

HVLP																			Metric	
PART	COAT	TIP SIZE	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
	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
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
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
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
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
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

HVLP																		Metric		
PART	COAT	TIP SIZE	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
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
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
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
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
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 EDGE BLENDING																		Metric		
PART	COAT	TIP SIZE	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