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Technical Process Bulletin

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TOUCH-N-PREP® COATINGS ALODINE® 1132

1. General Discussion:

Begin process with a clean, water break free, dry surface. If the water rinse or treatment beads up on the surface, it has not been properly cleaned or it was re-contaminated. **Avoid finger marks!** Clean latex gloves are highly effective at preventing finger oil and lint contamination during cleaning.

A preferred method of surface cleaning is the use of a wet Bear-Tex or Scotch Brite® Pad to abrade the surface. Abrasion of the surface in two directions at 90 degrees is recommended. After cleaning, dry the surface with a clean cloth. Wipe until no dark residue is picked up from the surface.

Remove cap.

Hold unit with applicator tip down.

To activate, press the pen tip against a clean, firm surface. This will open the valve allowing Alodine 1132 to reach the applicator tip. A new unit should charge in 30-45 seconds. When the Alodine wets the tip, release the downward pressure. Unit is ready to use.

5. Application:

Proper Application and Use Procedure of Alodine 1132 Touch-N-Prep Pen per MIL-DTL-81706, Class 1A and Class 3, Form VI, Method D

STEP 1:

Degrease metal surface. If a solvent is used, do not allow the solvent to dry on the surface, but remove the solvent and dry the surface with a clean lint free cloth.

STEP 2:

Wet a Bear-Tex, Scotch-Brite or other similar abrasive pad materials with water and scrub the metal surface to remove oxides and expose a fresh metal surface for subsequent conversion coating. Abrasion of the surface in two directions is recommended. Rinse with water and look for a water break free surface. If there is a water break, then continue scrubbing until a water break free surface is obtained.

STEP 3:

Rinse thoroughly while wiping with a clean cloth (such as cheesecloth) until the cloth remains clean (no dark residue is picked up from the surface). All scrubbing residues from the previous step must be removed before proceeding.

STEP 4:

After rinsing, wipe the surface with a clean cloth (such as a cheesecloth). Allow the metal surface to dry (or be slightly damp) and then apply the Alodine 1132 conversion coating with Touch-N-Prep pen.

STEP 5:

Apply Touch-N-Prep Alodine 1132 coating to the metal surface with smooth, even strokes. Be sure to cover all edges. A 50% overlap of strokes gives the optimum conversion coating. DO NOT PUDDLE! DO NOT RINSE! DO NOT WIPE! No "water breaks" or solution breaks should exist. A void in the wet film indicates incomplete cleaning. Repeat cleaning, if necessary. For optimum salt spray corrosion resistance and low electrical contact resistance, a second coat is applied at a 90-degree angle to the first coat. Apply the second coat as soon as the first coat dries. DO NOT PUDDLE! DO NOT RINSE! DO NOT WIPE!

Note:

As long as the Touch-N-Prep pen wets the surface, a coating will form. The ideal coating deposit will be nearly colorless for Class 3 or tan/brown in color for Class 1A.

STEP 6:

Prewarming the surface helps to improve the appearance of the coating. Alodine 1132 can be air dried, force dried with warm air (hair dryer) or a heat lamp. Do not disturb the wet film during drying.

STEP 7:

A "light to moderate" coating weight is required, such as greater than 10 mg/ft² but less than 25 mg/ft² utilizing weight-strip-weigh procedure.

STEP 8:

To recharge applicator tip, repeat Step 4.

STEP 9:

When Alodine 1132 dries thoroughly, primers or other coatings may be applied for MIL-DTL-81706, Class 1A.

STEP 10:

Always replace cap when not in use.

STEP 11:

For general purposes, Alodine 1132 may be used on aluminum, ferrous metals and galvanized surfaces.

STEP 12:

A new applicator tip can be cut to conform to any shape with a single edge razor blade.

Use caution. Contains chromate. Protect from freezing. DO NOT tamper with packaging. DO NOT try to refill.

Scotch Brite® of the 3M Company.

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