



26844 Adams Ave, Murrieta, CA 92562 Phone and Fax: 865-773-0599
Application Instructions for MCS

SURFACE PREPARATION:

- The parts must be absolutely free of all oils, grease, moisture, dust, scale or corrosion.
 - To do this, a thorough wash with acetone or similar solvent will take care of most impurities. Use gloves to protect your hands, and a respirator so as to not breath the vapors. Clean the parts in a well ventilated area away from sources of ignition such as fire, flame or sparks.
 - If you suspect the part may have oil in the metal you can pre-bake the parts at about 350° before cleaning with acetone, provided that the part would not be damaged by this temperature. This will burn off any oils from the machining process or from use. This should be done in a well ventilated area and **do not use an oven you cook food in.**

Metals:

- For steel, sandblast with 80-100 grit aluminum oxide or similar.
 - For softer metals, such as aluminum, use 100-120 grit aluminum oxide or similar at 35-40 PSI using a suction type blaster.
 - NOTE: Phosphating may be performed in lieu of sandblasting or in conjunction with the above mechanical etch.

Final Clean:

- Before spraying the part must be thoroughly cleaned using air blast, hot water rinse, solvent based rinse, or any other method that provides a clean dry surface. DO NOT USE petroleum based solvents.

MIXING:

- Stir and shake well. It is best to mix in a food blender type mixer or any unit capable of producing high speed shear/dispersion. The coating is provided ready to spray, however if desirable, thin up to 10% by volume with DISTILLED WATER.
- NOTE: Use of non-distilled water may adversely affect product performance and void the product's warranty, whether expressed or implied.

PRIMER:

- No primer needed.

APPLICATION TEMPERATURES:

	<u>Material</u>	<u>Surfaces</u>	<u>Ambient</u>	<u>Humidity</u>
Normal:	18-30°C	18-30°C	16-32°C	65-85%
Minimum:	13°C	13°C	10°C	50%
Maximum:	35°C	38°C	38°C	95%

SPRAY:

- Apply the coating in light fog passes (approximately 20% overlap) to achieve a thickness of .001" to .0015"
- Use sufficient air volume for correct operation of equipment (Minimum 50 PSI). Minimum part temperature should be 65°F. If the part is below this, warm the part. Do not warm the part above 110°F.



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- Spray at a right angle to the part with a 1mm or smaller nozzle size. Spray all irregular surfaces and edges first, making an extra pass later. Check the part for complete coverage. The part should be a light green color.

SPRAY GUN & MANUFACTURER:

- Any conventional unit will work.
- It is recommended that you use a gravity feed type touch-up gun. And as previously stated, it is important that the nozzle size is 1mm or less.

DRYING TIME:

- Immediately dry the coating in an environment with temperatures in the range of 100°F to 110°F. The part should change to a chalk white color (Color determines when the coating is dry).

FINAL CURE:

- Typical: 260°F/500°F for one hour at temperature.
- Note: If the final cure is attained and a recoat is necessary, special surface preparation may be required.

VENTILATION AND SAFETY:

- When used in enclosed areas, thorough air circulation must be provided during and after application until the coating is cured. The ventilation system should be capable of preventing fine particulate matter from exceeding TLV limits. In addition to proper ventilation, fresh air respirators or fresh air hoods must be used by all application personnel. Where flammable solvents exist, explosion proof lighting equipment must be used. Hypersensitive persons should wear protective clothing, gloves and/or protective cream on the face, hands, and all exposed areas.

CLEAN UP:

- Clean tools with water.
- Read MSDS before using this product.

STORAGE CONDITIONS:

- Temperature: 19-43°C or 65-110°F
- Store indoors