



How to Make “3 Wet” Steel and Aluminum PELT System Calibration Panels

Panel Preparation

- Use standard **NON-galvanized** 12” x 4” (30cm x 10cm) steel panels (larger sizes OK). Galvanized panels can be accepted if no others are available.
- 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 0.60mil (15microns) or greater before application of remaining coatings.).
- Apply all coatings at thickness as close as possible to target thickness (See minimum film builds below). All coatings can be applied to the entire panel, with no special masking required.
- 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. If it is only possible to submit one panel per color, horizontal is preferred, to ensure adequate film build thickness.

Minimum film builds*:

Clearcoat	1.25 mils (32 microns)
Basecoat	0.50 mils (13 microns)
Primer	0.60 mils (15 microns)
E-Coat	0.60 mils (15 microns)

*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.

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 (peaks representing each coating layer are present). **Note:** If the PELT operator is uncertain whether the panels are okay based on PELT waves, a job file from the panel can be e-mailed to the Calibration Lab for verification, at the e-mail address below.
- 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. There are separate sheets for standard 4-layer, 5-layer with 2 primes, and Tri-Coat panels).
- The back of each panel should be labeled with customer name, date, and color information.

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

Your samples will be used by Imaginant to determine film build calibrations for use with the PELT Gauge. In order to achieve the highest degree of calibration accuracy, the samples must 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 on units). Lab sprayed samples should be avoided. **One copy of this form should be provided for each film build.**

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: _____

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

Name

Date

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Contact Name: _____ E-mail address: _____

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: _____

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Contact Name: _____ E-mail address: _____

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

Name

Date