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Carrera Coat Coatings

APPLICATION INSTRUCTIONS

The Carrera Coat line is an air-curing line of coating products based on our original CilGen line of products with some updates in formulation. The following steps are critical to a successful application of the Products:

1. All surfaces to be coated should be completely free of any oil, dirt or other debris. At a minimum, use a solvent rinse to remove such contaminants. Acetone, Xylene (Xylol), Lacquer thinner or similar product may be used (do not use cleaners containing petroleum products). No residue of the solvent should be allowed to remain.
2. Once clean, two options are available depending on the application and product chosen:
 - a. In most applications it is best to etch by sandblasting with a 100/120 grit aluminum oxide or similar hard, sharp material to create a “white metal” appearance. When using a sandblast cabinet, air pressure should be about 35 PSI, if using a suction type blasting unit the pressure should be much lower and in some cases as low as 2 to 3 PSI. Etching is especially critical on high temperature applications, with the exception of the CFC (Clear for Chrome) which has an adhesion promoter that negates the need for etching.
 - b. In lower temperature applications, it is not necessary to etch the substrate, simply wipe clean with a solvent as above and allow the solvent to fully evaporate leaving no residue behind.
3. After etching, again rinse with a solvent as in step #1 and make sure it fully evaporates or is removed so that no residue remains.
4. Apply the coating using a spray gun with a 1mm or smaller nozzle (0.6mm is preferred). The product goes on extremely thin, and in some cases when LTC is used with the Brilliance colors, each application should be about .0001” thick. Maximum thickness for most applications is in the range of .0008” to .001”. If the coating is applied too thick it can fail to bond adequately in high temperature applications.
 - a. In some instances, certain products (LTC, LTMC) can literally be wiped on with a clean, lint-free cloth.
 - b. Regardless of the application method, it is not possible to apply a second coat or overlap a coat if much more than 10 minutes has passed since the previous layer was applied. In low humidity areas, a little more time may be available.
5. Allow the coating to dry. There are two methods of achieving a dry for handling finish:
 - a. Simply allow to dry at room temperature for about 2 hours, overnight is best.
 - b. If allowing to dry in a low humidity environment, it is best to place in a location where some moisture can be found in the air, either through a humidifier or even a wet cloth placed below the part(s) and box or other container placed over them.
 - c. Another option when time is critical, after about 15 minutes of air drying, place the part(s) in an oven set at between 200°F and 400°F and leave in place for a minimum of 15 minutes. Longer exposure to the heat will not be an issue. This does not fully cure the part(s), but the coating will be very durable and will continue its cure cycle which is caused by the moisture in the air.
 - d. Clean equipment with acetone, M.E.K., Xylene, or similar solvent.

If these steps are followed the part will be properly coated.