



How to Powder Coat with the Gema Optiflex 2 Manual Powder Coating Gun

This overview of **how to powder coat** and use the OptiFlex®2 manual powder coating system is a starting reference point only, actual application values may be different.

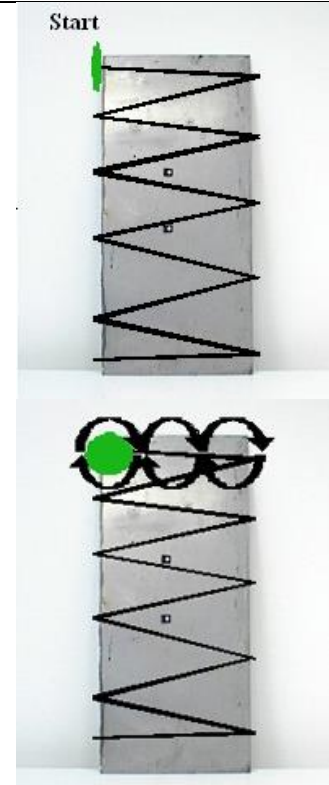
How to Powder Coat Flat Parts

Preferred Tip: Flat spray, Vertically aligned

1. Start by triggering at the upper most corner of the part
2. Allow gun-to-part distance: 15cm-25cm (6-10")
3. Make a zigzag pattern until you reach the thickness needed
4. Go slowly, let the gun do the work
5. The slower you go...The easier and faster you build the film thickness
6. Overlap patterns for improved uniformity

Alternative Tip: Deflector tip, 24 or 32mm

1. Start by triggering at the upper most corner of the part
2. Maintain gun-to-part distance: 15cm-25cm (6-10")
3. Making a slow swirling action across the part in a zigzag pattern
4. Go slowly, let the gun do the work
5. The slower you go... The easier and faster you build the film thickness
6. Overlap patterns for improved uniformity

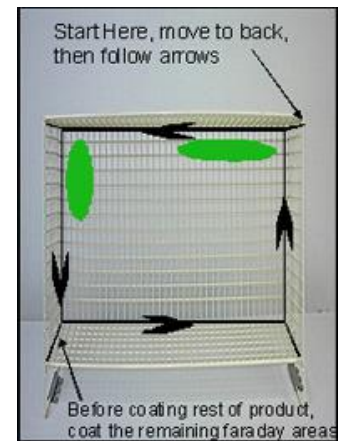


How to Powder Coat Complicated Parts Wire Basket

For flat spray, Align the pattern with the direction of the faraday area

For wire shelving a deflector tip may be preferred, 24 mm

1. Start by triggering at the upper most corner of the part
2. Moving the gun inward
3. Coat faraday areas first
4. Follow a uniform direction
5. Maintain gun-to-part distance:
Recessed area: 5cm-10cm (2-4")
Rest of product: 10cm-15cm (4"-6")
6. Align the spray pattern with the direction of travel
7. Finish remaining faraday areas, then cover the rest of product.
8. Go slowly, let the gun do the work



How to powder coat previously powder coated items – (Recoats)

1. Adjust the electrostatic parameters
2. An increase in powder delivery will be required (10-20%)
3. No adjustment to total air, rinsing air, or fluidizing air
4. Increase gun-to-part target distance
5. Flat parts: 20cm-25cm (8"-10")
6. Complicated parts with faraday areas
7. Baskets; 10cm 20cm (4"-8")
8. Inside cavities: 12cm-22cm (5"-9")
9. Use same application technique or gun motion
10. Use same nozzle configuration

