

Standard Application Procedure

Process Description: Create Living Hinges
Applicable Technologies: SLA
Revision Level: A
Revision Date: May 2007

Proto-Plasma-Rx

Proto-Plasma-Rx

Proto-Plasma-Rx

RP Tempering Compound

Proto-Reinforcement Coating

Proto-Reinforcement Coating

Living

Hinge

Supplies Needed:

- RP Tempering™ Compound
 - Loading Extractor
 - Injection Extractor
 - Squeegee
- Proto-Reinforcement© Coating
- Proto-Plasma-Rx™
- Rags or Paper Towel

Step 1: Gather the above supplies.

Step 2: Ideally the living hinge wall should be .015" to .020" thick to achieve the best results.

Step 3: Following the Compound Application Procedure for Proto-Reinforcement© apply 2 layers of the Proto-Reinforcement© using a brush to the living hinge plus 1/8 inch over onto the adjacent surfaces. Use thin coats of Proto-Reinforcement© for SLA materials, waiting 1 minute between coats.

Step 4: Allow 5 minutes to dry then very carefully and slowly flex the part 20 degrees inward, then flatten again. Be sure to support both sides of the hinge. If the part seems fragile disregard this step.

Step 5: Following the Compound Application Procedure for RP Tempering™ - Injected, apply the RP Tempering™ compound with the injector to the living hinge and smooth using the squeegee or small brush for tight areas.

Step 6: Following the Compound Application Procedure for Proto-Plasma-Rx™ spray on 3 coats of Proto-Plasma-Rx™.

Step 7: Allow 12 hours to achieve the full capability of the living hinge.

Standard Application Procedure

Process Description: Create Living Hinges

Applicable Technologies: SLA

Revision Level: A

Revision Date: May 2007

Step 8: To initially break in the hinge, start by flexing it small amounts for 5-6 iterations before subjecting it to normal hinge activity.