

Jinan Mech Piping Technology Co.,Ltd



**Operation Process of
Epoxy Powder Spraying**

ARTIST OF SURFACE COATING

Operation Process of Epoxy Powder Spraying

1. Range

The operation process focus on the manufacturing technique of Epoxy Powder Spraying and quality test.

2. Equipment

Preheating furnace, Spray space, Curing oven

3. Technological process of pipe with epoxy coating

Quality Inspection of Raw Material----Shot Blasting---- Load Epoxy Powder Material (The Internal and External Blow) ----Preheat----Outside spraying——Curing——air patenting----Body Marking---- Quality Inspection---- Packaging



Spray space



Details of The Epoxy Coating Pipe



Pipe Quality Inspection

3.4 Manufacturing Technique

3.4.1 Epoxy Coating $\leq 75 \mu m$:

Size	Quantity Once Produced	Temperature of Curing Oven		Solidification Time	Preheating Furnace Temperature	Chain Speed
		Oct.—Mar.	Apr.—Sep.			
1/2、3/4	10	1 st Curing Oven 240±10℃ 2 nd Curing Oven 230±10℃	1 st Curing Oven 230±10℃ 2 nd Curing Oven 220±10℃	15-20min	230℃	45-50HZ
1、11/4、 11/2、2	8					
21/2、3、	6					
4	4					
5、6	2					
8	1	1 st Curing Oven 240±10℃ 2 nd Curing Oven 230±10℃	1 st Curing Oven 230±10℃ 2 nd Curing Oven 220±10℃			

3.4.2 Epoxy Coating $\geq 100 \mu m$:

Size	Quantity Once Produced	Temperature of Curing Oven		Solidification Time	Chain Speed	Preheating Furnace Temperature	Compensation Heat Temperature
		Oct.—Mar.	Apr.—Sep.				
1/2、3/4	10	1 st Curing Oven 240±10℃ 2 nd Curing Oven 230±10℃	1 st Curing Oven 230±10℃ 2 nd Curing Oven 220±10℃	18-25min	40-45HZ	230℃	150-230℃
1、11/4、 11/2、2	8						
21/2、3	6						
4	4						
5、6	2						
8	1	1 st Curing Oven 240±10℃ 2 nd Curing Oven 230±10℃	1 st Curing Oven 230±10℃ 2 nd Curing Oven 220±10℃				

4. Spray Gun arrangement in the Productive Process

8” Pipe Need 18 Spray Gun Open Together

Spray Gun No.	Powder spraying Concentration (Kg/CM ²)	Atomization Concentration (Kg/CM ²)
West 9 th —West 1 st	0.8-2. 0	0.5—1.5
East 9 th -- East 1 st	0.8-2. 0	0.5—1.5

6” Pipe Need 16 Spray Gun Open Together

Spray Gun No.	Powder spraying Concentration (Kg/CM ²)	Atomization Concentration (Kg/CM ²)
West 9 th —West 2 nd	0.8-2. 0	0.5—1.5
East 9 th -- East 2 nd	0.8-2. 0	0.5—1.5

4” Pipe Need 16 Spray Gun Open Together

Spray Gun No.	Powder spraying Concentration (Kg/CM ²)	Atomization Concentration (Kg/CM ²)
West 9 th —West 2 nd	0.8-2. 0	0.5—1.5
East 9 th -- East 2 nd	0.8-2. 0	0.5—1.5

2” Pipe Need 12 Spray Gun Open Together

Spray Gun No.	Powder spraying Concentration (Kg/CM ²)	Atomization Concentration (Kg/CM ²)
West 9 th , 8 th , 6 th ,5 th ,3 rd ,2 nd	0.8-2. 0	0.5—1.5
East 9 th , 8 th , 6 th ,5 th ,3 rd ,2 nd	0.8-2. 0	0.5—1.5

1” Pipe Need 6 Spray Gun Open Together

Spray Gun No.	Powder spraying Concentration (Kg/CM ²)	Atomization Concentration (Kg/CM ²)
West 8 th , 7 th ,5 th ,4 th ,2 nd , 1 st	0.8-2. 0	0.5—1.5

Epoxy Coated Steel Pipe

Specification:

Coating Material: **Epoxy Resin Powder**

Coating Color: **Red, Blue, Yellow**

Coating Thickness: **40-300um**

Size: **1/2"---8"**

Normal Pressure: **0.1 Mpa--5Mpa**

Connection: **Grooved, Threaded, Flanged**

Application: **Water System, Fire-Fighting System HAVC System**



Advantages:

Environmental Friendly

Epoxy outside, or both outside & inside

Good Adhesion/Durability

High Resistance to the Corrosion

Resistance to blows and Chemical Aggressions

Better Appearance

Drinking Water System



MECH PIPING
迈科管道

ARTIST OF SURFACE COATING

- HDG
- Liquor Painting
- Epoxy Powder & Polyester Coating
- Plastic Lining
- Double Coating

