

# Compound Application Procedure

Compound Description:	RP Tempering™ Compound - Injected
Applicable Technologies:	SLA, SLS
Revision Level:	A
Revision Date:	March 2007

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

- RP Tempering™ Compound is a compound coating with MWCNT (Multi-Walled Carbon Nanotubes) that is fast drying and easy to apply.
- RP Tempering™ engineered layering techniques with Proto-Reinforcement© and/or Proto-Plasma-Rx™ are recommended in combination with RP Tempering™ Compound to achieve superior results.
- Do not shake the container before use.
- Secure the following materials and tools:
  - Injection Applicator Tool
  - Extractor Tool
  - RP Tempering™ Compound
  - Paper Towels
- Place the clear rubber tube tightly on the end of the Extractor tool. The plunger should be pushed all the way in.
- Take off the lid of the RP Tempering™ Compound.
- Place the clear rubber tube which is connected to the Extractor down into the RP Tempering™ Compound. Hold the base of the Extractor firmly with one hand, and pull the plunger ring with the other hand to fill the Extractor with RP Tempering™ Compound.
- Use a paper towel and grab the clear plastic tube and pull it off the Extractor. Wipe off the excess RP Tempering™ Compound.
- Clean the outside of the rubber tube and seal the ends with tape.

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- Gently set the lid back on the RP Tempering™ Compound.
- Pull the plunger out of the Injection Applicator body.
- Remove the needle like end from the Injection Applicator by twisting it a ½ turn.
- Pick up the Extractor with the rubber tube off. Insert the end of the Extractor tip into the open end of the Injection Applicator body and fill it 90% full.
- Insert the plunger into the filled Injection Applicator by tilting it upside down, which will allow the compound to run to the back of the Injection Applicator so that the excess air can be pushed out.
- Replace the needle like end on the Injection Applicator by twisting it a ½ turn.
- Insert the tip of the Injection Applicator into the tunnel, "V" Groove, or U shape of the part and push until the area is full. Repeat the process until all the tunnels, "V" Grooves and U shapes are full.
- Small air bubbles are OK.
- Wipe any excess compound with a paper towel
- Put all the RP Tempering™ Compound left in the Injection Applicator and Extractor back into the RP Tempering™ container. Seal the end of the Extractor with tape and place it in a sealed bag for future use.
- Make sure the lid is put tightly on the RP Tempering™ compound can.

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- Throw away the injection applicator.
  
- Average material usage for RP Tempering™ Compound is 800 square inches when brushed on, 7200 linear inches of tunnels and "V" Grooves.
  
- It will take 12 hours for RP Tempering™ Compound to cure, but the parts can be handled and shipped within one hour.
  
- 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.