



Application Instructions for: ColorGard™, Gray Ice, Turbo X™ and “Black Satin” Products

ColorGard™, Turbo X™ and “Black Satin” products are designed as chemical and corrosion resistant, high heat thermal barrier coatings. See the cure instructions below as not all of the coatings have the same cure temperature. These can be applied to most metals and other substrates that can withstand the cure temperatures. These instructions apply to the following products:

ColorGard™ Matte Aluminum	ALK	ColorGard™ Titanium	TIK	Turbo X™ Black	TXBK
“Black Satin” Header Coating	BHK	ColorGard™ Cast Iron Gray	CHK	Turbo X™ Blue	TXBL
Grey Ice	GHK	ColorGard Colors		ColorGard White**	CGW

The following are general instructions to help you achieve the best results using these products.

Surface preparation:

- The parts to be coated must be clean and free of all oils, grease, moisture, dust, scale or corrosion. If the part has oils, grease or other contaminants it must be cleaned to allow the coating to adhere to the substrate. This can be done by pre-baking the part. Solvents can be used if they will completely evaporate without any residue. The part should be free of oils before sand blasting. Do not use any cleaner that contains petroleum.
- Sand blast with 100 to 120 grit aluminum oxide or similar hard, sharp material at a pressure of approximately 35PSI in a standard suction-type sandblast cabinet. DO NOT USE GLASS BEAD. If a used part, pre-clean prior to sandblasting by either a burn off or clean with a solvent to remove all contaminants.
 - After sandblasting, clean any residue off with high pressure air. Protect yourself with safety shield, goggles and respirator.
 - If needed, a rinse with acetone or lacquer thinner can be done to further clean the part.
 - After sandblasting, do not handle the item with bare hands. Use hooks or clean, lint-free gloves.

Preparation of the coating:

- Shake and stir the coating well before use. A number of clean ball bearings or clean small nuts may be added to the coating to help agitate the coating while you shake the container. Be sure that all the solids are well dispersed throughout the liquid. We recommend using a dispersion blade.

Equipment:

- Use an airbrush or detail touch-up spray gun with a 1 mm or smaller tip, to apply the coating.
- Use a respirator with the correct NIOSH filter (consult the SDS before using). Wear safety glasses or goggles. Wear gloves to protect your hands from the coating and from solvents

Spraying the coating:

- Spray the coating in all hard to reach areas first then move out to the other areas. Recommend pressure at the gun is 25PSI to 35PSI. Your finished cured coating thickness should be about .001” to .0015”.
- Inspect part for complete coverage. Part should be glossy wet without runs or sags.

Curing the Coating:

- Allow coating to dry to the touch (15 to 30 minutes depending on environmental conditions).
- **For ColorGard White (CGW), recommend to allow coated part to outgas for 8 hours before oven curing (600°F for CGW).
- There are 2 methods of curing these coatings.
- The recommended method of curing the coating is in an industrial oven not used for food at **650°F-700°F** for 1 hour (part temperature). ****ColorGard White (CGW) full cure temperature is 600°F** for one hour, and **TurboX Black and Blue (TXBK, TXBL) full cure temperature is 650°F** for one hour.

Clean up:

- Clean equipment with acetone, M.E.K, Xylene, or similar solvent.

Refer to Safety Data Sheets for hazardous materials notices (available at www.techlinecoatings.com or call (865)773-0599).