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INSTRUCTION SHEET - MIL P - 20689D

TYPE I & II PLASTISOL
GENERAL PURPOSE DIPPING COMPOUND
FSN-9330-6542 BLACK

METAL PREPARATION:

Clean the surface if necessary with III Trichlorethylene, MEK or a similar degreasing solvent. Allow to dry. If the plastisol is to be bonded, use PA 3011 Plastisol Primer for optimum adhesion. See TB-11.

PA 3011 will adhere well to most clean surfaces. With cast aluminum, a phosphate treatment may be necessary for optimum adhesion. Degrease and dry, dip in 5% phosphoric acid for 15 minutes or until the surface is etched. Rinse with water, dry and prime.

GENERAL HOT DIPPING INSTRUCTIONS:

1. Fasten suspension wires to the part to be dip coated if necessary.
2. Heat in an oven set from 350°- 450° F until hot.
CAUTION: All parts of the item being coated must be able to withstand the oven temperature, whether or not they are being coated.
3. Immerse the hot part in the plastisol at the rate of 1 inch every 1-2 seconds. Use a smooth rate. (ie, dip without hesitation or jerking.)
4. Allow the part to remain in the plastisol for 15-25 seconds for a coating of 20-40 mils, or up to 45 seconds for coatings up to 100 mils. The coating thickness also depends on the part mass and temperature.
5. Withdraw the part at the rate of 1 inch every 1-2 seconds. Make withdrawal smooth or the surface will be wavy.
6. Allow to hang until dripping stops (approx. 10-15 seconds, if any). Remove "pips" from the bottom of the part by carefully touching with a small piece of paper or cardboard, or by inverting where practical.
7. Suspend the part in the oven, set between 365° - 425° f for 5-10 minutes on 20-50 mil coatings, 10-15 minutes for heavier coatings, or as indicated by experience.

GENERAL HOT DIPPING INSTRUCTIONS - PAGE 2 CONTINUED

8. If a thicker vinyl coat is desired, the first coating should be cured for approximately 5 minutes and re-dipped into the plastisol starting with step 3.

CAUTION: Plastisol is ruined if it becomes contaminated with water. Plastisol weight 9.75 lbs/gal. Store below 90 degrees F.

See IIB-02 for further hot dipping information.