



Loes Enterprises, Inc

1457 Iglehart Ave
St. Paul, Mn 55104

Fax: 651-646-3067

800-869-1088

WWW.Loesent.com

E-mail Loes@Loesent.com

PH: 651-646-1385

SPRAY COATING TECHNICAL BULLETIN

THIS COATING TECHNIQUE IS OFTEN USED WHEN PARTS ARE TOO LARGE OR TOO ODD SHAPED TO DIP COAT.

SPRAY PLASTISOLS ARE FORMULATED TO CONTAIN 75-100% SOLIDS. THE HIGHER THE % SOLIDS THE MORE PRESSURE IT WILL TAKE TO SPRAY THE COATING.

THE PLASTISOLS ARE FORMULATED WITH A LOW VISCOSITY AT HIGH SHEAR AND A SPECIAL PROPERTY CALLED "YIELD" THAT RESISTS THE PLASTISOL'S DRIPPING OFF THE PART AFTER APPLIED. THE LOW VISCOSITY ALLOWS THE PLASTISOL TO LEVEL ONCE APPLIED.

AVAILABILITY:

A SPRAY PLASTISOL CAN BE MADE IN A VARIETY OF COLORS AND HARDNESSES. CALL OUR TECHNICAL SALES STAFF FOR AVAILABILITY OF HARDNESSES AND COLORS OF PLASTISOL SPRAY COATINGS.

PHYSICAL PROPERTIES:

HARDNESS

GLOSS

ADHESION TO METAL SURFACES

SOLIDS CONTENT

COLORS

SHELF LIFE

LIGHT STABILITY

SHORE A & D RANGE AVAILABLE

MATTE, FLAT, SEMI-GLOSS, GLOSSY

REQUIRES PRIMING

75 - 100%

ANY AVAILABLE

6 MONTHS AT 60-90°F RANGE

CAN BE MADE LIGHT STABLE

EQUIPMENT NEEDED:

GRACO OR SIMILAR PUMP 15:1 OR 30:1 PRESIDENT OR BULLDOG MODEL.

GRACO OR DEVILBIS SPRAY GUN WITH 0.030" OR 0.010" SPRAY NOZZLE APERTURE IN VARIOUS SHAPES DEPENDING ON % SOLIDS AND COATING THICKNESS DESIRED.

GENERAL INSTRUCTIONS FOR SPRAY COATING PLASTISOLS

DESCRIPTION:

IN SPRAY COATING A SPRAY DEVICE THAT USES PRESSURE TO SPRAY THE PLASTISOL ONTO A METAL OR OTHER PART IS USED. OFTEN TIMES THE PARTS SPRAY COATED ARE VERY LARGE OR ODD SHAPED. THE PARTS ARE SPRAY COATED AND THEN CURED AT 350-400° F.

INSTRUCTIONS FOR SPRAY COATING PLASTISOLS

1. THE METAL PART SHOULD BE CLEANED WELL WITH SOME SORT OF DEGREASING AGENT AND ALLOWED TO DRY.
2. IF THE METAL IS TO BE PRIMED READ TECHNICAL BULLETIN TB-11 ON HOW TO USE PRIMERS.
3. AFTER CLEANING OR PRIMING THE METAL, PLACE THE PART IN AN AREA TO BE SPRAYED(SPRAY BOOTH) AND GET THE SPRAY GUN READY TO USE.IT IS BEST TO DO SOME TEST SPRAYING SO ADJUSTMENTS CAN BE MADE IN EQUIPMENT BEFORE RUINING A PART.
4. SPRAY THE PLASTISOL ONTO THE PART AT THE DESIRED THICKNESS AND ALL To LEVEL,
5. PLACE THE PART IN THE OVEN AT 350-400° F. AND ALLOW THE PLASTISOL TO REACH THIS TEMPERATURE TO INSURE PHYSICALS HAVE BEEN REACHED.