



How to Make Plastic and Composite PELT System Calibration Samples For Non-Automotive Applications

Minimum film builds:	Topcoat	1.0 mils (25 microns)
	Midcoats	0.40 mils (10 microns)
	Bottom Layers	0.60 mils (15 microns)

We cannot measure bottom layers with thickness less than 10 microns separately in most cases. Typical target thickness is thinner than our current capabilities for measuring a bottom layer.

***Note:** When your target thickness for any layer is less than the minimum thickness specified above, contact Imaginant's Calibration Lab to discuss potential issues prior to making panels.

Using Scrap Material for Calibration Samples

Imaginant can be provided with production scrap material containing all film coatings as long as the part has NOT been repainted (repaired) and the coating film thicknesses are within the factory target specifications. You can use a PELT System to check for repainting. We suggest accumulating scrap material over a period of time in order to eventually build up scrap samples for all active film build combinations.

Production scrap can be cut for shipment to Imaginant using a saw, or a minimum 4" diameter hand drill hole saw. 2 or 3 samples of each color from different areas of the production scrap panels should be sent to provide the Imaginant calibration lab with film build variation.

Using Panels or Plaques for Calibration Samples

If production scrap material is not available, 4"x12" (30cm x 10cm) plastic or composite panels (primed by the supplier when applicable) can be obtained from the supplier and then coated by the plant production process. The panels can be placed on a scrap carrier, or placed on the floor of each booth, coated manually, and then placed in a production carrier for production bake.

At least 2 panels of each color should be submitted in order to provide the Imaginant calibration laboratory with film build variation.

Important Notes

- It is not necessary to mask or tape off plastic or composite samples.
- Total usable sample area should not be less than 24 square inches (155 square cm).
- 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 name or code.
- If you have a PELT System, we strongly recommend using it to measure the calibration samples before sending them to assure adequate thickness of each layer.
- Panels not prepared to the above specifications may not be usable for calibration.

Ship completed panels to:

**Imaginant Inc. – Dock 29A
Attn: PELT Calibration Lab (585 264-0480)
3800 Monroe Ave.
Pittsford, NY 14534 USA**

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

PELT Gauge Calibration Sample Process and Product Information Sheet

Calibration samples are utilized by Imaginant to determine coating velocities for use with the PELT Gauge. To achieve the highest degree of calibration accuracy, the samples must be run through the actual production process. If necessary, samples may be sprayed manually in *production booths* (using production material) and baked in actual production process. Lab sprayed samples should be avoided. **One copy of this form should be provided for each calibration.**

Customer: _____ Date: _____

Prepared by: _____ Substrate: _____

If using a PO for payment, enter PO# submitted to Imaginant: _____

Our lab will send an e-mail upon receipt of your samples, indicating their status and when possible, the planned completion date of your calibrations. Please fill in contact information for the person to be notified:

Contact Name: _____ E-mail address: _____

**** Please fill in the layer information beginning with the first layer applied to the substrate that will be measured.****

<p>Layer 1 (Check one)</p> <p><input type="checkbox"/> Waterborne <input type="checkbox"/> Solventborne <input type="checkbox"/> Other <input type="checkbox"/> N/A</p> <p>Coating Name: _____</p> <p>Supplier Name: _____</p>	<p>Layer properties (Check one if applicable)</p> <p><input type="checkbox"/> Solid <input type="checkbox"/> Metallic <input type="checkbox"/> Pearl <input type="checkbox"/> Don't Know <input type="checkbox"/> N/A</p> <p>Coating Code: _____ Target Thickness: _____</p> <p>Supplier Code: _____ Notes: _____</p>
<p>Layer 2 (Check one)</p> <p><input type="checkbox"/> Waterborne <input type="checkbox"/> Solventborne <input type="checkbox"/> Other <input type="checkbox"/> N/A</p> <p>Coating Name: _____</p> <p>Supplier Name: _____</p>	<p>Layer properties (Check one if applicable)</p> <p><input type="checkbox"/> Solid <input type="checkbox"/> Metallic <input type="checkbox"/> Pearl <input type="checkbox"/> Don't Know <input type="checkbox"/> N/A</p> <p>Coating Code: _____ Target Thickness: _____</p> <p>Supplier Code: _____ Notes: _____</p>
<p>Layer 3 (Check one)</p> <p><input type="checkbox"/> Waterborne <input type="checkbox"/> Solventborne <input type="checkbox"/> Other <input type="checkbox"/> N/A</p> <p>Coating Name: _____</p> <p>Supplier Name: _____</p>	<p>Layer properties (Check one if applicable)</p> <p><input type="checkbox"/> Solid <input type="checkbox"/> Metallic <input type="checkbox"/> Pearl <input type="checkbox"/> Don't Know <input type="checkbox"/> N/A</p> <p>Coating Code: _____ Target Thickness: _____</p> <p>Supplier Code: _____ Notes: _____</p>
<p>Layer 4 (Check one)</p> <p><input type="checkbox"/> Waterborne <input type="checkbox"/> Solventborne <input type="checkbox"/> Other <input type="checkbox"/> N/A</p> <p>Coating Name: _____</p> <p>Supplier Name: _____</p>	<p>Layer properties (Check one if applicable)</p> <p><input type="checkbox"/> Solid <input type="checkbox"/> Metallic <input type="checkbox"/> Pearl <input type="checkbox"/> Don't Know <input type="checkbox"/> N/A</p> <p>Coating Code: _____ Target Thickness: _____</p> <p>Supplier Code: _____ Notes: _____</p>
<p>Layer 5 (Check one)</p> <p><input type="checkbox"/> Waterborne <input type="checkbox"/> Solventborne <input type="checkbox"/> Other <input type="checkbox"/> N/A</p> <p>Coating Name: _____</p> <p>Supplier Name: _____</p>	<p>Layer properties (Check one if applicable)</p> <p><input type="checkbox"/> Solid <input type="checkbox"/> Metallic <input type="checkbox"/> Pearl <input type="checkbox"/> Don't Know <input type="checkbox"/> N/A</p> <p>Coating Code: _____ Target Thickness: _____</p> <p>Supplier Code: _____ Notes: _____</p>

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

Name _____ Date