

<p align="center"><b>Plastisol Coating</b> Individual Module: 17</p>	<p align="center">TEL 204: Polymer Molding &amp; Forming Department of Technology</p>	<p align="center">Student Name: (PRINT)</p>
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**Overview:**

Plastisol coating is often done on a metal form or plug. The vinyl coating that is created is then removed from the form. However, a plastisol coating can be permanently applied to a metal object if the object is first coated with primer. Tool handles are coated this way.



**Module Grade:**

	<b>Self evaluation</b>	<b>Instructor evaluation</b>
Appropriate thickness (10)	_____	_____
Uniform thickness (10)	_____	_____
Uniform trimming (15)	_____	_____
Surface finish (15)	_____	_____
Burns (15)	_____	_____
Completely cured product (15)	_____	_____
Lessons learned (20)	_____	_____
Final Grade	_____	_____

**Molding Procedures:**

1. Wear safety glasses.
2. Wear gloves and do not touch hot molds, hot plastic, hot molder surfaces.
3. THIS STEP ONLY WHEN PRIMER IS USED. Sand product lightly to remove dirt.
4. THIS STEP ONLY WHEN PRIMER IS USED. Apply plastisol primer and let air dry.
5. THIS STEP ONLY WHEN PRIMER IS USED. Attach a hook or hanging wire on the product so it can hang in the oven to preheat.
6. Preheat the mold to 350 – 380 degrees Fahrenheit (20 minutes in the oven).
7. Dip into plastisol bath and let dwell until desired thickness is built up.
8. Withdraw slowly as this dictates the surface finish.
9. Place back in an oven and cure at 350 degrees for 25 to 45 minutes. Watch for a color change, light smoking, and keep it from burning. The coating is cured when its surface changes from glossy to dull and back to a glossy finish. PLACE ALUMINUM FOIL UNDER THE FORM TO CATCH DRIPS IN THE OVEN!
10. Quench in a cooling bucket for a few minutes. NEVER use the sink to quench a plastisol mold.
11. Check the cure by slicing a small piece and pulling on it to check toughness. Re-cure if it breaks.
12. Trim the product with a sharp utility knife.

**Lessons Learned:**

List the most important lessons learned from this polymer module.

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2. \_\_\_\_\_  
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3. \_\_\_\_\_  
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**Notes**