

# Powder Coating Process

Our Powder Coating Process utilizes the **Powdura OneCure Powder System** to ensure a long lasting beautiful finish. Powdura OneCure is a single cure, dry on dry primer and topcoat powder system that offers the best of both world when it comes to performance in extreme conditions, as well as color and gloss retention. Powdura OneCure offers the following advantages over liquid coating or traditional DTM powders:

- > Higher corrosion resistance, better color & gloss retention
- > Advanced protection against edge corrosion
- > Better impact/adhesion to metal
- > Exceptional smoothness and appearance
- > Excellent surface hardness and resistance to chipping and marring
- > Zero VOC vs liquid

## 1. BLAST

Each trailer is blasted with steel shot to remove all rust and mill scale from metals produced during the manufacturing process. This thorough blasting creates the proper anchor profile that ensures optimal adhesion for the Zinc Epoxy Primer Powder.

## 2. WASH

We then run the trailers through a two-stage automatic pretreatment cleaning process. The trailers first go through a Phosphate Metal Pretreatment Wash, which removes any foreign contaminants from the metal, inhibits rust and helps with paint adhesion. Next, they move into a final rinse stage to rinse the metal, promoting better adhesion to the blasted surface and ensuring a stronger bond with the powder coating.

## 3. DRYER

Immediately after the automatic pretreatment wash, the trailers enter a forced air dry-off oven. This ensures that any residual moisture is completely removed and the metal is thoroughly dry before beginning the powder coating process.

## 4. PRIMER

A single cure dry on dry Zinc Epoxy One Cure Primer is applied to the entire trailer frame. This covers the complete metal profile, ensuring optimal coverage during the curing process for the best adhesion and corrosion protection.

## 5. COLOR

In the second step, we apply dry-on-dry high gloss Onecure powder in all of our offered colors. The Sherwin William's advanced ultra-durable primer and top coat we use offers the highest quality color and gloss retention and an extremely durable UV finish for protection against weathering.

## 6. CURE

In the final step, our trailers enter the oven to undergo the curing process where all steel surpasses 425 degrees to ensure complete and even curing. The Powdura OneCure cross-links zinc primer and topcoat chemically to create a robust and high quality coating system. This process is highly corrosion and chip resistant and will extend the life of your trailer finish.



DOUBLE A RED



SAND DUNE TAN



ROYAL BLUE



RANGER GREEN



CATERPILLAR  
YELLOW



ANSI GREY



ENVIRO GREEN



HAZARD ORANGE



INDUSTRIAL GREEN



BLACK



WHITE



METALLIC  
CHARCOAL