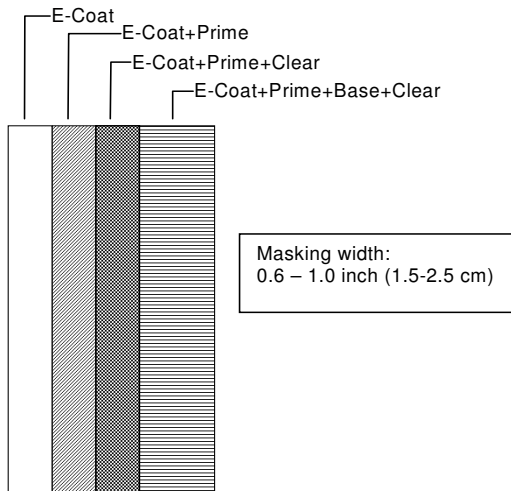


## How to Make Steel and Aluminum PELT System Calibration Panels

### Panel Preparation

- **Note:** Separate instructions are available for preparing plastic samples and 3-wet technology panels.
- Use standard **NON-galvanized** 12" x 4" (30cm x 10cm) steel panels (larger sizes OK).
- 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 heat-resistant tape to the back of the panel prior to application of E-Coat to create an area of bare steel (a 1" square area or larger is optimal). Leave the tape on the back of the panel for the entire process.
- 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.
- **IMPORTANT:** DO NOT bake the Basecoat before application of Clearcoat. After E-Coat, mask off first section, then Prime. After Prime, mask off second section. Mask off third section, making sure tape can be pulled off. Basecoat the panel, pull off the third tape, Clearcoat the panel, and then bake in process ovens. The panel should look like the following diagram:

### Clear/Base/Prime/E-Coat



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)

### 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.
- Panels must be prepared to the above specifications for our standard calibrations, which are generated using both magnetic induction and microscope data. If panels are not masked, (and in some cases when they are masked incorrectly), calibrations can still be generated using microscope data only.
- 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).
- Backs of all panels should be labeled with plant 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](mailto: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

# 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 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: \_\_\_\_\_

**I certify that the submitted sample is the closest achievable representation of the actual production process.**

\_\_\_\_\_  
Name

\_\_\_\_\_  
Date

# 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: \_\_\_\_\_

## **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