



Loes Enterprises, Inc

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TEXTURED PLASTISOLS

DESCRIPTION: Textured plastisols are dip applied plastisols which leave the part with a textured coating after fusion. This coating can vary in texture from fine to coarse, analogous to sand paper grades. Textured plastisols can also vary in durometer and color.

PROCESSING CONDITIONS: The key to proper processing of textured plastisols is fusion time and a steady entry and withdrawal of the part in or out of the dip tank. the preheat temperature of the part, dwell time of the part in the dip tank, and the parts ability to absorb and release heat will determine the thickness of the coating. The proper fusion time and temperature, which vary upon this coating thickness, will produce good physicals and a consistent texture. As a starting point we recommend a five to ten minute preheat at a temperature of 400° F to 450° F a 15 to 20 second dip cycle and a three to ten minute afterbake (cure) at 400° F to 450° F. The dip cycle consists generally of a fairly rapid dip into the plastisol, a dwell period, and then a withdrawal equal to the rate of drain of the plastisol off the part. Every part size will have a different optimum cycle.

STORAGE: The shelf life of textured plastisols is indefinite provided a stable temperature is maintained. Temperatures in excess of 90° F will begin to raise the viscosity. As a rule textured plastisols have more tendency to separate than glossy plastisols. Therefore, textured plastisols should be checked for settling of the texture particle resins to ensure proper processing. If settling has occurred, gentle agitation will redisperse.

PROCESSING GUIDELINES: Producing the proper matte texture will require manipulation of cycle times and temperatures. This is the task of the operator. Here are some general tips to help in tuning your production or lab cycle:

1. If the finished part lacks tear or tensile strength, increase cure time or temperature. Use 15 degree or 30 second intervals. The key is the coating must reach a temperature of 350° F to 370° F.

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2. If the finished part lacks texture, decrease the cure temperatures or time. Use 15 degree or 30 second intervals. The gloss results from the texture resin melting into a smooth coating. Avoid changing more than one variable in the cycle at one time.

Loes Enterprises, Inc produces three grades of textured plastisols, coarse, medium and fine. Durometer and color can be selected by the customer to match their specifications.

Minimum order quantity is five gallons. Half gallon samples are available in black. Orders for specific colors less than drum quantities have an initial \$60.00 color-matching fee. Allow 8 to 10 days for matching and a returned color chip.

Questions on textured plastisols can be directed to Loes Enterprises, Inc at (651) 646-1385 or (800) 869-1088. Please have a formula number available if one applies when calling.