

### **Information regarding powder coating your Nolting rails:**

I am writing this to work as a guide for those who wish to have the rails on their Nolting commercial table powder coated. If you are not familiar with powder coating, I will try to explain. Powder coating is simply a polymer in powder form that is sprayed on bare metal. The metal is put on metal hangers for spraying the powder and hanging in the oven. The metal is given an electrostatic charge to make the powder "stick" to the metal. The metal is then put into an oven and heated to approximately 425 degrees for about 15 minutes. This makes the powder melt and flow together. The result is a very hard and durable finish. Powder coating is very popular in the auto restoration business. It is environmentally friendly and does not emit toxins into the atmosphere like paint does.

You will be able to choose any color you want to put on them. The company should have samples or chips to choose from. Take the sample chips and one of your rails (a short one) outside in the sunlight to see what the color really looks like.

Ask the powder coating company if they can arrange to have the rails sandblasted. Sandblasting should be done with fine grit silica sand. The purpose of sandblasting is to remove all of the old paint and galvanized coating and expose the bare metal. The surface will be slightly rough. This is what the powder will adhere to. This is the most important part of the powder coating process. Most companies send metal out to be blasted. If the powder coating company tells you that it is not necessary, go somewhere else.

The next step is to put the rails in powder coater's oven for a few minutes to bake off any oils and contaminants. This is a very important step. Ask the company their procedure and if they are doing it right, they will do this step.

Your rails are almost 12' in length. Ask the powder coating company if they have an oven long enough to accommodate this length. If not, look elsewhere.

When you get your rails back, install the 2 short rails first. Be sure to unplug the main power cord. You do not need to remove the machine from the table or remove the power cord when you take them off. After you have installed the machine to carriage rails, lock the machine so it doesn't move around and slide the long rails in place. Always remember to start all of the button head screws and nuts before tightening anything. Tighten the screws from the middle to the end of the table in each direction. You will need a 3/8" nut driver or socket to loosen and tighten the nuts. The hex is 9/64". Hold the button head screw and break the nut loose from inside the rail to prevent breaking your allen wrench. Be sure to re-level your table after installing the rails. Put a level on the short rails first to make sure they are level, then check the long rails. Adjust as necessary to a perfect level in all directions using the top of the rails as the point where you want to put the level.

You can find several powder coating companies in the yellow pages. You shouldn't have to ship your rails.

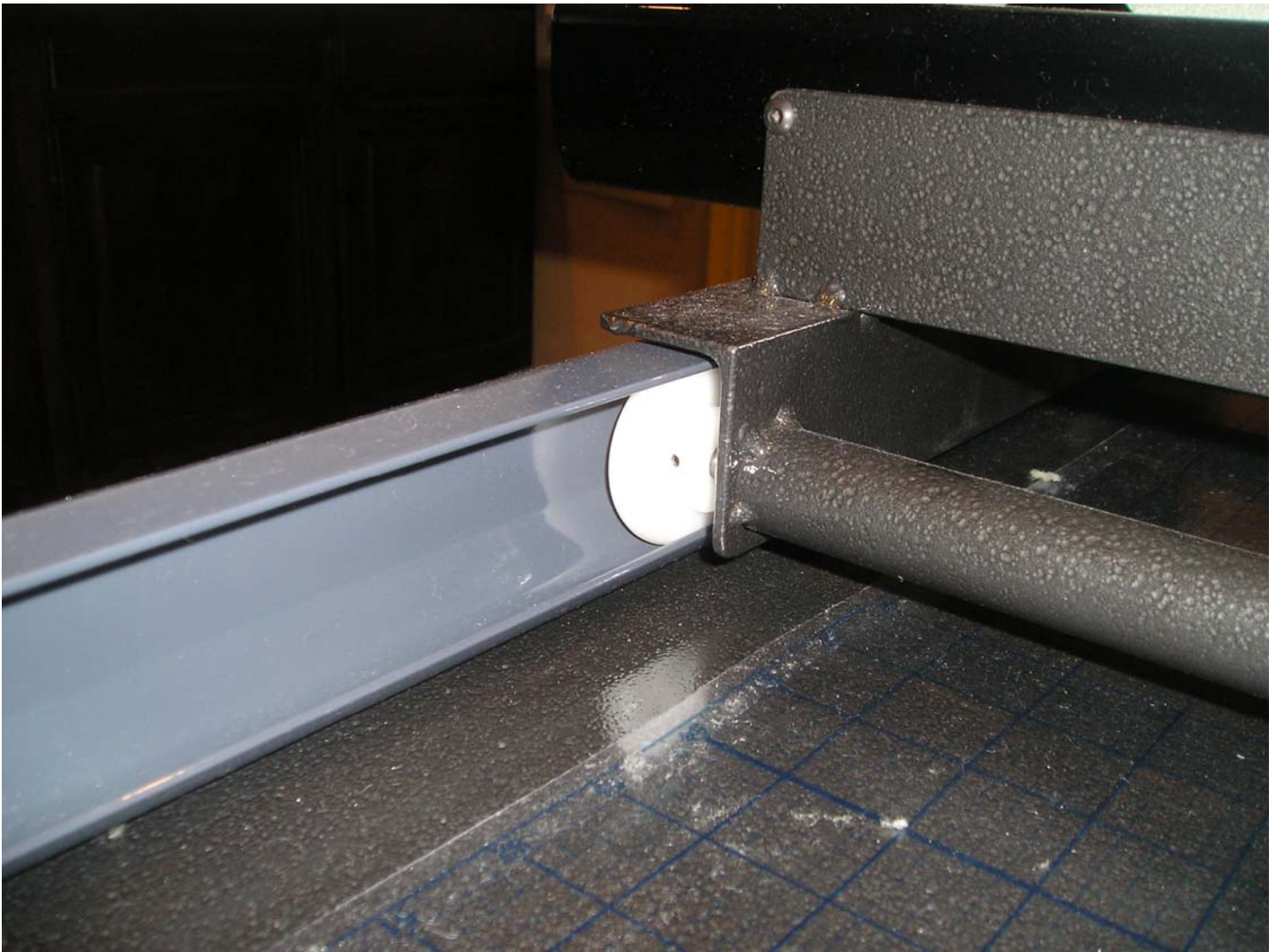
The cost for media blasting and powder coating should be from \$175 to \$225(USD) for all 4 pieces.

Finally, don't be disappointed when your rails look great against the painted table. The cost to powder coat an entire table is over \$1,000 and is also lot of work. You have to remove everything including the bearings in the ends of the rollers. Every bolt and nut must come off.

I've attached a few pictures of my studio tables. I've been having my rails powder coated for almost 2 years now. The white table was done approximately in December of 2005. The black table is about 6 months old. As you can see, even with lots of use, the wheels look like new with no black gunk, and only a light dusting to remove lint and dust.

Hope this helps.

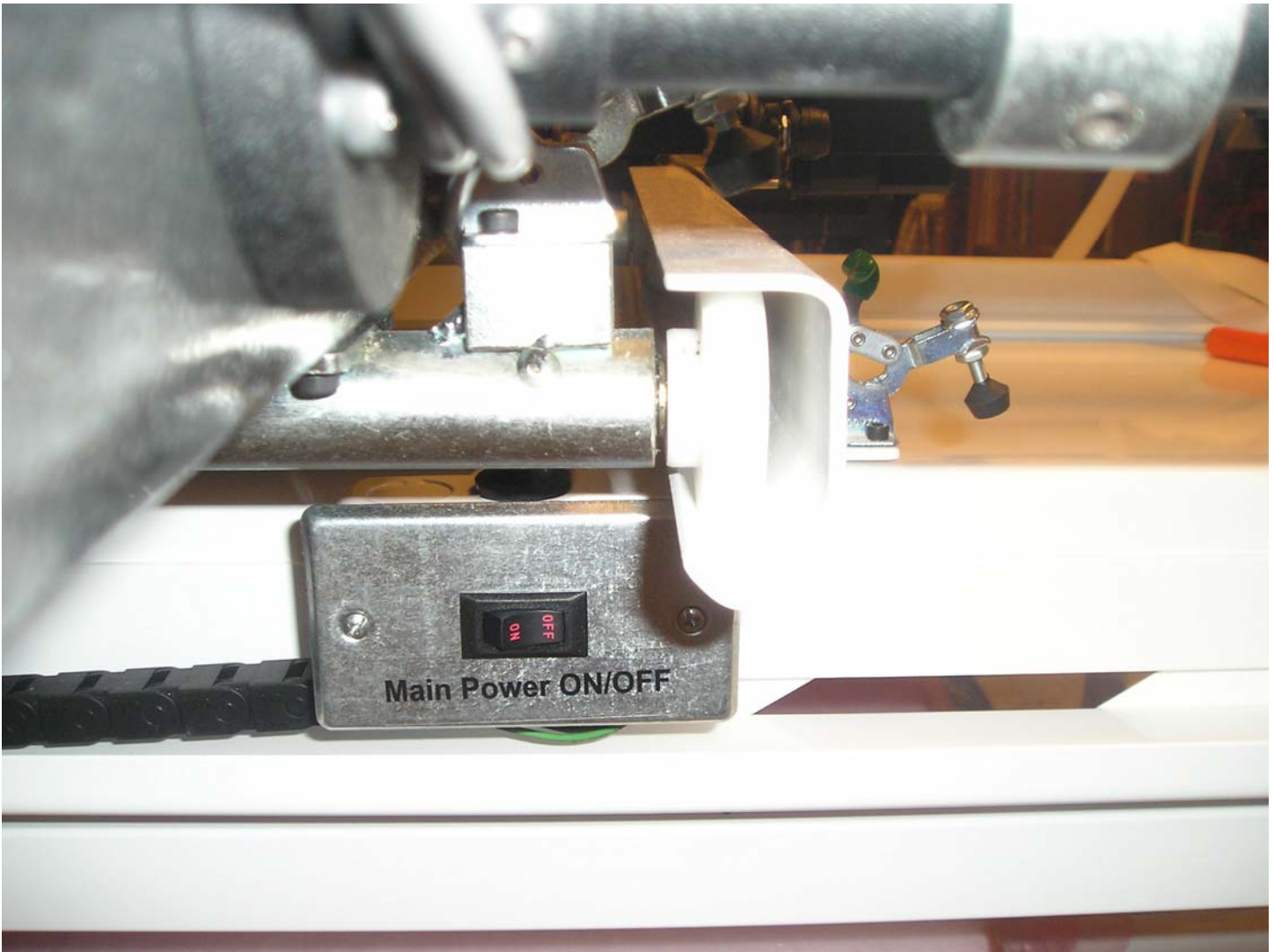
Sonia  
[www.Youcanquiltit.com](http://www.Youcanquiltit.com)



This table is 6 months old. It's difficult to match the exact color of the existing black finish on the tables. I have the rails for black tables done in a glossy gray. Don't choose a textured surface, as that will defeat the purpose.



This white table is almost 2 years old.



The carriage rails must also be powder coated. The wheels will stay clean with almost no effort. You still need to remove threads that may get caught, or lint, but no gunk.