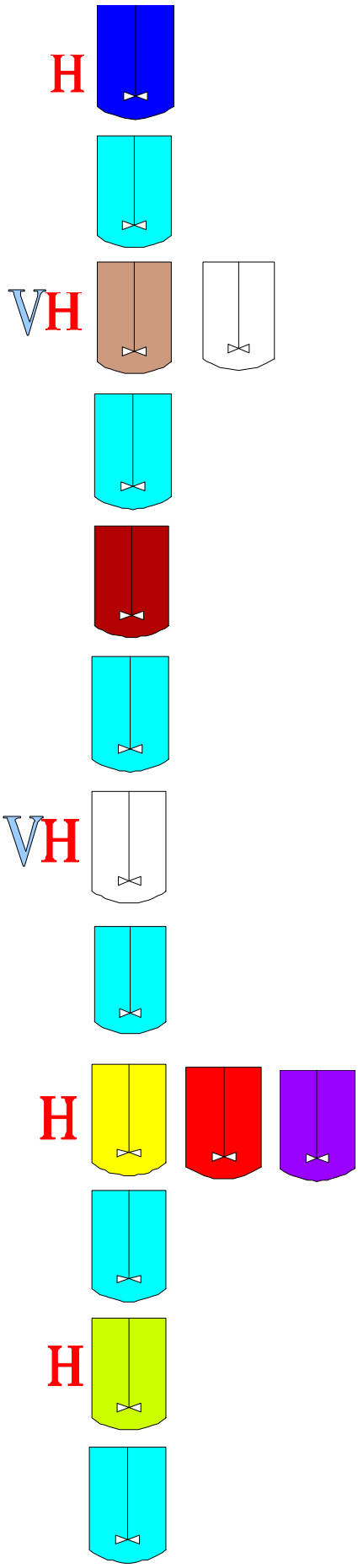
# DiamonDyze™ Processing




The first tank, made of Polypropylene is for initial cleaning. Parts are hung on racks made of titanium or aluminum then dipped in An100 for 15 min or until all soils are off & clean . The tank should be agitated either mechanically or with a pump circulating the liquid. The liquid in this tank should be heated to 120F to 140F. The parts will be in the tank for 15 minutes.

Next the parts should be rinsed in deionized water dipping at least twice to remove all residues from the cleaning tank. The tank contains deionized water at room temperature. The second tank is a rinse tank and is made of Plastic.

The next step is to either etch or polish. Polishing is preferred for most applications though the chemical is more expensive. If the appearance is not critical an etching compound may be used. The tank is heated to 160F and the parts will remain in this tank for 6 to 10 minutes with the liquid being agitated. This tank requires that voltage be applied. It is to be maintained at 12 V DC and the amperage adjusted to maintain 12 V DC. A Polypropylene tank is used.

Next the parts should be rinsed in deionized water dipping at least twice to remove all residues from the previous tank. The tank contains deionized water at room temperature. The tank is a rinse tank and is made of Plastic.

This application is known as desmutting. The parts should be placed in this container for 3 to 5 minutes with constant agitation of the chemical. This will be at room temperature and the tank is to be made of polypropylene.

Next the parts should be rinsed in deionized water dipping at least twice to remove all residues from the previous tank. The tank contains deionized water at room temperature. The second tank is a rinse tank and is made of Plastic.

This is the anodizing tank and it is critical that the temperature be maintained at between 68 and 72 F. This can require both heating and cooling of the tank. This tank contains a Sulfuric Acid solution. The parts remain in the tank for a minimum of 120 minutes with agitation. It is necessary that the amperage induced in this tank be maintained at a rate of 10 to 12 amps per Sq. Inches of surface to be treated. The tank is to be made of polypropylene.

Next the parts should be rinsed in deionized water dipping at least twice to remove all residues from the previous tank. The tank contains deionized water at room temperature. The second tank is a rinse tank and is made of Plastic.

Parts are dipped into the color of DiamonDyze chosen. Colors may be mixed to create non standard shades. The temperature of the tank is to be maintained at 120F to 140F for 10 to 15 minutes, with agitation. This tank is made of Polypropylene.

Next the parts should be rinsed in deionized water dipping at least twice to remove all residues from the previous tank. The tank contains deionized water at room temperature. The second tank is a rinse tank and is made of Plastic.

This is the seal tank and is heated to 180F to 190F and the parts are dipped into this tank for 15 minutes with agitation.

Next the parts should be rinsed in deionized water dipping at least twice to remove all residues from the previous tank. The tank contains deionized water at room temperature. The second tank is a rinse tank and is made of Plastic.

**All tanks marked with an "H" are to be heated. All tanks with a "V" require voltage/amperage.**