

## How to use: TECNADIS METALCOAT ENHANCER

### Protective coating with hydrophobic and oleophobic properties

#### PRODUCT DESCRIPTION

### Component 1

#### Tecnadis METALCOAT ENHANCER



The treatment Tecnadis METALCOAT ENHANCER is presented as a mono-component that is used to improve Tecnadis METALCOAT BASE or PLUS's anti-adherence properties.

#### HOW TO USE IT

#### STEP 1. PREPARING THE SURFACE

The surface treated with TECNADIS METALCOAT BASE or PLUS must be **clean and dry** before the application. Avoid presence of dust or any other solid particles on the surface. To degrease the surface with alcohol and to dry with a cloth or air is recommended before the application.

#### STEP 2. PRODUCT APPLICATION

##### 1) RECOMMENDED TOOLS:

Paint spray gun is recommended, "Trans-Tech" type with feeding filter, and a compressor with an air flow capacity of at least 6 bar and with two spray controller parameters, air and product.

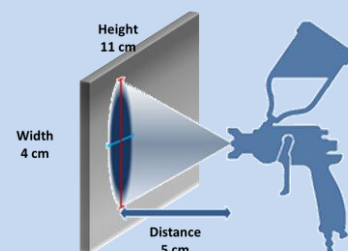
AIR GUN: REFERENCE MODEL		
MOUTHPIECE	Hole size	0,85 mm
HEAD	Head shape	Elliptical or equivalent
TYPE	Trans-Tech, with feeding filter	



##### 2) GUN CALIBRATION:

To calibrate the gun, adjust the **spray pattern** and the **amount of product per time unit (ml/min)** to the values below, in order to assure an approximated yield of 25 ml/min:

GUN: CALIBRATION PARAMETERS		
DISTANCE TO THE GLASS		5 cm
ATOMIZATION		High
SPRAY PATTERN	Width	4 cm
	Height	11 cm
AMOUNT OF PRODUCT	Per unit of area	Approx. 90 ml/m <sup>2</sup>
	Per time unit	Approx. 20 -25 ml/min



### 3) SPRAYING:

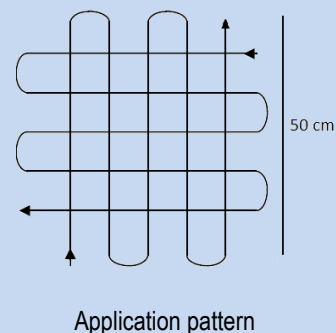
Spray the Tecnadis METALCOAT ENHANCER over the surface treated with TECNADIS METALCOAT BASE or PLUS in one layer homogeneously, avoiding possible excesses and product's sags.

As **standard application** it is recommended to apply **two layers** of the product **perpendicular to each other** (see the figure). **Approximated performance** is 90 ml/m<sup>2</sup>.

#### Application method:

Product's spray **recommendations** are the followings:

- Follow the pattern of application, i.e., make passes in **two directions perpendicular to each other** and also with the gun perpendicular to the surface and trying to leave the gun in the same position.
- **The aspect of the coating should not be altered** by the deposition of this top layer. For this reason, a very fast spraying will be used for the deposition preferably. Although it seems that nothing has been applied, the enhancer product has been already deposited.
- Avoid excess product. If this occurs, use the air of the gun or a cloth to dry and spread it uniformly along the surface.
- After deposition of the Tecnadis METALCOAT ENHANCER, the solvent dries in one minute.



### STEP 3. CURING OF THE TECNADIS METALCOAT ENHANCER

The Tecnadis METALCOAT ENHANCER needs a thermal drying at 200°C to ensure the proper fixation of the product over the before product, Tecnadis METALCOAT BASE or PLUS. Several thermal devices can be used to this aim, namely **ovens** for small pieces and industrial line productions, or **thermal portable devices such as thermal guns or cannons** for in-situ applications in already-existing lines. The recommended duration for this process should be between **15-30 minutes**, depending on the piece to be treated and the thermal device used.

For example, in the case of using an oven the curing process, the piece (s) is subjected to 200°C during 30 minutes each. In the case of using the thermal gun or cannon, the device's power will be adjusted to get the indicated temperatures in the piece (s) during the corresponding times. In the case of using a LEISTER, it has been estimated that 15 minutes/m<sup>2</sup> approximately and power of 4 will be needed. Then, to ensure a good fixation specific thermal contribution of 3 to 5 seconds per area of 5 x 5 cm approximately can be made.

**Important:** Direct contact with the heat focus and hot supports must be avoided since a strong thermal shock at this point may cause a too fast drying, ending in a whitish and brittle coating.



### INSTRUCTIONS FOR HANDLING

The security information of the product needed for its use without risks is not included in this document. Before manipulating the product, read carefully the Material Safety Data Sheets and the labels for a safe use and to be aware of physical and health risks. The MSDS are available and are provided by TECNAN S.L. Application of the product should be carried out in a properly ventilated place. It contains volatile solvent (ethanol).