

# More about Transfer Efficiency!!

Even though we're pretty sure you didn't ask.

This table shows application methods, approximates their film build and indicates the maximum Transfer Efficiency (TE) you can expect. These base values can then vary widely depending on spray conditions, some of the more common factors are listed below. This list is neither exact nor exhaustive and is intended to assist general users in their understanding of TE.

Mils Applied	Maximum Expected Transfer Efficiency											
	100%	90+%	80%	70%	60%	50%	40%	30%	20%	10%	0%	
0.01												
1												
2												
3												
4												
5												
6												
7												
8												
9												
10												

**The Legend:**

- You **never** get 100% transfer efficiency. There is always some loss from cleanup/spillage.
- Rollcoat (machine)
- Dipping, Flow coaters, Curtain coaters, Rollcoat (hand), etc.
- Automatic Spray Machine
- HVLP or Air Assist or Airless Spray (most finishers land in this area)
- Conventional Spray (this is why we can't use these anymore)

**Common Transfer Efficiency Variables (for spray applications)**

- Part Size                    -25% to +25% for small or large pieces respectively
- Gun Setup                    0 to -15% for excessive air pressures, poor fan pattern, worn tips/seals, etc.
- Painter Experience        -15% to +15%, mostly from technique (triggering, applying correct amount of paint, less rework, etc.)
- Painter Fatigue            0 to -15% (show this to your boss and tell him that's why you need to take breaks!)