

## DIP MOLDING PLASTISOLS – TECHNICAL PRESENTATION

Lakeside Polymer Services provides custom formulated plastisols to meet specific customer requirements. The following is a typical procedure for dipping plastisols. Please contact Lakeside Polymer Services directly to see how we can meet your specific needs.

### A Typical Procedure for Dipping Plastisols

1. If good adhesion to the metal is required, dip or spray the cleaned piece with a special primer, water or solvent base available.
2. Allow the piece to air dry to avoid blistering primer.
3. Preheat the piece(s) to be coated in oven to get the substrate up to a temperature of about 300°F. A typical time and temperature might be 10' @ 400°F.
4. Remove the part(s) from the oven and dip into the plastisol, which is in a tank at room temperature. Immerse quickly to avoid losing heat, but slow enough so as not to entrap air. Increasing the temperature of the part and/or dwelling longer in the plastisol will increase the coating thickness.
5. Slowly and smoothly withdraw the part(s) so as not to leave dip lines and/or drips.
6. Place the part(s) back in an oven and bring the coating up to a temperature of 350-375°F to develop full physical properties.
7. The part(s) can be cooled in air or water quenched.
8. It is a good idea to gently stir the plastisol between dips to keep from developing hot spots in the tank, which can lead to swirling on the parts and gelled particles in the tank.

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