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Coatings Review

News and Updates from Your Source for Quality Wood Finishing Solutions

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Regulatory Compliance - Spray Booth Daily Shutdown procedures

In the previous Coatings Review Issue we covered spray booth start-up procedures. This issue is focused on spray booth shut-down procedures. Shut-down procedures can be equally as important to employee and facility safety. Failure to complete all necessary procedures could endanger others, cause loss of time, loss of resource, and possibly result in fire. This sample procedure is a general guideline. When establishing facility operations, always consider specific equipment and coatings recommendations.

At the end of each shift or work day,

- Shut down product line conveyor systems.
- Turn off the air supply to pumps/spray equipment and relieve pressure per

“Failure to complete all necessary procedures could endanger others”

the equipment manufacturer’s recommendations.

NOTE! This is very important. Failure to do so may result in a spill or an unexpected release of pressure and product.

- Clean gun according to equipment manufacturers’ recommendations.

- Turn off mixing equipment.
- Ensure all coating containers have lids and are tightly closed.
- Turn off ventilation system.
- If filters are dirty or manometer readings are outside the acceptable operating range, change out booth filters according to the procedure that follows.
- Clean up overspray and lacquer dust according to the procedure that follows.
- If pot liners are used, dispose of according to the procedure that follows.
- Ensure all other equipment is turned off.

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Technical Tip - Pot Life & Performance

All catalyzed coatings have a specific length of time after catalyzation in which they should be applied to achieve peak performance. This time is called the “pot life” and is determined during product development and testing.

Many catalyzed coatings will gel when the pot life has expired, and be obviously unusable, but some, such as acrylics, may thicken only slightly or not at all. When a product appears useable after the pot life has passed there may

be a temptation to apply it as normal. The coating may spray and dry as always, but problems will arise in the finished product. Durability and chemical resistance will be lessened and

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Article Excerpt - Troubleshooting and preventing finishing issues

Most companies are facing competitive challenges that require them to look at ways to reduce costs and increase productivity. To achieve the goals of lean manufacturing, companies must consider three steps: Troubleshoot and correct their problems in finishing; closely manage and monitor the process; and provide continuing education and improvement to prevent finishing issues from reoccurring.

Troubleshooting

The first step is to identify what defects are occurring and why. A defect and rework log will need to be written and maintained. What is the most common root cause to look for when troubleshooting defects? Many finishing defects are caused by production issues before the product enters the finishing area. It is important to look back to the beginning of the production process to ensure the grade and species of wood is appropriate and carefully mated to the finishing system and color process used for finishing. Does the wood have the correct natural color? Is the wood substrate consistent in color and grain pattern? Is the pore and grain texture appropriate for the final finish effect required to meet customers' expectations?

Other "front end" manufacturing defects to look for are machining and sanding consistency of the product. If product is not finishing well, it may be caused by dull tooling or poor setup and alignment of the machining equipment. Countless finishing defects can be traced back to poor maintenance or inadequate dust collection of widebelt or random orbit sanders.

Handling and staging of the product should be critiqued to identify where damage may occur prior to finishing. Finishing defects from handling average approximately 15 to 20 percent of finishing department reworks.

To troubleshoot and correct root causes of finish defects or finish failures during the finishing process, spray operators will need to check the wet mil thickness of the coating to ensure the coating is being applied in compliance with the manufacturers' recommendations. This information should be documented for each process for future reference if a problem or defect should occur. Incorrect gloss levels may indicate a problem with inadequate agitation of the coating or in-line filter problems. Check to make sure filters are clean and are the correct mesh size for the coating to be sprayed.

Over 40 percent of finishing defects are caused by inadequate equipment maintenance and cleaning. This may result in the finish having an orange peel texture, uneven color and film build, and excessive runs and sags.

Process Management

There are four essential tools to provide managers the resources to effectively control a finishing process.

1. Finishing Schedules

A finishing schedule is a written procedure specific to the color and finishing system. All process parameters for each step of the finish system must be included in this document.

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Calendar Highlights Laugh Out Loud

Monday February

18th: Rudd Company will be closed in observance of President's Day. Freight companies will not deliver on Monday, February 18th.



Monday March 9th: Daylight savings time begins. Don't forget to set your clock forward 1 hour on Sunday before bed.

*Regular customer service hours are
Monday - Friday 7:30 am - 5:00pm PST*



the half-wit that works here about 18 hours a day. He makes \$10 a week and I buy him a case of beer every Friday," replied the owner
"That's the guy I want to talk to; the half wit," says the agent.
The owner says, "That would be me."

Employment Standards determined a small woodworking shop owner was not paying proper wages to his help and sent an agent out to interview him. "I need a list of your employees and how much you pay them," demanded the agent.
"Well, there's Jake my finisher who's been with me for 3 years, I pay him \$900 a week. The apprentice Tom has been here for 6 months, and I pay him \$500 a week. Then there's



Regulatory Compliance - Spray Booth Daily Shutdown Procedures (Continued)

- Ensure booth area is cleaned up and free of debris.
- Ensure all containers of solvents, dirty rags, solvent saturated supplies, overspray, etc. are in closed metal containers and removed from the work area.

Pot Liner Handling Procedure

1. Remove pot liners from pressure pot.
2. Pour excess material back into original drum or pail. Immediately take used pot liners outdoors to designated area.
3. Lay the liners out to dry.
4. When completely dry, place in metal pail labeled "Used Pot Liners" and cover with metal lid.

NOTE: NEVER MIX WET pot liners with other garbage

Spray Booth Filter Change-Out Procedure

1. Remove used filters from spray booth.
2. Place in metal drum labeled "Used Filters".
3. Wet with water.
4. Cover drum with metal lid.
5. Remove from spray booth.
6. Store drum outdoors in designated area.
7. When full, seal drum and dispose in dumpster.

Wiping Rag Handling Procedure

1. Immediately place used rags in metal flame-retarding oily waste can labeled "Contaminated Rags" and close lid.

2. At the end of each day, take used rags outside to designated area.
3. Place in metal drum labeled "Contaminated Rags" and cover with a tight or latching metal lid. Store drum outdoors in designated area.
4. When the drum is full of the rags, arrange for pick-up. Rags can either be shipped as hazardous waste or picked up by an industrial laundry service.

NOTE: If rags are not being laundered by a professional laundry service rags soiled with hazardous materials will designate as hazardous waste. **They cannot be dried and thrown away.** If rags are being shipped as hazardous waste, the oily waste can must be marked with the words "hazardous waste" and with the appropriate immediate hazard warnings, such as 'flammable' or 'toxic'.

Lacquer Dust Removal Procedure

1. Sweep floors in spray booth area at the end of each shift.
2. Use straw broom to prevent static electricity & aluminum dustpan to prevent sparking.
3. Place sweepings in metal pail and wet with water.
4. Cover with metal lid.
5. When full, seal lid and dispose of in dumpster.
6. Rinse broom and dustpan with water before storing.

For additional information regarding specific regulations and requirements, contact Rudd Company's Regulatory Manager, KaLyn Burmeister, at 1-800-444-7833 or kburmeister@ruddcompany.com.

Technical Tip - Pot Life & Performance (Continued)

the coating may mar very easily. In some cases, a haze may be seen on the film's surface.

Confusion regarding the time of catalyzation is often the cause of a coating being used after its pot life. Always note the catalyzation time and observe Rudd's pot life recommendations for peak performance.

For additional information or technical support, please contact Rudd Company's Technical Support Department at 1-800-444-7833 or techsupport@ruddcompany.com

Quotable Quotes

The difference between perseverance and obstinacy is that one comes from a strong will, and the other from a strong won't.

-Henry Ward Beecher

Don't be afraid to give your best to what seemingly are small jobs. Every time you conquer one it makes you that much stronger. If you do the little jobs well, the big ones will tend to take care of themselves.

-Dale Carnegie

The best executive is the one who has sense enough to pick good men to do what he wants done, and self-restraint enough to keep from meddling with them while they do it.

-Theodore Roosevelt



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Article Excerpt - Troubleshooting and preventing finishing issues (Continued)

2. Standard Operating Procedures (SOPS)

Standard operating procedures are step-by-step work instructions communicating all critical information on how to perform the procedure.

3. Quality Control Standards (QCS)

A written QCS document will describe what defects are allowed that will still meet the quality standards and what defects must be rejected. Most QCS documents include photography to illustrate each type of defect.

4. Coating Specifications

A coating specification is a written document that includes all physical and chemical properties of the coating being used in the process, basic process data on how the coating is used in the system, and the quality assurance test that the coating system equals or exceeds. This document provides the finishing manager

the information they need to ensure the durability and quality of the coating system.

Many spray operators prefer to perform their task in a manner they are used to. It is the responsibility of the manager to communicate to the employees that SOPs are written to help them do their job as efficiently as possible, using best practice standards.

Communication and Education

Education and communication are key to preventing defects and problems in finishing. It is our recommendation that finishing supervisors, project estimators, marketing directors and purchasing agents communicate together as a group before new projects are specified and

quoted.

Finishing managers should reserve time in the busy work schedule to meet with the finishing team on a regular basis to review their SOP. This will not only reinforce compliance of the procedures, but also allow the employees to ask questions or offer valuable suggestions on how to improve the process.

Understanding what your finishing defects are, eliminating the root problems, and maintaining a consistent process through efficient management and training is a proven method to exponentially increase bottom line profits.

Article excerpt courtesy of Finishing magazine July/August 2007. Article by Phil Stevenson. Complete article available at <http://www.finishingmagazine.com/print/Finishing-Magazine>

“Education and communication are key to preventing defects and problems in finishing.”