

Compound Application Procedure

Compound Description:	Fire Retardant Protoplass©
Applicable Technologies:	SLA, SLS, FDM, Digital Printed
Revision Level:	A
Revision Date:	March 2007

Legend: ■ -Application Notes ● - Work Content ▲ -Inspection

- Fire Retardant Protoplass© is an aerosol spray that is fast drying and easy to apply.
- Fire Retardant Protoplass© should be used with Proto-Reinforcement© coating.
- Average material usage for Fire Retardant Protoplass© is 1200 square inches.
- When correctly applied, the finished layered thickness of this engineered layer technique will be .006" inch with a tolerance of +/- .001".
- Shake the Fire Retardant Protoplass© can well before spraying.
- If using a sweeping, heavier spray over the part, do 2 passes over the area and count it as 1 layer; typically apply 5 layers but refer to the Standard Application Procedure for specific instructions to obtain different part characteristics. If using a spray technique that is more of a mist, similar to the way you would apply spray paint, then apply 10 layers. In either case, apply 2 passes to equal one coat when using this method. Wait 30 seconds between coats.
- Never wait more than an hour to apply the next layer of coating. This applies to the same or other tempering coatings and materials. This may damage the previous coat breaking down the chemical materials.
- It will take 12 hours for Fire Retardant Protoplass© to cure, but the parts can be handled and shipped within one hour.