

Compound Application Procedure

Compound Description:	<u>Proto-Plasma-Rx™</u>
Applicable Technologies:	<u>SLA, SLS, FDM, Digital Printed</u>
Revision Level:	<u>A</u>
Revision Date:	<u>March 2007</u>

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

- Proto-Plasma-Rx™ is an aerosol spray that is fast drying and easy to apply.
- Proto-Plasma-Rx™ should be used with Proto-Reinforcement© coating.
- Average material usage for Proto-Plasma-Rx™ is 2200 square inches.
- When correctly applied, the finished layered thickness of this engineered layer technique will be .004" inch with a tolerance of +/- .001".
- Shake Proto-Plasma-Rx™ 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 (coat); typically apply 2 coats for sealing and added durability while only adding .002 inches to the part. Typically apply 6 coats for maximum durability and impact strength 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 do spray paint, then apply 4 to 12 layers. In either case, apply 2 passes to equal one layer when using this method. Wait 30 seconds between coats.
- When Proto-Plasma-Rx™ is applied properly, it will seem like you are laying the coats on thick, but this will not be the final results. During the curing period the Proto-Plasma-Rx™ it will start expanding as soon as it hits air. Wait 30 seconds in between coats.
- In tight fitting or threaded areas, avoid spraying anything except a light coat of Proto-Plasma-Rx™
- 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.

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- It will take 12 hours for Proto-Plasma-Rx™ to cure, but the parts can be handled and shipped within one hour.
- Paint and plating can be applied over Proto-Plasma-Rx™.