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COLD DIPPING PLASTISOLS

1. The part to be coated must be free of dirt, grease, oil, and foreign matter.
2. Fasten a suspension system of wire, clamps, cotton thread, etc., to item being coated.
3. Immerse the section to be coated at the rate of 1/2" every 1-2 seconds. Use a smooth rate. A mechanical device for the immersion and withdrawal is required for consistent production.
4. Hold this position for 5-10 seconds to allow the plastisol to level around the part.
5. Withdraw the part at the rate of 1/2" every 2-5 seconds. Make the withdrawal smooth or the surface may be wavy. If properly withdrawn, there should be no dripping of the coating.
6. Suspend the part in an oven set between 365° and 400° F until it is cured. The cure time will depend upon the oven temperature, mass of the part, complexity of the part, and oven efficiency. Avoid sudden jarring of the coated part to avoid disturbing the plastisol coating. The plastisol coating is cured (ie: becomes vinyl) when it reaches a temperature of 300° F to 375°F, depending upon the type of dip coating used. Most plastisols cure between 350° and 360° F.
7. If a thicker vinyl coat is desired, repeat the procedure starting with step 3. Otherwise, cool by hanging in air or dipping in water.

CAUTION: Plastisol (the liquid vinyl) is ruined if it becomes contaminated with water. The vinyl (cured plastisol) is not harmed by water, and in fact, is very resistant to water.

8. If thinner vinyl coating is desired, thin with our VR 150 Viscosity Reducer unless otherwise specified. Follow instructions for use on instruction sheet or the label.

These are general instructions. Loes Enterprises, Inc manufactures cold dips to meet an end requirement. Further recommendations will be made with the plastisol ordered.

Cold dips may be sprayed if dipping is not applicable.

Ask for our help with your plastisol problems.
LOES ENTERPRISES, INC

COMMON PROBLEMS WITH COLD DIP PLASTISOLS - PAGE 2 CONTINUED

<u>PROBLEM</u>	<u>ANALYSIS</u>	<u>CORRECTION</u>
Plastisol dripping curtaining	Part bumped or jarred	Allow proper clearance or for part in the dipping container. Avoid all unnecessary movement of coated parts.
	Withdrawn too fast	Increase withdrawal time.
	Plastisol too cool or warm	Plastisol works best at $80^{\circ} \pm 5^{\circ}$ F heating or cooling may cause drip.
Uneven surface dripping	Dirty part, grease or liquid on part	Plastisol may coat unevenly if the part is dirty. Clean thoroughly.
	Basket warm after primer bake	Allow the part to cool completely after baking primer before dripping.
	Plastisol separation	(ie: liquid on the surface) Stir before using.
	Plastisol too cold	Warm to 80° F. See instructions below.
Blisters in plastisol	Wet primer	Primer must be dry before using.
	Too hot	Decrease oven temperature &/or cure time.
	Excess of thinner	Excess viscosity reducer of the wrong Type may cause blistering.
Coating too heavy	Plastisol bodied	Plastisol should be stirred before each days use.
	Plastisol too cold	Plastisol will body if cooled too low, keep warm ($70-80^{\circ}$ F) place.
	Viscosity increase from aging	Some cold plastisols will body upon aging or exposure to excess heat, add viscosity reducer.

PROBLEM

Coating weak or
crumbly

ANALYSIS

Undercured

CORRECTION

Increase heat and or
cure time.

Shelf life: Most cold dips will have a shelf life of 6 months to 4 years at 75° F or cooler.

Storage: Keep container closed when not in use. Keep away from excess heat (sunlight, radiators, etc.) 75° F \pm 5° F for storage.

If warming of the plastisol is required, store in a warm place (80-90° F) overnight. DO NOT heat more, or the plastisol will gel from excess heat.