



Instructions For Application of FIB Basecoat™

(Product ID: FB-XXX)

Warning! Use with adequate ventilation or appropriate respiratory protection. This product is flammable; do not spray near flame, heat, or sparks. This product contains solvents and propellants that may damage some plastic surfaces.

Directions:

1. Clean the model, calibration coupons, and a small test piece with alcohol or acetone on wipes.
2. Shake the paint thoroughly for several minutes. Ideally, the paint in its container may also be partially submerged in an ultrasonic bath (cleaner) filled with water for a few minutes to enhance mixing.
3. Pour the paint into the gun without filtering or straining.

For the HVLP gun:

Set gun to 10 psi (68kPa). This may vary due to air-hose differences. This keeps overspray to a minimum. Set the fluid control knob on the sprayer all the way closed (clockwise) and then open it two full turns (anticlockwise) and pattern control to almost full open or anticlockwise. This setting yields a sheet pattern (as opposed to a circular pattern at the opposite extreme of the adjustment) which typically yields more uniform results.

For the air brush:

4. Set the pressure to 10 psi (68kPa) or less.
5. Test your spray method on a test piece of metal. Keep the gun about 12 inches (30 cm) away from surface while spraying.

See the specific directions for each product below before painting the model surface.

Over a bare metal surface or screen layer coated surface, apply about 7 to 9 (very light) cross coats. Cross coats means working from left to right or right to left while moving down the model, then work back up left to right or right to left. This constitutes one coat. The next coat is applied top to bottom or bottom to top in a similar manner.

Do not exceed 12 coats as too much paint could result in separation from the metal. Do not apply a wet coat. Wet coats may cause the model to appear to have a skin rash.

Let the FIB Basecoat™ layer dry before applying UniFIB® or BinaryFIB® over top. FIB Basecoat™ does not need to separately cured. It can be cured with the PSP layer after it is applied.

Models coated with FIB-based paints should be cured at 65° C for at least one hour in order to minimize the temperature sensitivity of the pressure response of the paint.

For all Paints:

For best results, apply light coats, allow paint to dry between coats (~10 sec.), and STOP when you have good coverage.

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Most common reasons for FIB Basecoat™ paint failure:

1. Too many coats on the surface.

The paint will crack and peel off. This will require the model to be repainted.

2. Applying paint too heavily. (surface appears wet)

Generally caused by moving the gun too slowly. This will look like a rash, repaint recommended if the problem is extensive.

3. Grease or oil on surface.

May not notice this by eye, but the temperature and pressure sensitivity of the paint will be compromised. Clean and repaint.

Removal of FIB Basecoat™ from surfaces:

Acetone on wipes works best for metal surfaces, but will damage most plastic surfaces.

Caution! Acetone can damage the surface of some plastics!

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