



# Application Information

## Crinkle & Wrinkle Application

These finishes offer a unique wrinkle finish pattern that is designed to serve for decorative as well as functional purposes in a varied assortment of colors. They work over a wide film thickness range and possess outstanding chemical resistance and mechanical properties. Wrinkle Finishes are ideal for applications such as sports and recreation equipment, furniture, hand and power tools, hardware, fixtures, toolboxes, safety equipment, appliances, wire goods, automotive underbody/underhood, furniture, cabinetry and metal shelving applications.

- [Film Thickness](#) Wrinkle powders will develop their surface texture at a given film thickness range. If the coating is too thick or too thin, then the wrinkle texture will be different or nonexistent. Therefore, you must control the film thickness during application of the powder within the tolerance specified by the coating manufacturer to ensure acceptable results. Maintaining film thickness control entails proper gun settings, environmental conditions of the spray area, part ground and part temperature at time of coating. To a lesser extent booth airflow can also affect film thickness control.
  - [Part Cure Temperature](#) Wrinkle powders need to be cured at the part metal temperatures and dwell times specified for each coating. Temperatures or dwell times outside these parameters will give poor results.
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- [Bring-Up Time](#) This process variable describes the time it takes to “bring-up” a part to the given cure temperature. Wrinkle powders sometimes require that a part be brought up to cure temperature rapidly to ensure that the flow characteristics of the formulation be allowed to form the desired surface texture.
- [Hanging/Racking](#) How your parts are hanging in the oven during the final cure cycle can also affect a wrinkle finish. Wrinkle finishes tend to come out more uniform when you hang the parts vertically rather than horizontally. When hanging horizontally in the oven during cure, the flat areas faced up on the piece might come out less defined. For example, if you were coating a valve cover and placed in the oven horizontally, the corners and sides of the valve cover will have a more defined wrinkle effect, where the flatter top of the cover will be less defined.

## Helpful Tips & Information

A wrinkle powder coating is made with a surface modifier. Almost all of these coatings (wrinkle, texture, vein, river, etc.) won't really wrinkle or texture up until the end of the cure cycle. Being that these coatings are generally a lower gloss level, you are better to slightly over cure a wrinkle rather than under curing.

Once fully curing a wrinkle coating and you notice inconsistencies in the finish, below are some trouble shooting tips.

- [If you have areas on the substrate where the wrinkle is smooth or glossy](#) this is usually caused by either under cure, low mil thickness, hanging of parts in the oven, or improperly bringing the part up to temperature.