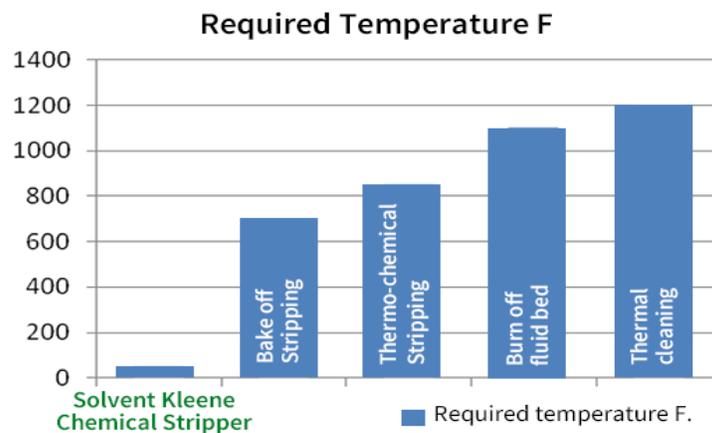




## STRIPPING CURED POWDER COATING

Companies engaged in powder coating face issues of coating build up removal from hooks, racks, hangers and rejected parts. The techniques used for removal can include cold chemicals such as those offered by Solvent Kleene, Inc., mechanical methods or thermal or thermo chemicals offered by others.



**MECHANICAL STRIPPING** utilizes blasting media such as CO<sup>2</sup> pellets, glass beads, steel shots, etc. These are blasted at the coated surface and remove the coating by abrasion. Aggressive media will remove the coating but can leave a rough profile on the metal surface of parts that have been stripped and will need to be repaired.

**THERMAL CLEANING** uses heat to break down the coating but creates ash residue which requires removal by water blast. Thermal cleaning can be done by baking the coating, burning off or by fluidized bed. The key to this technique requires the parts to be resistant to the high temperatures employed, which can reach 1200°F/648°C.

**BAKE OFF** is a technique utilizing an oven with temperatures about 700°F/370°C. This temperature will eventually ignite the powder coating. Such ovens have a water mist system which slows the burning and reduces equipment damage. The left over ash residue must be completely cleaned off.

**BURN-OFF / FLUID BED** requires 1100°F/590°C temperatures. The coating burns quickly and water is then used to stop the burning and remove the excess ash. Fluid bed stripping uses sand for heat transfer. The parts are placed in the fluidized tank where the hot sand, 800°F/426°C, removes the coating. No additional cleaning will be needed, the sand provides the scrubbing action.

**THERMO-CHEMICAL** stripping uses a combination of heat and chemical reaction. This is also known as “molten salt stripping”. The working temperature is 850°F/454°C.

**ROOM TEMPERATURE STRIPPING** Solvent Kleene, Inc.’s “cold” chemicals perform at room temperature or low heat of 135°F/57°C. This powder coat stripping method is suggested by Solvent Kleene, Inc. The chemicals are environmentally preferred and are safer for the operator. The chemicals dissolve the powder coat binders requiring an easy rinse after immersion. These room temperature powder coat strippers are used to strip parts as well as hangers, racks and hooks. This technique is very cost effective using an immersion tank. Exhaust ventilation is highly recommended.

For powder coating removal at room temperature or low temperature of 135°F/57°C Solvent Kleene offers:

- D-Zolve 1012 dissolves powder coating at room temperature
- D-Zolve 319 dissolves powder coating at room temperature
- D-Zolve 917 strips powder coating at 135°F/57°C

FREE SAMPLES ARE AVAILABLE



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