DuraBake Instructions

For use on ferrous metals, stainless steel, and aluminum.

1. Start by degreasing with LCW TruStrip. Allow the parts to soak in TruStrip for a minute or two. Swish the parts in the TruStrip before removing. Allow the parts to air dry. The air dry will take only a few seconds and the TruStrip will not leave a residue. This is very important as the residual contaminates evaporate with the TruStrip and do not stay on the surface as with other degreasers.
2. In a commercial application we recommend blasting with 60-120 grit aluminum oxide or sand. When blasting is complete blow the dust off the parts with shop air.
3. (Option) For an even better overall finish Parkerize the parts at this point.
4. Shake the DuraBake container for three minutes after hearing the mixing ball. DuraBake does not require a separate hardener. The hardener is mixed into the DuraBake at our factory. It is activated by heat.
5. Apply with a conventional air spray gun or a HVLP spray gun. Add DuraBake Reducer to thin the DuraBake if it does not fully atomize (you want a smooth finish.) Spray in 3-4 smooth, even passes. Build the DuraBake to the desired thickness. Stop intermittently to "flash off" the solvents by spraying air only with your spray gun onto the parts.
6. Allow the coated parts to sit for 20 minutes at room temperature before placing them in the oven.
7. Bake metals at 350°F for 30 minutes. When the parts cool down, they are ready for assembly.

Optimum thickness is 1 mL. A thinner coating is required on tight tolerance areas and a thicker coating can be applied on high-wear areas. Unused DuraBake may be poured back into the original container. Clean your spray gun thoroughly with DuraBake Reducer. Although the DuraBake coated part is ready for use it will continue to cure over the next 5-6 days. DuraBake is also available in convenient aerosol cans for small projects. DuraBake has a shelf life of 12-18 months. Call 800-830-6677 if you have any questions or if you are not getting excellent results.

Always wear protective gloves, eyewear, and an approved respirator. Be in a well-ventilated area. Read all warnings and first aid information and read and follow all instructions when using any DuraCoat® products.