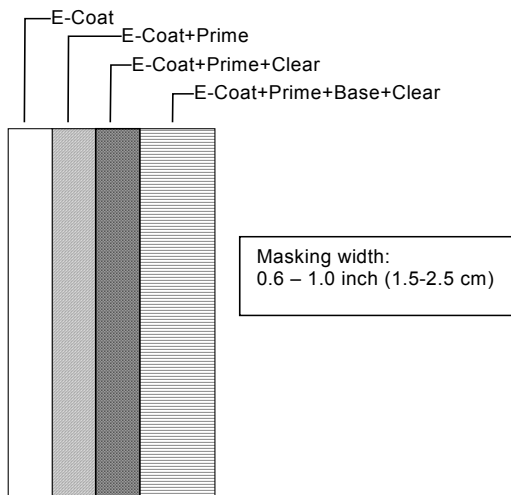


How to Make Steel and Aluminum PELT System Calibration Panels

Panel Preparation

- Use standard **NON-galvanized** 12" x 4" (30cm x 10cm) steel panels (larger sizes OK).
- Every coating must be applied in process, including E-Coat. Get a good ground when applying E-Coat (Verify the resulting E-Coat thickness is 0.75mil (19microns) or greater before application of remaining coatings!!).
- Apply heat-resistant tape to the back of the panel prior to application of E-Coat to create an area of bare steel (a 1" square area or larger is optimal). Leave the tape on the back of the panel for the entire process.
- If possible, provide for each color a panel that was coated on a horizontal surface and a panel that was coated on a vertical surface.
- Do NOT bake the Basecoat before application of Clearcoat!! After E-Coat, mask off first section, then Prime. After Prime, mask off second section. Mask off third section, making sure tape can be pulled off. Basecoat the panel, pull off the third tape, Clearcoat the panel, and then bake in process ovens. The panel should look like the following diagram:

Clear/Base/Prime/E-Coat



Minimum film builds:

Clearcoat	1.25 mils (32 microns)
Basecoat	0.50 mils (13 microns)
Primer	1.00 mils (25 microns)
E-Coat	0.75 mils (19 microns)

Important notes

- If you have a PELT System, we strongly recommend using it to measure the calibration panels before sending them to assure adequate thickness of each layer.
- Panels not prepared to the above specifications may not be usable for calibration.
- Fill out the appropriate Process and Product Information Sheet for each color (see following pages).
- Backs of all panels should be labeled with plant name, date, and color information.

Send completed panels to:

JSR Ultrasonics
Attn: Calibration Lab
3800 Monroe Ave.
Pittsford, NY 14534 USA

Process and Product Information Sheets can be sent with panels, or faxed to **+1 585 264 9642** or e-mailed to cal.lab@jsrultrasonics

PELT Gauge Calibration Sample Process and Product Information Sheet

The calibration samples will be used by JSR to determine film build calibrations for use with the PELT Gauge. In order to achieve the highest degree of calibration accuracy, the samples need to be run through the actual production process. Samples may be manual sprayed in *production booths* (using production material) and baked in the process (by placing panels in units). Lab sprayed samples should be avoided.

One copy of this form should be provided for each film build.

Customer: _____

Date: _____

Prepared by: _____

Substrate: _____

E-Coat / Conductive Prime

Target Thickness: _____

Vendor code: _____

Vendor: _____

Product Name: _____

Initials: _____

Primer / Adhesion Promoter (Check one)

Waterborne Solvent borne Powder Other

Target Thickness: _____

Vendor code: _____

Vendor: _____

Prime color: _____

Initials: _____

Basecoat (Check one)

Waterborne Solvent borne Other

Target Thickness: _____

Vendor code: _____

Vendor: _____

Color code: _____

Initials: _____

Color name: _____

Solid Metallic Pearl Don't Know

Clearcoat (Check One)

Waterborne Solvent borne Powder Other

Target Thickness: _____

Vendor code: _____

Vendor: _____

Product Name: _____

Initials: _____

I certify that the above sample is the closest achievable representation of the actual production process.

Name

Date

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One copy of this form should be provided for each film build.

Customer: _____

Date: _____

Prepared by: _____

Substrate: _____

E-Coat / Conductive Prime

Target Thickness: _____

Vendor code: _____

Vendor: _____

Product Name: _____

Initials: _____

Primer 1 (Check one)

Waterborne Solvent borne Powder Other

Target Thickness: _____

Vendor code: _____

Vendor: _____

Prime color: _____

Initials: _____

Primer 2 (Check one)

Waterborne Solvent borne Powder Other

Target Thickness: _____

Vendor code: _____

Vendor: _____

Prime color: _____

Initials: _____

Basecoat (Check one)

Waterborne Solvent borne Other

Target Thickness: _____

Vendor code: _____

Vendor: _____

Color code: _____

Initials: _____

Color name: _____

Solid Metallic Pearl Don't Know

Clearcoat (Check one)

Waterborne Solvent borne Powder Other

Target Thickness: _____

Vendor code: _____

Vendor: _____

Product Name: _____

Initials: _____

I certify that the above sample is the closest achievable representation of the actual production process.

Name

Date

PELT Gauge Calibration Sample Process and Product Information Sheet

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Customer: _____

Date: _____

Prepared by: _____

Substrate: _____

E-Coat / Conductive Prime

Target Thickness: _____

Vendor code: _____

Vendor: _____

Product Name: _____

Initials: _____

Primer / Adhesion Promoter (Check one)

Waterborne Solvent borne Powder Other

Target Thickness: _____

Vendor code: _____

Vendor: _____

Prime color: _____

Initials: _____

Ground-Coat (Check one)

Waterborne Solvent borne Other

Target Thickness: _____

Vendor code: _____

Vendor: _____

Mid-Coat (Check one)

Waterborne Solvent borne Other

Target Thickness: _____

Vendor code: _____

Vendor: _____

Color code: _____

Initials: _____

Color name: _____

Solid Metallic Pearl Don't Know

Clearcoat (Check one)

Waterborne Solvent borne Powder Other

Target Thickness: _____

Vendor code: _____

Vendor: _____

Product Name: _____

Initials: _____

I certify that the above sample is the closest achievable representation of the actual production process.

Name

Date