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1

Select A Dipping Container

The dipping container is where you will dip your part and can be made of any material such as plastic, glass or metal. A square or rectangular container works the best and it should be large and deep enough to completely submerge the part being processed.

When you lay your part into the center of the container:

1. You should have at least **5-6** inches of space between the side of your part and the sides of the container.
2. The container should also be deep enough that when you process your desired part it will be totally submerged below the water line.
3. Your container can never be too deep, but it can be too shallow.

Using a metal or glass container will hold the heat range longer than plastic. No matter what your container is made of any material should give you at least 20-30 minutes to process your part. This is more than an adequate amount of time for most parts to be processed.



2

Select Your Part

IMPORTANT: Only parts that will not be harmed by being submerged in water can be processed. Absolutely no parts containing electronics can be processed. We suggest doing a couple of test parts prior to processing your true desired part.

1. No soft woods such as MDF or plywood, which will absorb water and expand can be processed.
2. Hard woods such as hard walnut and hard oak can be processed.
3. Metals such as steel, aluminum and stainless can be processed (You will need to provide an etching primer and urethane primer paint to process metal parts).
4. Plastics such as ABS, Polypropylene, Styrene, PVC and Acrylics can be processed.

Any part that you primer or base color coat can adhere to can be used.

3

Prep Your Part

When using any aerosol products provided in the kit, always use the respirator provided. Only use aerosol products in a well ventilated area.

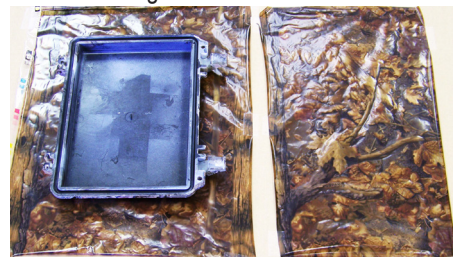
1. Make sure any area of the part you do not wish to paint or print an image on is protected. You can use masking tape or masking paper to mask off any areas you do **NOT** want to print on.
2. Clean part completely using the scuff pad provided using a cleaning agent or by washing the part with a detergent type cleaner. *(The scuff pad will help clean and break the surface of the part for better adhesion. Do not use an aggressive cleaner that may harm the part. Test a small area prior to proceeding. No oil, grease or contamination can be visible on the part.)*
3. Make sure the part is dry with no residue left on the part.
4. Spray a light dust coat of primer covering all areas to be processed.
5. Spray a second coat of primer (medium wet) onto the part. You do **NOT** want it so wet that the primer runs. *(Allow primer coat to dry for one to two hours at room temperature then lightly scuff the part completely with a dry scuff pad before moving to the next step. Once part has been sprayed with primer you need to apply the base coat within 24 hours.)*
6. Apply a base coat covering to all areas of the part to be processed. Multiple light coats are preferred over one heavy coat. Allow the base coat to dry for a minimum of one to two hours at room temperature and lightly scuff the part completely with a dry scuff pad before moving to the next step.

4

Setup Film

The film is a water soluble product. Do not get any moisture or water on any area of the film, if it comes in contact with water it will not process normally.

1. The film has a label stating this side up. When the film is placed in the water you should be able to read the label.
2. Measure your film. You need to have enough film to cover the desired area to be processed plus 4-5 inches extra on each side of your part.
3. Cut the film to the size you will need to process your desired part. Make sure you have at least one inch of room to expand from the edge of the film to the side of the dipping container.
4. You do not want to cut the film too small. If the film has three to four inches to expand before reaching the side of the container it will stretch and you will lose the definition of the image.



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Setup Container

NOTE: Step #1 helps you select the container size you will need in the following steps.

1. Hot water is needed for your dipping container.
2. Use enough water so that once you have poured the heated water into your dipping container the water level sets approximately 1" from the top. The gap between the water and the top of the container prevents the water and your pattern from spilling over the sides when you submerge the part.

For the next stage **you will need a timer or stopwatch** that can alert you when sixty seconds has elapsed. When using any aerosol products provided in the kit, always use the respirator provided. Only use aerosol products in a well ventilated area.

6

Dip

NOTE: Reference pictures 1-A through 8-F below.

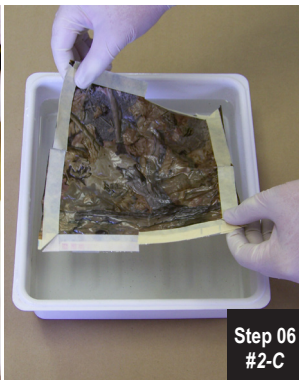
1. Depending on your environment you may want to use 1/2" masking tape and apply a border around the film^{1-A}, cut a few lines completely through the tape on all four sides^{1-B} so the film can expand once it is placed in the water. This will help stabilize the film.
2. Hold the film from the two furthest corners then bring both corners together so the film now resembles a sling. Lay the film^{2-C} in the center of your dipping container (on top of the hot water) and easily lay both corners down together.
3. Let the film hydrate in the water for sixty seconds.
4. Shake the Activator can vigorously to create a good mix. *Activator is a solvent and resin base product which enables the ink to make a successful transfer.*
5. After your film has hydrated for **60 seconds** spray your activator^{5-D} evenly across the film from side to side, then from top to bottom creating a cross hatch pattern. One light pass in each direction is sufficient. The aerosol can must be level over the film and about **10-12 inches** above the film. Wait **5-10 seconds** as the film is activated and turns into liquid ink. (*You do not want a heavy amount of spray. You do not have to saturate the film just make sure you have covered the film with activator.*)
6. Do not get into a hurry the film may take longer to liquefy prior to dipping. This all depend on how the activator was applied. The film will only expand to the size of the container then stop^{6-E}. When the film is fully activated it should have a nice glossy appearance.
7. Begin to process your part by starting at one end keeping the part at a thirty to forty degree angle^{7-F}.
8. Once you start to process your part keep slow even pressure submerging your part into the water.
9. Attempt to keep the same angle until the part is completely submersed below the water line. You are attempting to enter the water so you **DO NOT** trap air bubbles under the part.
10. Push your part down and towards the ink. A smooth even motion produces the best results. We suggest doing a couple of test parts prior to processing your true desired part. **Note:** Use clean fresh water for every part you dip to ensure excess activator is not in the water which can ruin your next dips.



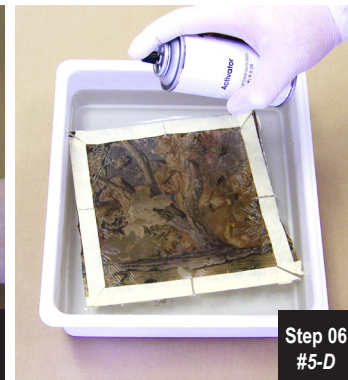
Step 06
#1-A



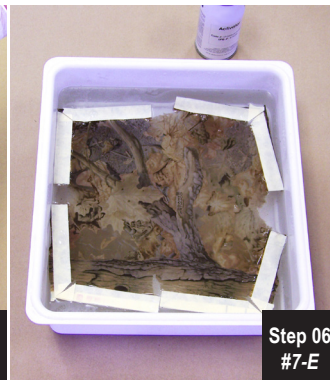
Step 06
#1-B



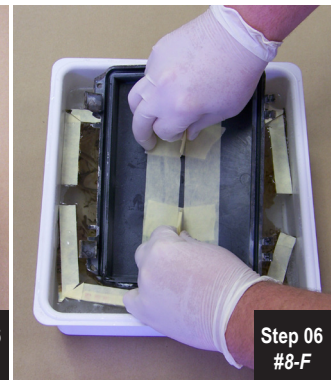
Step 06
#2-C



Step 06
#5-D



Step 06
#7-E



Step 06
#8-F

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7

Rinse

After you have processed your part you will need to immediately remove any PVA residue from the part.

1. Do not touch or rub on any area of the part that has been processed.
2. The part needs to be rinsed under running water. Cold water will work but warm or hot water will remove more of the residue quicker.
3. The part must be completely free of any PVA residue left from the printing process. Failure to do this will prevent the finishing top coat from adhering to the part.
4. After rinsing let the part air dry. If any shiny areas are visible there is still PVA residue present. Simply rinse the part again until it has a dull appearance.

8

Top Coat

When using any aerosol products provided in the kit, always use the respirator provided. Only use aerosol products in a well ventilated area.

1. Apply the aerosol top coat in even passes over the part.
2. Let each coat set up for at least one to two hours at room temperature before applying another coat.
3. Apply coats until desired appearance is achieved.
4. It is always better to apply several light coats rather than a single heavy coat.
5. Once the top coat has dried you are ready to use your part. **Note:** Top coat finishes require **10-14 days** to fully cure; while you can use your part, you will want to be more careful until it is fully cured.

HAZARD AND DISPOSAL INFORMATION

SURFACE PREPARATION: Surface should be clean and dry. Remove dirt, grease, oil, wax and loose paint.

DIRECTIONS: Use outdoors or in well ventilated area when temperature is between 68° to 78°F (20° to 26°C) and humidity is below 60% to ensure proper drying. Mask surrounding area where over spray might settle. Shake can for at least one minute, listening for rattle of mixing ball. Shake for 10 seconds at 1-2 minute intervals during application. Hold can 6 to 10 inches from surface. Press spray button firmly. Do not cover with continuous spray. Move back and forth releasing spray head after each stroke. Overlap each stroke. Apply two thin coats rather than one heavy coat.

CLEAN UP: If spray button becomes clogged, pull off and clean with solvent. DO NOT stick pins or wire into can opening. Replace spray button firmly with valve opening pointing away from you. To prevent valve from clogging after use, turn can upside down and press spray head for 4 seconds.

CONTAINS: Acetone CAS#67-64-1, Ethyl Acetate CAS#141-78-6, Propane CAS#74-98-6, N-Butane CAS#106-97-8, PM Acetate CAS#108-65-6.

DANGER: Vapors may ignite explosively. Prevent vapor build-up. Keep from sparks, heat, flame or any other heat sources. Do not smoke. Turn off pilot lights, stoves, heaters, electric motors and other sources of ignition during use and until all vapors are gone. Do not puncture, burn or place container in garbage compactor. The prolonged exposure to heat or sun may cause "bursting". Do not expose to heat or store at temperatures above 120°F (49°C). If affected by inhalation of vapor or spray mist, remove to fresh air.

WARNING: To avoid breathing vapors or spray mist, open windows and doors or use other means

to ensure fresh air entry during application and drying. If you experience eye watering, headaches or dizziness, increase fresh air or wear an approved HIOSH respirator or leave the area. Avoid contact with skin or eyes.

FIRST AID: In case of eye contact, flush immediately with water for at least 15 minutes and call poison control center, hospital emergency room, or physician immediately; for skin, wash thoroughly with soap and water. If affected by inhalation of vapor or spray mist, remove to fresh air. If swallowed, Call poison control center, hospital emergency room, or physician immediately.

NOTICE: Reports have associated the repeated and prolonged occupational OVER-EXPOSURE to solvents with brain and nervous system damage. The deliberate misuse by concentrating and inhaling the vapors may be harmful or fatal.

WARNING: This product contains a chemical(s) known to the State of California to cause cancer.

DANGER! EXTREMELY FLAMMABLE LIQUID AND VAPOR. CONTENTS UNDER PRESSURE. VAPORS HARMFUL. VAPORS MAY CAUSE FLASH FIRE. EYE IRRITANT. SEE CAUTIONS ON LABEL.

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