



Xtremcoat™

Coating Instructions

Cleaning: Soak parts to be coated in a solution of degreaser soap and hot water. After soaking, scrub parts using a soft nylon brush and rinse with fresh water.

Drying: Allow enough time for parts to dry completely. If you have a compressor, use air to speed the drying process.

Bead Blasting: Use blasting on stainless steel and bare aluminum to dull and provide a better surface for the coating. If the aluminum parts are anodized or the steel parts are phosphate coated, skip blasting. Blast only if the surface coating is worn or corrosion is present. After blasting, repeat cleaning and drying before proceeding!

Warning: Prior to solvent cleaning or handling any coatings, we ask that you work in a well ventilated environment! Breathing solvents or coating fumes in a closed room, can be damaging to your health. Please continue this process outdoors or open a door and/or windows to let in fresh air. Also use a fan to vent any fumes to outdoors.

Gloves: We recommend that vinyl gloves be worn during and after solvent cleaning to prevent any finger prints from contaminating the surface. Using gloves will also protect your hands. You may have to use several pair of gloves, as the solvent may start to dissolve the gloves if exposed to solvent too long.

Solvent Cleaning: We recommend that all parts be dipped or wiped down with a solvent cleaner prior to coating. This will remove any finger prints or residue left on the surface. We recommend using Acetone for best results, as it evaporates quickly and leaves no residue. Note: Do not use the acetone for nail polish removal, use a commercial type. You will find it in the paint section at your local hardware store.

Drying: Let the parts dry until the solvent has evaporated.

Pre-Heat: It is important to pre-heat parts to at least 100F prior to coating to remove any moisture and prevent any spray overrun. If you want your parts really flat finished, heat the parts to around 120F prior to coating.

Note: This coating is intended to be a thin film, it is **NOT** filler! Any surface imperfections should be corrected prior to coating.

Coating Instructions

"Continued"

Application: Using an airbrush, spray in light passes. Spray from different directions for proper coverage. We recommend that you adjust your airbrush and test the spray pattern prior to coating your parts. After coating, let the parts air dry for a minimum of one hour prior to heat treatment.

Note: If you mess up or do not like the results, do not worry! You can easily remove the coating with Acetone and start over again. Do not proceed to heat treatment, if you are not happy with the results. After heat treatment, only blasting can remove this coating.

Warning: Prior to baking the coatings, we ask that you work in a well ventilated environment! Breathing solvents or coating fumes in a closed room, can be damaging to your health. Please continue this process outdoors, or open a door and/or windows to let in fresh air. Also use a fan to vent any fumes outdoors.

Baking: We recommend an air circulating oven, but a conventional oven will work fine. All parts must be suspended in the oven. Do not place parts directly on the oven racks. We use copper wires for hanging, but steel is fine. Make sure parts are not touching each other and are properly suspended in the oven. Set your oven temperature to 325F, and bake for 45 minutes at temperature. After the time is up, turn off the oven and let parts cool down. Some ovens run hotter or cooler. The temperature we recommend is actual temperature.

Note: If you bake the parts at a higher temperature 325F-345F, the surface will be slightly harder, but the color will change. If you are looking for a color match, do not exceed our baking recommendations.

Final Step: After the parts have cooled down, remove from the oven. We recommend applying a thin coat of WD40 and wipe down any access with a soft cloth. This will bring out the true color of the coating and will help with the reassembly.

Any questions or comments, please contact us at: www.usanodizing.com