



**THE ALSA CORPORATION**

## **Chrome FX Mobile Pro Instruction Guide**



**You have just purchased the most portable and economical spray chrome system in the world**

**The Chrome FX Gun comes attached directly to the pots making it extremely mobile and capable of performing on the spot smaller jobs**

**Your Mobile Pro Chrome FX System includes the following:**

**The Chrome FX Gun/2 Pots, Activator Gun/Pot, D I Gun/Pot, Air Gun, 1qt. Basecoat, 8oz. Basecoat Hardener, 1qt. Topcoat, 1qt. Tint Topcoat, 2-8oz. Topcoat Hardener, 1-4oz. Concentrate (A)=(Silver), 1-8oz. CFX-B (B)=(Reducer), 1-6oz. Activator Concentrate, 3-4oz. Candy Concentrates**

## **INSTRUCTIONS**

1- Prepare your substrate to be chromed. (Primers if needed will seal the porous substrate. Our tech support team can advise you to help determine which of the many Alsa primers best suits your application if needed.) Ensure that the substrate is properly cleaned primed and sanded as if you are painting a finished piece.

2- Always mix your basecoat in a ratio of 4:1 basecoat/hardener. Apply CFX Base Coat, one light coat followed by one heavy or two medium wet coats and allow to dry until completely cured.

3-Once you have your substrate ready to chrome prepare your Mobil Pro for chroming and:

- check for any air leaks and tighten or adjust fittings
- clean containers and make sure they are free of debris and or liquids
- prepare your chemicals

### 4- Chemical Preparation

(A) = Silver: 13.5 grams (or 13.5ml) for each 32 oz. of De-Ionized water (not included)

(B) = Reducer: 28.1 grams (or 28.1ml) for each 32oz. of De-Ionized water (not included)

Note: Distilled water is not a substitute for D-I water.

Activator: 38.7 grams (or 38.7ml) for each 32oz. of De-Ionized water (not included)

(For half the amount of D-I water use half the amount of the chemicals)

5- Fill your Mobile Pro with each chemical in it's specific container.

### **YOU ARE NOW READY TO CHROME**

A- Take special precautions not to touch your substrate once it has been Base Coated and Dried as your finger prints will show on your finished product.

B- Place your piece in a manner in which your prepared chemicals will reach all areas to be chromed and secure your piece as chemicals under pressure can potentially move your pieces around especially smaller items.

C- Apply 2-3 even passes of Activator to your piece and visually inspect that your piece "sheets" which means the Activator completely wets your substrate with no breaks in the coverage. If breaks should occur re-apply the Activator and once the "sheeting" has been achieved, allow 10 seconds and rinse off all excess Activator from the piece.

**D- Apply chroming chemicals to the piece in an even motion. Apply in 2 passes and then rinse with the De-Ionized water and continue to chrome until the full chrome has occurred making sure *not to “over chrome”*. Once you have finished this step rinse off all excess chemicals with the De-Ionized water.**

**E- Dry your piece with compressed air in an even motion, top to bottom, ensuring all water evacuates evenly to avoid staining. Allow moisture to evaporate from your piece for at least 2 hours depending on the ambient air temperature.**

#### **YOU ARE NOW READY TO TOPCOAT**

**Once you have achieved your chromed surface you are now ready to topcoat. For just a clear top coat use the product labeled *“Tint TopCoat”* only and apply the CFX *“Tint TopCoat”* to your piece. If a color chrome is desired mix the product labeled CFX *“TopCoat”* with any of the Elsa Candy Concentrates. 2-3 coats is required in either case and allow to dry in the same manner as you dried the base.**

#### **YOU ARE NOW FINISHED**

**Make sure you clean off all your equipment and store it properly so as not to contaminate the components. It is very important to note here that you always place the A and B chemicals in the respective A and B pots and never mix them up.**

**NOTE: STORE ALL CHEMICALS IN A COOL PLACE**

**It is strongly advised that you read the next section on **TROUBLESHOOTING** before you start this process as this heads up will make your chroming easier.**

## **TROUBLESHOOTING**

As in any industrial finishing process, problems are sometimes encountered with respect to the appearance of the finished product. It is therefore important to know where to look in order to correct any problems that occur.

An effective first step in determining which step of the process is causing the problem is to apply the ChromeFX™ Intermediate Coat to a clean piece of glass, which has not been base coated. If the glass is metallized without any problems, you can then narrow the problem down to the Basecoat or Topcoat.

Please remember that when trying to isolate the problem, the source could lie either with the chemicals or the technique.

Your spray area must also be from 72 to 92 degrees Farenheit.

If you are still experiencing problems, after testing the ChromeFX™ Intermediate Coat on a piece of glass and looking through this troubleshooting guide, please do not hesitate to contact us for further technical assistance.

**Problem: The ChromeFX™ Intermediate Coat deposit comes out blue or cloudy.**

### **Cause / Solution:**

- The base coat may not be dry enough
- The Activator may be too old and therefore should be changed
- The de-ionized or distilled water has gone bad and therefore should be replaced
- The calibration of the gun has been changed so that too much or too little is being sprayed; both amounts must be spraying equally & simultaneously

**Problem: The product surface will not accept the Basecoat.**

### **Cause / Solution:**

- Improperly mixed Basecoat:
  - Always mix your basecoat at a ratio of 4:1 basecoat/hardener.
- Contamination of the product surface.
  - Clean the product surface prior to basecoating with a streak free cleaner.
  - Apply a light, even first coat, let flash, then apply a steady even heavier coat. This can be repeated until you achieve an even sheen.

**Problem: Can not achieve an even sheen when applying the activator.**

### **Cause / Solution:**

- The product surface was not properly cured.
  - Let the basecoated surface cure for 24 hours (or force dry) in a contaminant/dust free area before applying the activator. If the air temp is below 75 degrees allow 36 hours for drying. When force drying/baking 2-3 hours no more and no less at 140 degrees is sufficient. Allow twenty minutes after spraying basecoat to force/bake dry. Allow piece to cool down after baking for at least 15 minutes.
  - **Always ensure your Base Coat is completely cured !**

**Problem: There is a hazy or smoky look to the chrome before applying Topcoat.**

### **Cause / Solution:**

- The Activator was not thoroughly rinsed off.
  - Rinse with distilled water taking care to hit every recessed area that may hold activator.
  - Always try to rinse the object from top to bottom to insure a proper sheeting action.
  - Take care to avoid splashing of this rinse back onto already cleaned areas. As this will cause small brown (burnt looking) spots to appear in the chrome coat.
  - Try to maintain a temperature during chrome stage of roughly 70 degrees to prevent a humidity build up when you apply the cool water to the surface.
  - The de-ionized or distilled water may have gone bad and should be replace
- If a fogginess remains even after blowing the surface dry, place the object in a drying oven for a short period of time to remove the moisture from the surface.
- **Make sure your gun has been set up properly so that the A/AB and B solutions are being applied at the same rate.**

**Problem: Product surface accepted Basecoat and Intermediate Chrome Coat without issue, but appearance problems occurred after applying clear Topcoat.**

### **Cause / Solution:**

- Make sure to use the ratio indicated on your Topcoat container. Too much Topcoat will make it too thick to properly flow from the gun causing heavy deposits on the surface (orange peel). Too much hardener will cause the Topcoat to try to set up before it can flow out smooth. Leaving you with a far less durable finish.
- Set your air pressure to no greater than 60 psi.
- Keep your gun 6-8 inches above the surface and apply in a smooth steady fashion, making sure to keep your gun the same distance from the surface.
- Allow pieces to cure according to the following:
  - Basecoat: air dry (24-48 hrs.) / force dry (2-3 hours @ 140 degrees)
  - **DO NOT OVER CHROME. Once the piece is fully chromed stop! Do not over apply the chroming solution as this can cause cloudiness and hazing as you apply the topcoat later on.**

- Topcoat: air dry (12 hrs.) / force dry (1 hour. @ 140 degrees)
  - The temperatures listed above are for plastics. Aluminum, Glass & Ceramics can withstand higher temperatures.
  - High speed, continuous line operations do not need to let the products air dry overnight