

# **Instructions For Application of FIB-Based Paints**

## **Product numbers: UF-\*\*\*, F-\*\*\*, BF-\*\*\*, FF-\*\*\*, and FB-\*\*\***

**Warning!** Use with adequate ventilation or appropriate respiratory protection. This product is flammable; do not spray near flame, heat, or sparks. This product contains solvents and propellants that may damage some plastic surfaces.

**Note!** FIB-based paints must be sprayed over clean metal, FIB basecoat (FB-\*\*\*), or cured screen layer (SCR-\*\*\*). Failure to do so may result in the PSP manifesting a high temperature sensitivity to its pressure response and/or corruption of the pressure response calibration.

### **Directions:**

1. Clean the model, calibration coupons, and a small test piece with alcohol or acetone on wipes.
2. Shake the paint thoroughly for several minutes. Ideally, the paint in its container may also be partially submerged in an ultrasonic bath (cleaner) filled with water for a few minutes to enhance mixing.
3. Pour the paint into the gun without filtering or straining.

For the Astra brand touch-up gun: Set touch-up gun to the lowest air setting that will still suck paint up the tube. This may vary due to air-hose differences (20 psig or 137 kPa is a typical starting point). This keeps overspray to a minimum. Set the fluid control knob on the sprayer all the way closed (clockwise) and then open it two full turns (anticlockwise) and pattern control to almost full open or anticlockwise. This setting yields a sheet pattern (as opposed to a circular pattern at the opposite extreme of the adjustment) which typically yields more uniform results.

For the Badger brand air brush: Set the pressure to 10 psi (68kPa) or less.

4. Test your spray method on a test piece of metal. Keep the can about 12 inches (30 cm) away from surface while spraying.
5. See the specific directions for each product below before painting the model surface.
6. Models coated with FIB-based paints should be cured at 65° C for at least one hour in order to minimize the temperature sensitivity of the pressure response of the paint.

### **For UF-\*\*\*, F-\*\*\*, or FB-\*\*\* Paints:**

Over a bare metal surface or screen layer coated surface, apply about 7 to 9 (very light) cross coats. Cross coats means working from left to right or right to left while moving down the model, then work back up left to right or right to left. This constitutes one coat. The next coat is applied top to bottom or bottom to top in a similar manner.

Do not exceed 12 coats as too much paint could result in separation from the metal. Do not apply a wet coat. Wet coats may cause the model to appear to have a skin rash.

**For BF-\*\*\* Paint:**

Over a bare metal surface or screen layer coated surface, apply about 12 to 18 (very light) cross coats. Cross coats means working from left to right or right to left while moving down the model, then work back up left to right or right to left. This constitutes one coat. The next coat is applied top to bottom or bottom to top in a similar manner.

Do not exceed 18 coats as too much paint could result in separation from the metal. Do not apply a wet coat. Wet coats may cause the model to appear to have a skin rash.

**For FF-\*\*\* Paint:**

Over a bare metal surface, apply about 5 to 7 (very light) cross coats. Cross coats means working from left to right or right to left while moving down the model, then work back up left to right or right to left. This constitutes one coat. The next coat is applied top to bottom or bottom to top in a similar manner. Additional coats will slow the paint response time. Wet coats may cause the model to appear to have a skin rash.

**For all Paints:**

For best results, apply light coats, allow paint to dry between coats (~10 sec.), and STOP when you have good coverage.

**Most common reasons for FIB paint failure:**

**1. Too many coats on the surface.**

The paint will crack and peel off. This will require the model to be repainted.

**2. Applying paint too heavily. (surface appears wet)**

Generally caused by moving the gun too slowly. This will look like a rash, repaint recommended if the problem is extensive.

**3. Grease or oil on surface.**

May not notice this by eye, but the temperature and pressure sensitivity of the paint will be compromised. Clean and repaint.

**Removal of PSP from surfaces:**

Acetone on wipes works best for metal surfaces, but will damage most plastic surfaces.

Please contact ISSI if you have any paint questions,  
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