

BYK-Gardner USA 3800 Monroe Ave., Pittsford, NY 14534 USA  
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## How to Make 3-Wet Steel and Aluminum PELT System Calibration Panels

### Panel Preparation

- Use standard, **NON-GALVANIZED** 12" x 4" (30cm x 10cm) steel panels. Larger sizes are OK. Galvanized panels can be accepted if no others are available.
- 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 0.60 mils (15 microns) or greater before application of remaining coatings.
- Apply all coatings at thickness as close as possible to target thickness (see minimum film builds below). All coatings can be applied to the entire panel, with no special masking required.
- For each color provide a panel that was coated on a horizontal surface and a panel that was coated on a vertical surface. If it is only possible to submit one panel per color, horizontal is preferred to ensure adequate film build thickness.

#### Minimum film builds for calibration\*:

Clearcoat	1.25 mils (32 microns)
Basecoat	0.50 mils (13 microns)
Primer	0.50 mils (13 microns)
E-Coat	0.60 mils (15 microns)

\*Note: When target thickness for any layer is less than the minimum thickness specified above, contact BYK-Gardner's PELT Calibration Lab to discuss potential issues prior to making panels.

### Important Notes

- If you have a PELT gauge, we strongly recommend using it to measure the calibration panels before sending them to assure adequate thickness of each layer (peaks representing each coating layer are present). **Note: If the PELT operator is uncertain whether the panels are okay based on PELT waves, a job file from the panel can be e-mailed to the PELT Calibration Lab for verification at the e-mail address below.**
- Panels not prepared to the above specifications may not be usable for calibration.
- 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).
- The back of each panel should be labeled with customer name, date, color information, and orientation.

### Shipping

Send PELT calibration panels to:

**BYK-Gardner USA**  
**Attention: PELT Calibration Lab**  
**3800 Monroe Ave, Dock 29A**  
**Pittsford, New York 14534 USA**

Process and Product Information Sheets can be shipped with panels, faxed, or e-mailed to [BYK.PELTCalibration@altana.com](mailto:BYK.PELTCalibration@altana.com)



## PELT Gauge Calibration Sample Process and Product Information Sheet

Your samples will be used by BYK-Gardner 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 BYK-Gardner: \_\_\_\_\_

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

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Customer: \_\_\_\_\_

Date: \_\_\_\_\_

Prepared by: \_\_\_\_\_

Substrate: \_\_\_\_\_

If using a PO for payment, enter PO# submitted to BYK-Gardner: \_\_\_\_\_

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 BYK-Gardner 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 BYK-Gardner: \_\_\_\_\_

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