



# The Alsa Corporation

The Worlds Most Exotic Finishes



## APPLICATION GUIDE CHROMEFX

### BASECOAT APPLICATION:

**Step 1:** Mix an appropriate amount of Basecoat “**B712**” with its supplied hardener “**BH712**” and thinner “**BT712**” at a ratio of (6:1:1).

**Step 2:** Apply the Basecoat in a heavy flow coat. This will flow out to a surface smooth as glass (required for the ChromeFX process). Avoid touching or sanding the surface and keep any airborne debris from landing on the freshly basecoated item.

**Step 3:** Cure the Basecoat for a period of 10 hours @ 140° F.

### CHEMICAL MIXING INSTRUCTIONS:

**Step 1:** Begin by mixing (60 ml) of chemical “**AB**” with every gallon of distilled / de-ionized water then placing it into the container marked “**AB**” in the ChromeFX System.

**Step 2:** You will then mix (30 ml) of chemical marked “**B1**” and (30 ml) of chemical marked “**B2**” for every gallon of distilled / de-ionized water. This mix will be placed into the container marked “**B**” in the ChromeFX System.

**CAUTION: WHEN MIXING THESE TWO CHEMICALS DO NOT MIX THEM DIRECTLY WITH EACHOTHER, ALWAYS ADD TO THE WATER OR IT MAY CREATE A VIOLENT REACTION!**

**Step 3:** Mix 5 ounces (148 ml) of the chemical marked “**Activator**” for each gallon of distilled / de-ionized water. This solution will be placed into the container marked “**Activator**” in the ChromeFX System.

**Step 4:** The final container is labeled as “**Water**” in the ChromeFX System and can be filled completely with distilled / de-ionized water as this is your Rinse gun and will be your most commonly used step.

### CHROMING PROCESS:

**Step 1:** Using the Activator gun thoroughly soak the previously basecoated piece until an even sheen is achieved.

**Step 2:** Completely rinse the **Activator** from the surface using the Rinse gun.

**Step 3:** Using the Chroming gun (dual headed gun) begin applying the chrome (ensuring both sides of the gun have an equal amount of volume coming out). If you notice any yellowing stop chroming and immediately rinse the part completely with the Rinse gun. Using the Chroming gun begin re-applying on any areas that still appears to have a light bluish tint until the desired chroming look is achieved.



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**Step 4:** Rinse the surface completely using your Rinse gun until no chemicals remain.

***NOTE: IT IS EXTREMELY IMPORTANT THAT THE CHROMED PART IS THOROUGHLY RINSED OR ANY RESIDUE LEFT BEHIND WILL CAUSE A YELLOWING EFFECT WITH TIME.***

**Step 5:** Using the air gun / blow gun carefully remove all excess water from the part (taking care not to let any water drops remain as this will cause a stain).

**Step 6:** Wait until all moisture has fully evaporated from the part before moving on to the Topcoat Application.

## **TOPCOAT APPLICATION:**

**Step 1:** Apply Alsa Clear Polyurethane topcoat “**T520**” which mixes at a ratio of (4:1) with its supplied hardener “**TH520**”. At this stage Alsa’s Candy Concentrates can also be added to the mixture to achieve a colored chrome effect once applied.

**Step 2:** Cure the topcoat for a period of up to 1 hour at 140° F.