90	35.0	25.0
Car Bumper	1 - Color	313	0.6	0.3	0.1	62.1	17.2	10.3	112	38	29	45	30	24	30	8	5	90	35.0	25.0
Car Door	1 - Color	313	0.6	0.3	0.1	62.1	17.2	10.3	112	31	22	45	30	21	30	8	4	90	25.0	17.5
Car Fender	1 - Color	313	0.6	0.3	0.1	62.1	17.2	10.3	112	31	22	45	30	21	30	8	4	90	25.0	17.5
Car Hood	1 - Color	415	0.6	0.3	0.1	89.6	17.2	10.3	112	31	22	45	30	21	30	8	4	90	25.0	17.5
Corner	1 - Color	517	0.6	0.3	0.1	124.1	17.2	10.3	112	31	22	45	30	21	30	8	4	90	25.0	17.5
Corners Interior	1 - Color	517	0.6	0.3	0.1	124.1	17.2	10.3	112	31	22	45	30	21	30	8	4	90	25.0	17.5
Cylinder Horizontal	1 - Color	313	0.6	0.3	0.1	62.1	17.2	10.3	112	35	26	45	30	23	30	8	4	90	30.0	22.5
Cylinder Large	1 - Color	517	0.6	0.3	0.1	124.1	17.2	10.3	112	31	22	45	30	21	30	8	4	90	25.0	17.5
Cylinder Vertical	1 - Color	313	0.6	0.3	0.1	62.1	17.2	10.3	112	35	26	45	30	23	30	8	4	90	30.0	22.5
Cylinder Combined	1 - Color	313	0.6	0.3	0.1	62.1	17.2	10.3	112	35	26	45	30	23	30	8	4	90	30.0	22.5
Flat Panel	1 - Color	517	0.6	0.3	0.1	124.1	17.2	10.3	112	31	22	45	30	21	30	8	4	90	25.0	17.5
Fridge End Panel	1 - Color	517	0.6	0.3	0.1	124.1	17.2	10.3	112	31	22	45	30	21	30	8	4	90	25.0	17.5
Headboard	1 - Color	517	0.6	0.3	0.1	124.1	17.2	10.3	112	31	22	45	30	21	30	8	4	90	25.0	17.5
Lattice	1 - Color	313	0.6	0.3	0.1	124.1	17.2	10.3	112	38	29	45	30	24	30	8	5	90	35.0	25.0
Motorcycle Fender	1 - Color	313	0.6	0.3	0.1	62.1	17.2	10.3	112	35	26	45	30	23	30	8	4	90	30.0	22.5
Panel Curve	1 - Color	517	0.6	0.3	0.1	124.1	17.2	10.3	112	35	26	45	30	23	30	8	4	90	30.0	22.5
Panel Curve Complex	1 - Color	517	0.6	0.3	0.1	124.1	17.2	10.3	112	35	26	45	30	23	30	8	4	90	30.0	22.5
Panel Horizontal	1 - Color	517	0.6	0.3	0.1	124.1	17.2	10.3	112	31	22	45	30	21	30	8	4	90	25.0	17.5
Panel Vertical	1 - Color	517	0.6	0.3	0.1	124.1	17.2	10.3	112	31	22	45	30	21	30	8	4	90	25.0	17.5
Panel with Cutouts	1 - Color	415	0.6	0.3	0.1	89.6	17.2	10.3	112	35	26	45	30	23	30	8	4	90	30.0	22.5
Panel with Grooves	1 - Color	415	0.6	0.3	0.1	89.6	17.2	10.3	112	38	29	45	30	24	30	8	5	90	35.0	25.0
Panel with Shapes	1 - Color	415	0.6	0.3	0.1	89.6	17.2	10.3	112	35	26	45	30	23	30	8	4	90	30.0	22.5
Sphere Half	1 - Color	415	0.6	0.3	0.1	89.6	17.2	10.3	112	38	29	45	30	24	30	8	5	90	35.0	25.0
Vertical Panel	1 - Color	517	0.6	0.3	0.1	124.1	17.2	10.3	112	31	22	45	30	21	30	8	4	90	25.0	17.5
Vertical Piece	1 - Color	517	0.6	0.3	0.1	124.1	17.2	10.3	112	31	22	45	30	21	30	8	4	90	25.0	17.5
Wavy Panel	1 - Color	313	0.6	0.3	0.1	62.1	17.2	10.3	112	31	22	45	30	21	30	8	4	90	25.0	17.5
Wood Panel	1 - Color	517	0.6	0.3	0.1	124.1	17.2	10.3	112	31	22	45	30	21	30	8	4	90	25.0	17.5

AIRLESS																			Metric	
PART	COAT	TIPSIZE	AIR PRESSURE (bar)			FLUID PRESSURE (bar)			DRY FILM THICKNESS (µm)			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	152	52	40	45	30	24	30	8	5	90	35.0	25.0
	2 - Clear	517	N/A	N/A	N/A	144.8	17.2	10.3	152	52	40	45	30	24	30	8	5	90	35.0	25.0
ACQPA Panel Cylinder	1 - Color	313	N/A	N/A	N/A	82.7	17.2	10.3	152	52	40	45	30	24	30	8	4	90	35.0	25.0
	2 - Clear	313	N/A	N/A	N/A	82.7	17.2	10.3	152	52	40	45	30	24	30	8	4	90	35.0	25.0
ACQPA Panel Horizontal	1 - Color	313	N/A	N/A	N/A	82.7	17.2	10.3	152	52	40	45	30	24	30	8	5	90	35.0	25.0
	2 - Clear	313	N/A	N/A	N/A	82.7	17.2	10.3	152	52	40	45	30	24	30	8	5	90	35.0	25.0
ACQPA Panel Vertical	1 - Color	313	N/A	N/A	N/A	82.7	17.2	10.3	152	52	40	45	30	24	30	8	4	90	35.0	25.0
	2 - Clear	313	N/A	N/A	N/A	82.7	17.2	10.3	152	52	40	45	30	24	30	8	4	90	35.0	25.0
ASTM Deep T	1 - Color	415	N/A	N/A	N/A	103.4	17.2	10.3	152	52	40	45	30	24	30	8	5	90	35.0	25.0
	2 - Clear	415	N/A	N/A	N/A	103.4	17.2	10.3	152	52	40	45	30	24	30	8	5	90	35.0	25.0
ASTM H Beam	1 - Color	415	N/A	N/A	N/A	103.4	17.2	10.3	152	52	40	45	30	24	30	8	4	90	35.0	25.0
	2 - Clear	415	N/A	N/A	N/A	103.4	17.2	10.3	152	52	40	45	30	24	30	8	4	90	35.0	25.0
ASTM Panel	1 - Color	415	N/A	N/A	N/A	103.4	17.2	10.3	152	52	40	45	30	24	30	8	5	90	35.0	25.0
	2 - Clear	415	N/A	N/A	N/A	103.4	17.2	10.3	152	52	40	45	30	24	30	8	5	90	35.0	25.0
ASTM Pipe	1 - Color	415	N/A	N/A	N/A	103.4	17.2	10.3	152	52	40	45	30	24	30	8	4	90	35.0	25.0
	2 - Clear	415	N/A	N/A	N/A	103.4	17.2	10.3	152	52	40	45	30	24	30	8	4	90	35.0	25.0
Bookshelf	1 - Color	415	N/A	N/A	N/A	103.4	17.2	10.3	152	52	40	45	30	24	30	8	5	90	35.0	25.0
	2 - Clear	415	N/A	N/A	N/A	103.4	17.2	10.3	152	52	40	45	30	24	30	8	5	90	35.0	25.0
Box	1 - Color	517	N/A	N/A	N/A	144.8	17.2	10.3	152	43	30	45	30	21	30	8	4	90	25.0	17.5
	2 - Clear	517	N/A	N/A	N/A	144.8	17.2	10.3	152	43	30	45	30	21	30	8	4	90	25.0	17.5
Bridge Section	1 - Color	415	N/A	N/A	N/A	103.4	17.2	10.3	152	52	40	45	30	24	30	8	5	90	35.0	25.0
	2 - Clear	415	N/A	N/A	N/A	103.4	17.2	10.3	152	52	40	45	30	24	30	8	5	90	35.0	25.0
Cabinet Door	1 - Color	415	N/A	N/A	N/A	103.4	17.2	10.3	152	47	35	45	30	23	30	8	4	90	30.0	22.5
	2 - Clear	415	N/A	N/A	N/A	103.4	17.2	10.3	152	47	35	45	30	23	30	8	4	90	30.0	22.5
Cabinet Drawer	1 - Color	415	N/A	N/A	N/A	103.4	17.2	10.3	152	47	35	45	30	23	30	8	4	90	30.0	22.5
	2 - Clear	415	N/A	N/A	N/A	103.4	17.2	10.3	152	47	35	45	30	23	30	8	4	90	30.0	22.5
Cabinet Frame Large	1 - Color	415	N/A	N/A	N/A	103.4	17.2	10.3	152	47	35	45	30	24	30	8	5	90	35.0	25.0
	2 - Clear	415	N/A	N/A	N/A	103.4	17.2	10.3	152	47	35	45	30	24	30	8	5	90	35.0	25.0
Cabinet Frame Medium	1 - Color	415	N/A	N/A	N/A	103.4	17.2	10.3	152	47	35	45	30	24	30	8	5	90	35.0	25.0
	2 - Clear	415	N/A	N/A	N/A	103.4	17.2	10.3	152	47	35	45	30	24	30	8	5	90	35.0	25.0
Cabinet Frame Small	1 - Color	415	N/A	N/A	N/A	103.4	17.2	10.3	152	47	35	45	30	24	30	8	5	90	35.0	25.0
	2 - Clear	415	N/A	N/A	N/A	103.4	17.2	10.3	152	47	35	45	30	24	30	8	5	90	35.0	25.0
Car Bumper	1 - Color	313	N/A	N/A	N/A	82.7	17.2	10.3	152	52	40	45	30	24	30	8	5	90	35.0	25.0
	2 - Clear	313	N/A	N/A	N/A	82.7	17.2	10.3	152	52	40	45	30	24	30	8	5	90	35.0	25.0
Car Door	1 - Color	313	N/A	N/A	N/A	82.7	17.2	10.3	152	43	30	45	30	21	30	8	4	90	25.0	17.5
	2 - Clear	313	N/A	N/A	N/A	82.7	17.2	10.3	152	43	30	45	30	21	30	8	4	90	25.0	17.5
Car Fender	1 - Color	313	N/A	N/A	N/A	82.7	17.2	10.3	152	47	35	45	30	23	30	8	4	90	30.0	22.5
	2 - Clear	313	N/A	N/A	N/A	82.7	17.2	10.3	152	47	35	45	30	23	30	8	4	90	30.0	22.5
Car Hood	1 - Color	415	N/A	N/A	N/A	103.4	17.2	10.3	152	43	30	45	30	21	30	8	4	90	25.0	17.5
	2 - Clear	415	N/A	N/A	N/A	103.4	17.2	10.3	152	43	30	45	30	21	30	8	4	90	25.0	17.5
Corner	1 - Color	517	N/A	N/A	N/A	144.8	17.2	10.3	152	43	30	45	30	21	30	8	4	90	25.0	17.5
	2 - Clear	517	N/A	N/A	N/A	144.8	17.2	10.3	152	43	30	45	30	21	30	8	4	90	25.0	17.5
Corners Interior	1 - Color	517	N/A	N/A	N/A	144.8	17.2	10.3	152	43	30	45	30	21	30	8	4	90	25.0	17.5
	2 - Clear	517	N/A	N/A	N/A	144.8	17.2	10.3	152	43	30	45	30	21	30	8	4	90	25.0	17.5
Cylinder Horizontal	1 - Color	313	N/A	N/A	N/A	82.7	17.2	10.3	152	47	35	45	30	23	30	8	4	90	30.0	22.5
	2 - Clear	313	N/A	N/A	N/A	82.7	17.2	10.3	152	47	35	45	30	23	30	8	4	90	30.0	22.5
Cylinder Large	1 - Color	517	N/A	N/A	N/A	144.8	17.2	10.3	152	43	30	45	30	21	30	8	4	90	25.0	17.5
	2 - Clear	517	N/A	N/A	N/A	144.8	17.2	10.3	152	43	30	45	30	21	30	8	4	90	25.0	17.5
Cylinder Vertical	1 - Color	313	N/A	N/A	N/A	82.7	17.2	10.3	152	47	35	45	30	23	30	8	4	90	30.0	22.5
	2 - Clear	313	N/A	N/A	N/A	82.7	17.2	10.3	152	47	35	45	30	23	30	8	4	90	30.0	22.5
Cylinder Combined	1 - Color	313	N/A	N/A	N/A	82.7	17.2	10.3	152	47	35	45	30	23	30	8	4	90	30.0	22.5
	2 - Clear	313	N/A	N/A	N/A	82.7	17.2	10.3	152	47	35	45	30	23	30	8	4	90	30.0	22.5
Dining Chair	1 - Color	415	N/A	N/A	N/A	103.4	17.2	10.3	152	47	35	45	30	23	30	8	4	90	30.0	22.5
	2 - Clear	415	N/A	N/A	N/A	103.4	17.2	10.3	152	47	35	45	30	23	30	8	4	90	30.0	22.5
Dining Table	1 - Color	517	N/A	N/A	N/A	144.8	17.2	10.3	152	47	35	45	30	23	30	8	4	90	30.0	22.5
	2 - Clear	517	N/A	N/A	N/A	144.8	17.2	10.3	152	47	35	45	30	23	30	8	4	90	30.0	22.5
Engine Cowling	1 - Color	415	N/A	N/A	N/A	103.4	17.2	10.3	152	43	30	45	30	21	30	8	4	90	25.0	17.5
	2 - Clear	415	N/A	N/A	N/A	103.4	17.2	10.3	152	43	30	45	30	21	30	8	4	90	25.0	17.5
Flat Panel	1 - Color	517	N/A	N/A	N/A	144.8	17.2	10.3	152	43	30	45	30	21	30	8	4	90	25.0	17.5
	2 - Clear	517	N/A	N/A	N/A	144.8	17.2	10.3	152	43	30	45	30	21	30	8	4	90	25.0	17.5

AIRLESS																			Metric	
PART	COAT	TIPSIZE	AIR PRESSURE (bar)			FLUID PRESSURE (bar)			DRY FILM THICKNESS (µm)			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
Fridge End Panel	1 - Color	517	N/A	N/A	N/A	144.8	17.2	10.3	152	43	30	45	30	21	30	8	4	90	25.0	17.5
	2 - Clear	517	N/A	N/A	N/A	144.8	17.2	10.3	152	43	30	45	30	21	30	8	4	90	25.0	17.5
Gas Tank	1 - Color	313	N/A	N/A	N/A	82.7	17.2	10.3	152	52	40	45	30	24	30	8	5	90	35.0	25.0
	2 - Clear	313	N/A	N/A	N/A	82.7	17.2	10.3	152	52	40	45	30	24	30	8	5	90	35.0	25.0
Half Barrel	1 - Color	415	N/A	N/A	N/A	103.4	17.2	10.3	152	47	35	45	30	23	30	8	4	90	30.0	22.5
	2 - Clear	415	N/A	N/A	N/A	103.4	17.2	10.3	152	47	35	45	30	23	30	8	4	90	30.0	22.5
H Beam	1 - Color	415	N/A	N/A	N/A	103.4	17.2	10.3	152	47	35	45	30	23	30	8	4	90	30.0	22.5
	2 - Clear	415	N/A	N/A	N/A	103.4	17.2	10.3	152	47	35	45	30	23	30	8	4	90	30.0	22.5
Headboard	1 - Color	517	N/A	N/A	N/A	144.8	17.2	10.3	152	43	30	45	30	21	30	8	4	90	25.0	17.5
	2 - Clear	517	N/A	N/A	N/A	144.8	17.2	10.3	152	43	30	45	30	21	30	8	4	90	25.0	17.5
Horizontal Car Hood	1 - Color	415	N/A	N/A	N/A	103.4	17.2	10.3	152	43	30	45	30	21	30	8	4	90	25.0	17.5
	2 - Clear	415	N/A	N/A	N/A	103.4	17.2	10.3	152	43	30	45	30	21	30	8	4	90	25.0	17.5
Horizontal Wagon Roof	1 - Color	415	N/A	N/A	N/A	103.4	17.2	10.3	152	43	30	45	30	21	30	8	4	90	25.0	17.5
	2 - Clear	415	N/A	N/A	N/A	103.4	17.2	10.3	152	43	30	45	30	21	30	8	4	90	25.0	17.5
HVLP H-Beam	1 - Color	313	N/A	N/A	N/A	82.7	17.2	10.3	152	47	35	45	30	23	30	8	4	90	30.0	22.5
	2 - Clear	313	N/A	N/A	N/A	82.7	17.2	10.3	152	47	35	45	30	23	30	8	4	90	30.0	22.5
HVLP I-Beam	1 - Color	313	N/A	N/A	N/A	82.7	17.2	10.3	152	47	35	45	30	23	30	8	4	90	30.0	22.5
	2 - Clear	313	N/A	N/A	N/A	82.7	17.2	10.3	152	47	35	45	30	23	30	8	4	90	30.0	22.5
I Beam	1 - Color	415	N/A	N/A	N/A	103.4	17.2	10.3	152	47	35	45	30	23	30	8	4	90	30.0	22.5
	2 - Clear	415	N/A	N/A	N/A	103.4	17.2	10.3	152	47	35	45	30	23	30	8	4	90	30.0	22.5
Large Set Panel	1 - Color	517	N/A	N/A	N/A	144.8	17.2	10.3	152	43	30	45	30	21	30	8	4	90	25.0	17.5
	2 - Clear	517	N/A	N/A	N/A	144.8	17.2	10.3	152	43	30	45	30	21	30	8	4	90	25.0	17.5
Lattice	1 - Color	313	N/A	N/A	N/A	82.7	17.2	10.3	152	47	35	45	30	24	30	8	5	90	35.0	25.0
	2 - Clear	313	N/A	N/A	N/A	82.7	17.2	10.3	152	47	35	45	30	24	30	8	5	90	35.0	25.0
Motorcycle Fender	1 - Color	313	N/A	N/A	N/A	82.7	17.2	10.3	152	47	35	45	30	23	30	8	4	90	30.0	22.5
	2 - Clear	313	N/A	N/A	N/A	82.7	17.2	10.3	152	47	35	45	30	23	30	8	4	90	30.0	22.5
Panel Curve	1 - Color	517	N/A	N/A	N/A	144.8	17.2	10.3	152	47	35	45	30	23	30	8	4	90	30.0	22.5
	2 - Clear	517	N/A	N/A	N/A	144.8	17.2	10.3	152	47	35	45	30	23	30	8	4	90	30.0	22.5
Panel Curve Complex	1 - Color	517	N/A	N/A	N/A	144.8	17.2	10.3	152	47	35	45	30	23	30	8	4	90	30.0	22.5
	2 - Clear	517	N/A	N/A	N/A	144.8	17.2	10.3	152	47	35	45	30	23	30	8	4	90	30.0	22.5
Panel Horizontal	1 - Color	517	N/A	N/A	N/A	144.8	17.2	10.3	152	43	30	45	30	21	30	8	4	90	25.0	17.5
	2 - Clear	517	N/A	N/A	N/A	144.8	17.2	10.3	152	43	30	45	30	21	30	8	4	90	25.0	17.5
Panel Vertical	1 - Color	517	N/A	N/A	N/A	144.8	17.2	10.3	152	43	30	45	30	21	30	8	4	90	25.0	17.5
	2 - Clear	517	N/A	N/A	N/A	144.8	17.2	10.3	152	43	30	45	30	21	30	8	4	90	25.0	17.5
Panel with Cutouts	1 - Color	415	N/A	N/A	N/A	103.4	17.2	10.3	152	47	35	45	30	23	30	8	4	90	30.0	22.5
	2 - Clear	415	N/A	N/A	N/A	103.4	17.2	10.3	152	47	35	45	30	23	30	8	4	90	30.0	22.5
Panel with Grooves	1 - Color	415	N/A	N/A	N/A	103.4	17.2	10.3	152	52	40	45	30	24	30	8	5	90	35.0	25.0
	2 - Clear	415	N/A	N/A	N/A	103.4	17.2	10.3	152	52	40	45	30	24	30	8	5	90	35.0	25.0
Panel with Shapes	1 - Color	415	N/A	N/A	N/A	103.4	17.2	10.3	152	47	35	45	30	23	30	8	4	90	30.0	22.5
	2 - Clear	415	N/A	N/A	N/A	103.4	17.2	10.3	152	47	35	45	30	23	30	8	4	90	30.0	22.5
Pylon Exterior	1 - Color	415	N/A	N/A	N/A	103.4	17.2	10.3	152	47	35	45	30	23	30	8	4	90	30.0	22.5
	2 - Clear	415	N/A	N/A	N/A	103.4	17.2	10.3	152	47	35	45	30	23	30	8	4	90	30.0	22.5
Pylon Interior	1 - Color	415	N/A	N/A	N/A	103.4	17.2	10.3	152	47	35	45	30	23	30	8	4	90	30.0	22.5
	2 - Clear	415	N/A	N/A	N/A	103.4	17.2	10.3	152	47	35	45	30	23	30	8	4	90	30.0	22.5
Sphere Half	1 - Color	415	N/A	N/A	N/A	103.4	17.2	10.3	152	52	40	45	30	24	30	8	5	90	35.0	25.0
	2 - Clear	415	N/A	N/A	N/A	103.4	17.2	10.3	152	52	40	45	30	24	30	8	5	90	35.0	25.0
Strut Panel	1 - Color	415	N/A	N/A	N/A	103.4	17.2	10.3	152	43	30	45	30	21	30	8	4	90	25.0	17.5
	2 - Clear	415	N/A	N/A	N/A	103.4	17.2	10.3	152	43	30	45	30	21	30	8	4	90	25.0	17.5
Vertical Panel	1 - Color	517	N/A	N/A	N/A	144.8	17.2	10.3	152	43	30	45	30	21	30	8	4	90	25.0	17.5
	2 - Clear	517	N/A	N/A	N/A	144.8	17.2	10.3	152	43	30	45	30	21	30	8	4	90	25.0	17.5
Vertical Piece	1 - Color	517	N/A	N/A	N/A	144.8	17.2	10.3	152	43	30	45	30	21	30	8	4	90	25.0	17.5
	2 - Clear	517	N/A	N/A	N/A	144.8	17.2	10.3	152	43	30	45	30	21	30	8	4	90	25.0	17.5
Wavy Panel	1 - Color	313	N/A	N/A	N/A	82.7	17.2	10.3	152	43	30	45	30	21	30	8	4	90	25.0	17.5
	2 - Clear	313	N/A	N/A	N/A	82.7	17.2	10.3	152	43	30	45	30	21	30	8	4	90	25.0	17.5
Wing Panel	1 - Color	517	N/A	N/A	N/A	144.8	17.2	10.3	152	43	30	45	30	21	30	8	4	90	25.0	17.5
	2 - Clear	517	N/A	N/A	N/A	144.8	17.2	10.3	152	43	30	45	30	21	30	8	4	90	25.0	17.5
Wood Panel	1 - Color	517	N/A	N/A	N/A	144.8	17.2	10.3	152	43	30	45	30	21	30	8	4	90	25.0	17.5
	2 - Clear	517	N/A	N/A	N/A	144.8	17.2	10.3	152	43	30	45	30	21	30	8	4	90	25.0	17.5



AIRLESS CONVEYOR																			Metric	
PART	COAT	TIPSIZE	AIR PRESSURE (bar)			FLUID PRESSURE (bar)			DRY FILM THICKNESS (µm)			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	152	52	40	45	30	24	30	8	5	90	35.0	25.0
Box	1- Color	517	N/A	N/A	N/A	144.8	17.2	10.3	152	52	40	45	30	24	30	8	5	90	35.0	25.0
Cabinet Door	1- Color	415	N/A	N/A	N/A	103.4	17.2	10.3	152	47	35	45	30	23	30	8	4	90	30.0	22.5
Cabinet Drawer	1- Color	415	N/A	N/A	N/A	103.4	17.2	10.3	152	47	35	45	30	23	30	8	4	90	30.0	22.5
Cabinet Frame Large	1- Color	415	N/A	N/A	N/A	103.4	17.2	10.3	152	52	40	45	30	24	30	8	5	90	35.0	25.0
Cabinet Frame Medium	1- Color	415	N/A	N/A	N/A	103.4	17.2	10.3	152	52	40	45	30	24	30	8	5	90	35.0	25.0
Cabinet Frame Small	1- Color	415	N/A	N/A	N/A	103.4	17.2	10.3	152	52	40	45	30	24	30	8	5	90	35.0	25.0
Car Bumper	1- Color	313	N/A	N/A	N/A	82.7	17.2	10.3	152	52	40	45	30	24	30	8	5	90	35.0	25.0
Car Door	1- Color	313	N/A	N/A	N/A	82.7	17.2	10.3	152	43	30	45	30	21	30	8	4	90	25.0	17.5
Car Fender	1- Color	313	N/A	N/A	N/A	82.7	17.2	10.3	152	43	30	45	30	21	30	8	4	90	25.0	17.5
Car Hood	1- Color	415	N/A	N/A	N/A	103.4	17.2	10.3	152	43	30	45	30	21	30	8	4	90	25.0	17.5
Corner	1- Color	517	N/A	N/A	N/A	144.8	17.2	10.3	152	43	30	45	30	21	30	8	4	90	25.0	17.5
Corners Interior	1- Color	517	N/A	N/A	N/A	144.8	17.2	10.3	152	43	30	45	30	21	30	8	4	90	25.0	17.5
Cylinder Horizontal	1- Color	313	N/A	N/A	N/A	82.7	17.2	10.3	152	47	35	45	30	23	30	8	4	90	30.0	22.5
Cylinder Large	1- Color	517	N/A	N/A	N/A	144.8	17.2	10.3	152	43	30	45	30	21	30	8	4	90	25.0	17.5
Cylinder Vertical	1- Color	313	N/A	N/A	N/A	82.7	17.2	10.3	152	47	35	45	30	23	30	8	4	90	30.0	22.5
Cylinder Combined	1- Color	313	N/A	N/A	N/A	82.7	17.2	10.3	152	47	35	45	30	23	30	8	4	90	30.0	22.5
Flat Panel	1- Color	517	N/A	N/A	N/A	144.8	17.2	10.3	152	43	30	45	30	21	30	8	4	90	25.0	17.5
Fridge End Panel	1- Color	517	N/A	N/A	N/A	144.8	17.2	10.3	152	43	30	45	30	21	30	8	4	90	25.0	17.5
Headboard	1- Color	517	N/A	N/A	N/A	144.8	17.2	10.3	152	43	30	45	30	21	30	8	4	90	25.0	17.5
Lattice	1- Color	313	N/A	N/A	N/A	82.7	17.2	10.3	152	52	40	45	30	24	30	8	5	90	35.0	25.0
Motorcycle Fender	1- Color	313	N/A	N/A	N/A	82.7	17.2	10.3	152	47	35	45	30	23	30	8	4	90	30.0	22.5
Panel Curve	1- Color	517	N/A	N/A	N/A	144.8	17.2	10.3	152	47	35	45	30	23	30	8	4	90	30.0	22.5
Panel Curve Complex	1- Color	517	N/A	N/A	N/A	144.8	17.2	10.3	152	47	35	45	30	23	30	8	4	90	30.0	22.5
Panel Horizontal	1- Color	517	N/A	N/A	N/A	144.8	17.2	10.3	152	43	30	45	30	21	30	8	4	90	25.0	17.5
Panel Vertical	1- Color	517	N/A	N/A	N/A	144.8	17.2	10.3	152	43	30	45	30	21	30	8	4	90	25.0	17.5
Panel with Cutouts	1- Color	415	N/A	N/A	N/A	103.4	17.2	10.3	152	47	35	45	30	23	30	8	4	90	30.0	22.5
Panel with Grooves	1- Color	415	N/A	N/A	N/A	103.4	17.2	10.3	152	52	40	45	30	24	30	8	5	90	35.0	25.0
Panel with Shapes	1- Color	415	N/A	N/A	N/A	103.4	17.2	10.3	152	47	35	45	30	23	30	8	4	90	30.0	22.5
Sphere Half	1- Color	415	N/A	N/A	N/A	103.4	17.2	10.3	152	52	40	45	30	24	30	8	5	90	35.0	25.0
Vertical Panel	1- Color	517	N/A	N/A	N/A	144.8	17.2	10.3	152	43	30	45	30	21	30	8	4	90	25.0	17.5
Vertical Piece	1- Color	517	N/A	N/A	N/A	144.8	17.2	10.3	152	43	30	45	30	21	30	8	4	90	25.0	17.5
Wavy Panel	1- Color	313	N/A	N/A	N/A	82.7	17.2	10.3	152	43	30	45	30	21	30	8	4	90	25.0	17.5
Wood Panel	1- Color	517	N/A	N/A	N/A	144.8	17.2	10.3	152	43	30	45	30	21	30	8	4	90	25.0	17.5

HVLP																			Metric	
PART	COAT	TIPSIZE	AIR PRESSURE (bar)			FLUID PRESSURE (bar)			DRY FILM THICKNESS (µm)			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	41	14	11	45	30	24	20	8	5	90	35.0	25.0
	2 - Clear	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	14	11	45	30	24	20	8	5	90	35.0	25.0
ACQPA Panel Cylinder	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	14	11	45	30	24	20	8	5	90	35.0	25.0
	2 - Clear	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	14	11	45	30	24	20	8	5	90	35.0	25.0
ACQPA Panel Horizontal	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	14	11	45	30	24	20	8	5	90	35.0	25.0
	2 - Clear	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	14	11	45	30	24	20	8	5	90	35.0	25.0
ACQPA Panel Vertical	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	14	11	45	30	24	20	8	5	90	35.0	25.0
	2 - Clear	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	14	11	45	30	24	20	8	5	90	35.0	25.0
ASTM Deep T	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	14	11	45	30	24	20	8	5	90	35.0	25.0
	2 - Clear	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	14	11	45	30	24	20	8	5	90	35.0	25.0
ASTM H Beam	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	14	11	45	30	24	20	8	5	90	35.0	25.0
	2 - Clear	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	14	11	45	30	24	20	8	5	90	35.0	25.0
ASTM Panel	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	14	11	45	30	24	20	8	5	90	35.0	25.0
	2 - Clear	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	14	11	45	30	24	20	8	5	90	35.0	25.0
ASTM Pipe	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	14	11	45	30	24	20	8	5	90	35.0	25.0
	2 - Clear	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	14	11	45	30	24	20	8	5	90	35.0	25.0
Bookshelf	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	14	11	45	30	24	20	8	5	90	35.0	25.0
	2 - Clear	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	14	11	45	30	24	20	8	5	90	35.0	25.0
Box	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	11	8	45	30	21	20	8	4	90	25.0	17.5
	2 - Clear	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	11	8	45	30	21	20	8	4	90	25.0	17.5
Bridge Section	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	14	11	45	30	24	20	8	5	90	35.0	25.0
	2 - Clear	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	14	11	45	30	24	20	8	5	90	35.0	25.0
Cabinet Door	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	13	9	45	30	23	20	8	4	90	30.0	22.5
	2 - Clear	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	13	9	45	30	23	20	8	4	90	30.0	22.5
Cabinet Drawer	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	13	9	45	30	23	20	8	4	90	30.0	22.5
	2 - Clear	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	13	9	45	30	23	20	8	4	90	30.0	22.5
Cabinet Frame Large	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	14	11	45	30	24	20	8	5	90	35.0	25.0
	2 - Clear	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	14	11	45	30	24	20	8	5	90	35.0	25.0
Cabinet Frame Medium	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	14	11	45	30	24	20	8	5	90	35.0	25.0
	2 - Clear	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	14	11	45	30	24	20	8	5	90	35.0	25.0
Cabinet Frame Small	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	14	11	45	30	24	20	8	5	90	35.0	25.0
	2 - Clear	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	14	11	45	30	24	20	8	5	90	35.0	25.0
Car Bumper	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	14	11	45	30	24	20	8	5	90	35.0	25.0
	2 - Clear	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	14	11	45	30	24	20	8	5	90	35.0	25.0
Car Door	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	11	8	45	30	21	20	8	4	90	25.0	17.5
	2 - Clear	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	11	8	45	30	21	20	8	4	90	25.0	17.5
Car Fender	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	13	9	45	30	23	20	8	4	90	30.0	22.5
	2 - Clear	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	13	9	45	30	23	20	8	4	90	30.0	22.5
Car Hood	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	11	8	45	30	21	20	8	4	90	25.0	17.5
	2 - Clear	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	11	8	45	30	21	20	8	4	90	25.0	17.5
Corner	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	11	8	45	30	21	20	8	4	90	25.0	17.5
	2 - Clear	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	11	8	45	30	21	20	8	4	90	25.0	17.5
Corners Interior	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	11	8	45	30	21	20	8	4	90	25.0	17.5
	2 - Clear	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	11	8	45	30	21	20	8	4	90	25.0	17.5
Cylinder Horizontal	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	13	9	45	30	23	20	8	4	90	30.0	22.5
	2 - Clear	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	13	9	45	30	23	20	8	4	90	30.0	22.5
Cylinder Large	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	11	8	45	30	21	20	8	4	90	25.0	17.5
	2 - Clear	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	11	8	45	30	21	20	8	4	90	25.0	17.5
Cylinder Vertical	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	13	9	45	30	23	20	8	4	90	30.0	22.5
	2 - Clear	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	13	9	45	30	23	20	8	4	90	30.0	22.5
Cylinder Combined	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	13	9	45	30	23	20	8	4	90	30.0	22.5
	2 - Clear	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	13	9	45	30	23	20	8	4	90	30.0	22.5
Dining Chair	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	13	9	45	30	23	20	8	4	90	30.0	22.5
	2 - Clear	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	13	9	45	30	23	20	8	4	90	30.0	22.5
Dining Table	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	13	9	45	30	23	20	8	4	90	30.0	22.5
	2 - Clear	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	13	9	45	30	23	20	8	4	90	30.0	22.5
Engine Cowling	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	11	8	45	30	21	20	8	4	90	25.0	17.5
	2 - Clear	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	11	8	45	30	21	20	8	4	90	25.0	17.5
Flat Panel	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	11	8	45	30	21	20	8	4	90	25.0	17.5
	2 - Clear	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	11	8	45	30	21	20	8	4	90	25.0	17.5

HVLP																		Metric		
PART	COAT	TIPSIZE	AIR PRESSURE (bar)			FLUID PRESSURE (bar)			DRY FILM THICKNESS (µm)			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
Fridge End Panel	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	11	8	45	30	21	20	8	4	90	25.0	17.5
	2 - Clear	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	11	8	45	30	21	20	8	4	90	25.0	17.5
Gas Tank	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	14	11	45	30	24	20	8	5	90	35.0	25.0
	2 - Clear	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	14	11	45	30	24	20	8	5	90	35.0	25.0
Half Barrel	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	13	9	45	30	23	20	8	4	90	30.0	22.5
	2 - Clear	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	13	9	45	30	23	20	8	4	90	30.0	22.5
H Beam	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	13	9	45	30	23	20	8	4	90	30.0	22.5
	2 - Clear	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	13	9	45	30	23	20	8	4	90	30.0	22.5
Headboard	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	11	8	45	30	21	20	8	4	90	25.0	17.5
	2 - Clear	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	11	8	45	30	21	20	8	4	90	25.0	17.5
Horizontal Car Hood	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	11	8	45	30	21	20	8	4	90	25.0	17.5
	2 - Clear	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	11	8	45	30	21	20	8	4	90	25.0	17.5
Horizontal Wagon Roof	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	11	8	45	30	21	20	8	4	90	25.0	17.5
	2 - Clear	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	11	8	45	30	21	20	8	4	90	25.0	17.5
HVLP H-Beam	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	13	9	45	30	23	20	8	4	90	30.0	22.5
	2 - Clear	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	13	9	45	30	23	20	8	4	90	30.0	22.5
HVLP I-Beam	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	13	9	45	30	23	20	8	4	90	30.0	22.5
	2 - Clear	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	13	9	45	30	23	20	8	4	90	30.0	22.5
I Beam	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	13	9	45	30	23	20	8	4	90	30.0	22.5
	2 - Clear	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	13	9	45	30	23	20	8	4	90	30.0	22.5
Large Set Panel	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	11	8	45	30	21	20	8	4	90	25.0	17.5
	2 - Clear	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	11	8	45	30	21	20	8	4	90	25.0	17.5
Lattice	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	14	11	45	30	24	20	8	5	90	35.0	25.0
	2 - Clear	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	14	11	45	30	24	20	8	5	90	35.0	25.0
Motorcycle Fender	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	13	9	45	30	23	20	8	4	90	30.0	22.5
	2 - Clear	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	13	9	45	30	23	20	8	4	90	30.0	22.5
Panel Curve	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	13	9	45	30	23	20	8	4	90	30.0	22.5
	2 - Clear	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	13	9	45	30	23	20	8	4	90	30.0	22.5
Panel Curve Complex	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	13	9	45	30	23	20	8	4	90	30.0	22.5
	2 - Clear	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	13	9	45	30	23	20	8	4	90	30.0	22.5
Panel Horizontal	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	11	8	45	30	21	20	8	4	90	25.0	17.5
	2 - Clear	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	11	8	45	30	21	20	8	4	90	25.0	17.5
Panel Vertical	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	11	8	45	30	21	20	8	4	90	25.0	17.5
	2 - Clear	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	11	8	45	30	21	20	8	4	90	25.0	17.5
Panel with Cutouts	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	13	9	45	30	23	20	8	4	90	30.0	22.5
	2 - Clear	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	13	9	45	30	23	20	8	4	90	30.0	22.5
Panel with Grooves	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	14	11	45	30	24	20	8	5	90	35.0	25.0
	2 - Clear	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	14	11	45	30	24	20	8	5	90	35.0	25.0
Panel with Shapes	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	13	9	45	30	23	20	8	4	90	30.0	22.5
	2 - Clear	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	13	9	45	30	23	20	8	4	90	30.0	22.5
Pylon Exterior	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	13	9	45	30	23	20	8	4	90	30.0	22.5
	2 - Clear	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	13	9	45	30	23	20	8	4	90	30.0	22.5
Pylon Interior	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	13	9	45	30	23	20	8	4	90	30.0	22.5
	2 - Clear	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	13	9	45	30	23	20	8	4	90	30.0	22.5
Sphere Half	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	14	11	45	30	24	20	8	5	90	35.0	25.0
	2 - Clear	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	14	11	45	30	24	20	8	5	90	35.0	25.0
Strut Panel	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	11	8	45	30	21	20	8	4	90	25.0	17.5
	2 - Clear	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	11	8	45	30	21	20	8	4	90	25.0	17.5
Vertical Panel	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	11	8	45	30	21	20	8	4	90	25.0	17.5
	2 - Clear	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	11	8	45	30	21	20	8	4	90	25.0	17.5
Vertical Piece	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	11	8	45	30	21	20	8	4	90	25.0	17.5
	2 - Clear	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	11	8	45	30	21	20	8	4	90	25.0	17.5
Wavy Panel	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	11	8	45	30	21	20	8	4	90	25.0	17.5
	2 - Clear	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	11	8	45	30	21	20	8	4	90	25.0	17.5
Wing Panel	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	11	8	45	30	21	20	8	4	90	25.0	17.5
	2 - Clear	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	11	8	45	30	21	20	8	4	90	25.0	17.5
Wood Panel	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	11	8	45	30	21	20	8	4	90	25.0	17.5
	2 - Clear	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	11	8	45	30	21	20	8	4	90	25.0	17.5



HVLP CONVEYOR																	Metric			
PART	COAT	TIPSIZE	AIR PRESSURE (bar)			FLUID PRESSURE (bar)			DRY FILM THICKNESS (µm)			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	41	14	11	45	30	24	20	8	5	90	35.0	25.0
Box	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	11	8	45	30	21	20	8	4	90	25.0	17.5
Cabinet Door	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	13	9	45	30	23	20	8	4	90	30.0	22.5
Cabinet Drawer	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	13	9	45	30	23	20	8	4	90	30.0	22.5
Cabinet Frame Large	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	14	11	45	30	24	20	8	5	90	35.0	25.0
Cabinet Frame Medium	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	14	11	45	30	24	20	8	5	90	35.0	25.0
Cabinet Frame Small	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	14	11	45	30	24	20	8	5	90	35.0	25.0
Car Bumper	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	14	11	45	30	24	20	8	5	90	35.0	25.0
Car Door	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	11	8	45	30	21	20	8	4	90	25.0	17.5
Car Fender	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	11	8	45	30	21	20	8	4	90	25.0	17.5
Car Hood	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	11	8	45	30	21	20	8	4	90	25.0	17.5
Corner	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	11	8	45	30	21	20	8	4	90	25.0	17.5
Corners Interior	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	11	8	45	30	21	20	8	4	90	25.0	17.5
Cylinder Horizontal	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	13	9	45	30	23	20	8	4	90	30.0	22.5
Cylinder Large	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	11	8	45	30	21	20	8	4	90	25.0	17.5
Cylinder Vertical	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	13	9	45	30	23	20	8	4	90	30.0	22.5
Cylinder Combined	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	13	9	45	30	23	20	8	4	90	30.0	22.5
Flat Panel	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	11	8	45	30	21	20	8	4	90	25.0	17.5
Fridge End Panel	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	11	8	45	30	21	20	8	4	90	25.0	17.5
Headboard	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	11	8	45	30	21	20	8	4	90	25.0	17.5
Lattice	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	14	11	45	30	24	20	8	5	90	35.0	25.0
Motorcycle Fender	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	13	9	45	30	23	20	8	4	90	30.0	22.5
Panel Curve	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	13	9	45	30	23	20	8	4	90	30.0	22.5
Panel Curve Complex	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	13	9	45	30	23	20	8	4	90	30.0	22.5
Panel Horizontal	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	11	8	45	30	21	20	8	4	90	25.0	17.5
Panel Vertical	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	11	8	45	30	21	20	8	4	90	25.0	17.5
Panel with Cutouts	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	13	9	45	30	23	20	8	4	90	30.0	22.5
Panel with Grooves	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	14	11	45	30	24	20	8	5	90	35.0	25.0
Panel with Shapes	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	13	9	45	30	23	20	8	4	90	30.0	22.5
Sphere Half	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	14	11	45	30	24	20	8	5	90	35.0	25.0
Vertical Panel	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	11	8	45	30	21	20	8	4	90	25.0	17.5
Vertical Piece	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	11	8	45	30	21	20	8	4	90	25.0	17.5
Wavy Panel	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	11	8	45	30	21	20	8	4	90	25.0	17.5
Wood Panel	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	11	8	45	30	21	20	8	4	90	25.0	17.5

HVLP EDGE BLENDING																	Metric			
PART	COAT	TIPSIZE	AIR PRESSURE (bar)			FLUID PRESSURE (bar)			DRY FILM THICKNESS (µm)			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	41	11	9	45	30	21	20	8	N/A	90	25.0	17.5
Repair Car Door-Fender	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	11	9	45	30	21	20	8	N/A	90	25.0	17.5
Repair Vertical Panel	1 - Color	1.2	2.4	0.7	0.6	N/A	N/A	N/A	41	11	9	45	30	21	20	8	N/A	90	25.0	17.5

BLASTING														Metric
PART	COAT	MEDIA	AIR PRESSURE (bar)		FLUID PRESSURE (bar)		DRY FILM THICKNESS (µm)		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	Any	N/A	N/A	N/A	N/A	89	42	N/A	N/A	53	13	5	45
ACQPA Panel Cylinder	1 - Color	Any	N/A	N/A	N/A	N/A	89	42	N/A	N/A	53	13	5	45
ACQPA Panel Horizontal	1 - Color	Any	N/A	N/A	N/A	N/A	89	42	N/A	N/A	53	13	5	45
ACQPA Panel Vertical	1 - Color	Any	N/A	N/A	N/A	N/A	89	42	N/A	N/A	53	13	5	45
ASTM Deep T	1 - Color	Any	N/A	N/A	N/A	N/A	89	42	N/A	N/A	53	13	5	45
ASTM H Beam	1 - Color	Any	N/A	N/A	N/A	N/A	89	42	N/A	N/A	53	13	5	45
ASTM Panel	1 - Color	Any	N/A	N/A	N/A	N/A	89	42	N/A	N/A	53	13	5	45
ASTM Pipe	1 - Color	Any	N/A	N/A	N/A	N/A	89	42	N/A	N/A	53	13	5	45
Box	1 - Color	Any	N/A	N/A	N/A	N/A	89	35	N/A	N/A	53	8	5	45
Bridge Section	1 - Color	Any	N/A	N/A	N/A	N/A	89	42	N/A	N/A	53	13	5	45
Car Bumper	1 - Color	Any	N/A	N/A	N/A	N/A	89	42	N/A	N/A	53	13	5	45
Car Door	1 - Color	Any	N/A	N/A	N/A	N/A	89	35	N/A	N/A	53	8	5	45
Car Fender	1 - Color	Any	N/A	N/A	N/A	N/A	89	38	N/A	N/A	53	10	5	45
Car Hood	1 - Color	Any	N/A	N/A	N/A	N/A	89	35	N/A	N/A	53	8	5	45
Corner	1 - Color	Any	N/A	N/A	N/A	N/A	89	35	N/A	N/A	53	8	5	45
Corners Interior	1 - Color	Any	N/A	N/A	N/A	N/A	89	35	N/A	N/A	53	8	5	45
Cylinder Horizontal	1 - Color	Any	N/A	N/A	N/A	N/A	89	38	N/A	N/A	53	10	5	45
Cylinder Large	1 - Color	Any	N/A	N/A	N/A	N/A	89	35	N/A	N/A	53	8	5	45
Cylinder Vertical	1 - Color	Any	N/A	N/A	N/A	N/A	89	38	N/A	N/A	53	10	5	45
Cylinder Combined	1 - Color	Any	N/A	N/A	N/A	N/A	89	38	N/A	N/A	53	10	5	45
Flat Panel	1 - Color	Any	N/A	N/A	N/A	N/A	89	35	N/A	N/A	53	8	5	45
Gas Tank	1 - Color	Any	N/A	N/A	N/A	N/A	89	42	N/A	N/A	53	13	5	45
Half Barrel	1 - Color	Any	N/A	N/A	N/A	N/A	89	38	N/A	N/A	53	10	5	45
H Beam	1 - Color	Any	N/A	N/A	N/A	N/A	89	38	N/A	N/A	53	10	5	45
Horizontal Car Hood	1 - Color	Any	N/A	N/A	N/A	N/A	89	35	N/A	N/A	53	8	5	45
Horizontal Wagon Roof	1 - Color	Any	N/A	N/A	N/A	N/A	89	35	N/A	N/A	53	8	5	45
HVLP H Beam	1 - Color	Any	N/A	N/A	N/A	N/A	89	38	N/A	N/A	53	10	5	45
HVLP I Beam	1 - Color	Any	N/A	N/A	N/A	N/A	89	38	N/A	N/A	53	10	5	45
I Beam	1 - Color	Any	N/A	N/A	N/A	N/A	89	38	N/A	N/A	53	10	5	45
Large Set Panel	1 - Color	Any	N/A	N/A	N/A	N/A	89	35	N/A	N/A	53	8	5	45
Motorcycle Fender	1 - Color	Any	N/A	N/A	N/A	N/A	89	38	N/A	N/A	53	10	5	45
Panel Curve	1 - Color	Any	N/A	N/A	N/A	N/A	89	38	N/A	N/A	53	10	5	45
Panel Curve Complex	1 - Color	Any	N/A	N/A	N/A	N/A	89	38	N/A	N/A	53	10	5	45
Panel Horizontal	1 - Color	Any	N/A	N/A	N/A	N/A	89	35	N/A	N/A	53	8	5	45
Panel Vertical	1 - Color	Any	N/A	N/A	N/A	N/A	89	35	N/A	N/A	53	8	5	45
Panel with Cutouts	1 - Color	Any	N/A	N/A	N/A	N/A	89	38	N/A	N/A	53	10	5	45
Panel with Grooves	1 - Color	Any	N/A	N/A	N/A	N/A	89	42	N/A	N/A	53	13	5	45
Panel with Shapes	1 - Color	Any	N/A	N/A	N/A	N/A	89	38	N/A	N/A	53	10	5	45
Sphere Half	1 - Color	Any	N/A	N/A	N/A	N/A	89	42	N/A	N/A	53	13	5	45
Vertical Panel	1 - Color	Any	N/A	N/A	N/A	N/A	89	35	N/A	N/A	53	8	5	45
Vertical Piece	1 - Color	Any	N/A	N/A	N/A	N/A	89	35	N/A	N/A	53	8	5	45
Wavy Panel	1 - Color	Any	N/A	N/A	N/A	N/A	89	35	N/A	N/A	53	8	5	45

POWDER COATING																	Metric						
PART	COAT	TIP	CURRENT (µA)			POWDER DELIVERY (%)			TOTAL AIR (Nm <sup>3</sup> /h)			VOLTAGE (kV)			DRY FILM THICKNESS (µm)			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	7	50	10	7	50	10	7	65	15	10	65	38	19	20	8	5	90	25	15
Box	1 - Color	Flat 45	60	10	7	50	10	7	50	10	7	65	15	10	65	38	19	20	8	5	90	25	15
Corner	1 - Color	Flat 45	60	10	7	50	10	7	50	10	7	65	15	10	65	38	19	20	8	5	90	25	15
Corners Interior	1 - Color	Flat 45	60	10	7	50	10	7	50	10	7	65	15	10	65	38	19	20	8	5	90	25	15
Cylinder Horizontal	1 - Color	Flat 30	60	10	7	50	10	7	50	10	7	65	15	10	65	38	19	20	8	5	90	25	15
Cylinder Large	1 - Color	Deflector	60	10	7	50	10	7	50	10	7	65	15	10	65	38	19	20	8	5	90	25	15
Cylinder Vertical	1 - Color	Flat 30	60	10	7	50	10	7	50	10	7	65	15	10	65	38	19	20	8	5	90	25	15
Cylinder Combined	1 - Color	Flat 30	60	10	7	50	10	7	50	10	7	65	15	10	65	38	19	20	8	5	90	25	15
Flat Panel	1 - Color	Flat 65	60	10	7	50	10	7	50	10	7	65	15	10	65	38	19	20	8	5	90	25	15
L Channels	1 - Color	Deflector	60	10	7	50	10	7	50	10	7	65	15	10	65	38	19	20	8	5	90	25	15
Panel Curve	1 - Color	Deflector	60	10	7	50	10	7	50	10	7	65	15	10	65	38	19	20	8	5	90	25	15
Panel Curve Complex	1 - Color	Deflector	60	10	7	50	10	7	50	10	7	65	15	10	65	38	19	20	8	5	90	25	15
Panel Horizontal	1 - Color	Deflector	60	10	7	50	10	7	50	10	7	65	15	10	65	38	19	20	8	5	90	25	15
Panel Sampler	1 - Color	Flat 30	60	10	7	50	10	7	50	10	7	65	15	10	65	38	19	20	8	5	90	25	15
Panel Vertical	1 - Color	Deflector	60	10	7	50	10	7	50	10	7	65	15	10	65	38	19	20	8	5	90	25	15
Panel with Cutouts	1 - Color	Deflector	60	10	7	50	10	7	50	10	7	65	15	10	65	38	19	20	8	5	90	25	15
Panel with Grooves	1 - Color	Flat 45	60	10	7	50	10	7	50	10	7	65	15	10	65	38	19	20	8	5	90	25	15
Panel with Shapes	1 - Color	Deflector	60	10	7	50	10	7	50	10	7	65	15	10	65	38	19	20	8	5	90	25	15
Propeller	1 - Color	Flat 50	60	10	7	50	10	7	50	10	7	65	15	10	65	38	19	20	8	5	90	25	15
Quarter Box Back	1 - Color	Flat 50	60	10	7	50	10	7	50	10	7	65	15	10	65	38	19	20	8	5	90	25	15
Quarter Box Front	1 - Color	Flat 50	60	10	7	50	10	7	50	10	7	65	15	10	65	38	19	20	8	5	90	25	15
Sphere Half	1 - Color	Deflector	60	10	7	50	10	7	50	10	7	65	15	10	65	38	19	20	8	5	90	25	15
U Channels Large	1 - Color	Deflector	60	10	7	50	10	7	50	10	7	65	15	10	65	38	19	20	8	5	90	25	15
U Channels Small	1 - Color	Deflector	60	10	7	50	10	7	50	10	7	65	15	10	65	38	19	20	8	5	90	25	15
Vertical Panel With Holes	1 - Color	Flat 65	60	10	7	50	10	7	50	10	7	65	15	10	65	38	19	20	8	5	90	25	15
Wavy Panel	1 - Color	Flat 50	60	10	7	50	10	7	50	10	7	65	15	10	65	38	19	20	8	5	90	25	15

POWDER COATING CONVEYOR																	Metric						
PART	COAT	TIP	CURRENT (µA)			POWDER DELIVERY (%)			TOTAL AIR (Nm <sup>3</sup> /h)			VOLTAGE (kV)			DRY FILM THICKNESS (µm)			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			
Acute Crease	1 - Color	Flat 50	60	10	7	50	10	7	50	10	7	65	15	10	65	38	19	20	8	5	90	25	15
Box	1 - Color	Flat 45	60	10	7	50	10	7	50	10	7	65	15	10	65	38	19	20	8	5	90	25	15
Corner	1 - Color	Flat 45	60	10	7	50	10	7	50	10	7	65	15	10	65	38	19	20	8	5	90	25	15
Corners Interior	1 - Color	Flat 45	60	10	7	50	10	7	50	10	7	65	15	10	65	38	19	20	8	5	90	25	15
Cylinder Horizontal	1 - Color	Flat 30	60	10	7	50	10	7	50	10	7	65	15	10	65	38	19	20	8	5	90	25	15
Cylinder Large	1 - Color	Deflector	60	10	7	50	10	7	50	10	7	65	15	10	65	38	19	20	8	5	90	25	15
Cylinder Vertical	1 - Color	Flat 30	60	10	7	50	10	7	50	10	7	65	15	10	65	38	19	20	8	5	90	25	15
Cylinder Combined	1 - Color	Flat 30	60	10	7	50	10	7	50	10	7	65	15	10	65	38	19	20	8	5	90	25	15
Flat Panel	1 - Color	Flat 65	60	10	7	50	10	7	50	10	7	65	15	10	65	38	19	20	8	5	90	25	15
L Channels	1 - Color	Deflector	60	10	7	50	10	7	50	10	7	65	15	10	65	38	19	20	8	5	90	25	15
Panel Curve	1 - Color	Deflector	60	10	7	50	10	7	50	10	7	65	15	10	65	38	19	20	8	5	90	25	15
Panel Curve Complex	1 - Color	Deflector	60	10	7	50	10	7	50	10	7	65	15	10	65	38	19	20	8	5	90	25	15
Panel Horizontal	1 - Color	Deflector	60	10	7	50	10	7	50	10	7	65	15	10	65	38	19	20	8	5	90	25	15
Panel Sampler	1 - Color	Flat 30	60	10	7	50	10	7	50	10	7	65	15	10	65	38	19	20	8	5	90	25	15
Panel Vertical	1 - Color	Deflector	60	10	7	50	10	7	50	10	7	65	15	10	65	38	19	20	8	5	90	25	15
Panel with Cutouts	1 - Color	Deflector	60	10	7	50	10	7	50	10	7	65	15	10	65	38	19	20	8	5	90	25	15
Panel with Grooves	1 - Color	Flat 45	60	10	7	50	10	7	50	10	7	65	15	10	65	38	19	20	8	5	90	25	15
Panel with Shapes	1 - Color	Deflector	60	10	7	50	10	7	50	10	7	65	15	10	65	38	19	20	8	5	90	25	15
Propeller	1 - Color	Flat 50	60	10	7	50	10	7	50	10	7	65	15	10	65	38	19	20	8	5	90	25	15
Quarter Box Back	1 - Color	Flat 50	60	10	7	50	10	7	50	10	7	65	15	10	65	38	19	20	8	5	90	25	15
Quarter Box Front	1 - Color	Flat 50	60	10	7	50	10	7	50	10	7	65	15	10	65	38	19	20	8	5	90	25	15
Sphere Half	1 - Color	Deflector	60	10	7	50	10	7	50	10	7	65	15	10	65	38	19	20	8	5	90	25	15
U Channels Large	1 - Color	Deflector	60	10	7	50	10	7	50	10	7	65	15	10	65	38	19	20	8	5	90	25	15
U Channels Small	1 - Color	Deflector	60	10	7	50	10	7	50	10	7	65	15	10	65	38	19	20	8	5	90	25	15
Vertical Panel With Holes	1 - Color	Flat 65	60	10	7	50	10	7	50	10	7	65	15	10	65	38	19	20	8	5	90	25	15
Wavy Panel	1 - Color	Flat 50	60	10	7	50	10	7	50	10	7	65	15	10	65	38	19	20	8	5	90	25	15