

# DuraBake Instructions

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. In a commercial application I recommend blasting with 60-120 grit aluminum oxide or sand. When blasting is complete blow the dust off the parts with shop air. (Option) For an even better overall finish Parkerize the parts at this point. 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. Apply with a conventional air spray gun or a HVLP spray gun. Add xylene to reduce the DuraBake if it does not fully atomize.(you want a smooth finish) Spray in 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. 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 xylene. Allow the coated parts to sit for 20 minutes at room temperature before placing them in the oven. Bake metals at 300°F for 15 minutes. Bake alloys and synthetics at 180°F for 3 hours. When the parts cool down they are ready for assembly. Although the DuraBake coated firearm 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.