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Automotive PP Bumper Painting Line

No	Process Name	Treatment Method	Process Time	Temp.	Remarks
1	Loading				Manual
2	Pre-degreasing	Spray	1.5min	45～55℃	Gas Heating
3	Main Degreasing	Spray	2.0min	45～55℃	Gas Heating
4	Water Rinse	Spray	1.0min	RT	water
5	Pure Water Rinse	Spray	1.0min	RT	RO Water Purifier Supply
6	Pure Water Direct	Spray	0.1min	RT	
7	Drip-drying		5.0min	RT	In an Enclosed Tunnel
8	Water Drying	Hot air circulation	15.0min	60～70℃	Direct Natural Gas Heating
9	Forced Cooling	Air blowing	3.0min	RT	High-Capacity Cooling Fan
10	Sanding&Cleaning	Manual	1.0min	RT	Grinding Room
11	Electrostatic Dust	Ionized air	1.0min	RT	Automatic
12	Primer Spraying	Manual (both sides)	1.0min	RT	Equipped with Class 100,000 Cleanroom
13	Flash-off / Leveling	Immersion leveling	5.0min	RT	In an Enclosed Tunnel

14	Primer Curing	Hot air circulation	30.0min	60～70℃	Indirect Natural Gas Heating
15	Forced Cooling	Air blowing	3.0min	RT	High-Capacity Cooling Fan
16	Sanding & Cleaning	Manual	1.0min	RT	Grinding Room
17	Electrostatic Dust	Ionized air	1.0min	RT	Automatic
18	Basecoat Spraying (Color Paint)	Manual (both sides)	1.0min	RT	Equipped with Class 100,000 Cleanroom
19	Flash-off/Leveling		5.0min	RT	In an Enclosed Tunnel
20	Color Paint Flash	Heat lamp	5.0min	30～50℃	Electric
21	Forced Cooling	Air blowing	3.0min	RT	High-Capacity Cooling Fan
22	Clearcoat Spraying	Manual (both sides)	1.0min	RT	Equipped with Class 100,000 Cleanroom
23	Flash-off /		10.0min	RT	In an Enclosed Tunnel
24	Topcoat Curing	Hot air circulation	30.0min	60～70℃	Indirect Natural Gas Heating
25	Forced Cooling	Air blowing	3.0min	RT	High-Capacity Cooling Fan
26	Natural Cooling		10.0min	RT	
27	Unloading				Manual