



HYDRO-DIP



Dip Kit Instruction Manual

Welcome to Hydro Dip Kit Kryptek Edition. This kit will allow you to prep, paint, dip, and clear coat items of your choice in your selected pattern. This is a painting and dipping process using hazmat materials. In this manual and on the back of your aerosol cans, you will find complete instructions and safety information for this process.

Before you begin

You will need a dipping container. Make sure the container is large enough to accommodate both the size of your film and the part you are going to dip. Most objects will be dipped at a 30 degree angle. If you are dipping a rifle stock, be sure the stock can be fully submerged in the tank without touching the bottom or sides of dipping container. Bathtubs and sinks are not recommended due to clean up challenges. A variety of plastic containers are available at local box stores that vary in price. Locate your dip tank in an area that will not be exposed to wind, falling debris, or splashing water.

Your kit contains the following: All products can be purchased separately at www.hydrodip.com

- All-Surface Primer
- Base Color Paint
- Film Activator formulated custom for the pattern in your kit.
- Matte Clear Coat
- Hydrographic Film
- Prep-Wipe/s
- Scuff Pad/s
- Nitrile Gloves (Deleted Respirator since we don't offer that)
- Touch-up Dabber tool/s
- Instruction Manual Also downloadable at www.hydrodip.com

Clean and Prep Parts.

For good adhesion, surface must be free of dirt, grease, wax, rust, or moisture.

The following steps are important and will promote solid paint adhesion to your parts. This will add to durability and life expectancy of your protective Hydrodip coating.

1. Using the provided Prep-Wipe clean parts thoroughly. All wax, grease, and contaminants **MUST** be removed. It is important to clean the surface before scuffing to prevent scratching contaminants into the substrate.
2. Use provided scuff pad to dull the surface. This causes micro scratches in the surface which will help the primer to mechanically bond with the base substrate for years to come.
3. Re-clean the scuffed parts with the prep wipe.
4. Be sure to mask any areas where paint and overspray is not desired.

Now is a great time to determine how you will manage the part while it is being painted. Hooks, masking tape, jigs, and various devices are commonly used here for holding, managing, and suspending parts during the spray processes.

Apply All-Surface Primer

1. **MIX BY SHAKING CAN VIGOROUSLY.** Allow metal ball to mix All-Surface primer thoroughly for 3 minutes. Repeat during use.
2. **COVER NEARBY AREAS TO PROTECT FROM SPRAY MIST.**
3. **PRACTICE SPRAY TECHNIQUE.**
4. **PRIME ITEM.** Spray can upright 7"- 8" away from surface using sweeping motion side to side with slight overlap. Apply 4 medium coats until coverage is achieved, wait 5 minutes between each coat.
5. **AFTER USE:** To prevent clogs, hold can upside down and spray until clear gas appears. To clean overspray or if nozzle becomes clogged, wear eye protection and wipe with mineral spirits following solvent manufacturer's instructions. **DO NOT** stick a pin in spray tip opening.
6. **After 15 -30 minutes (when primer is dry to the touch) you may begin painting**

Base Color Paint

1. **MIX BY SHAKING CAN VIGOROUSLY.** Allow metal ball to mix Base Color thoroughly for one minute. Repeat during use.
2. **COVER NEARBY AREAS TO PROTECT FROM SPRAY MIST.**

3. **PRACTICE SPRAY TECHNIQUE.**
4. **PAINT ITEM.** Spray can upright 10"- 11" away from surface using sweeping motion side to side with slight overlap.
5. **First Coat-** Spray first light coat. Full color coverage is not needed here. This creates a tack coat for the next coats to adhere to.
6. **Second Coat-** Spray a medium wet coat with full color coverage. Wait 5 minutes and apply a third coat, wait 10 minutes and apply a 4th coat. It is important to not only achieve color coverage, paint build is also important. If the paint is too thin, film activator will eat the paint off the part during the dipping process. The dipped graphic will slide off with the paint if this occurs.
7. **Wait a MINIMUM of 30 minutes for paint to dry before dipping.**

Lay Film

1. Fill dipping container with 92 degrees F to 96 degrees F. Do not over fill your container. The container should not overflow while submerging items. Be sure the dipping container is deep enough to allow your part to fully submerge in water, without touching the bottom of the dip container.
2. Shake activator can for 1 minute
3. Place the desired cut of film for the object you're dipping shiny side down on top of the water and wait 60 seconds before applying activator. Do not trap air bubbles under the film while laying film on the water. See video www.hydrodip.com/
4. Mix Activator can by shaking vigorously.
5. Hold can 12" to 18" from surface of film at a 45 degree angle, do not hold horizontally and spray in even, consistent passes until the entire surface is wet and glossy. This is a critical step! Dry spots on the film will not yield positive results. See Video <https://youtu.be/TIQ5dY5GyT4>

Dip Parts

1. Wait 15 to 20 seconds after applying activator before dipping your part. In general parts should be dipped in a slow and controlled fashion at a 30 degree angle to allow air to flow out from under your part. Softly touch down your part to avoid touch down dots. Do not trap air bubbles, always dip your part at an angle and avoid touching flat surfaces down on the film. This traps air bubbles and leaves speckles in your graphic.
2. When removing dipped part from container avoid allowing dipping debris to stick on your part. Do not touch a freshly dipped part until it has been rinsed. Immediately begin a clean water rinse with warm water to wash away all of the liquefied film. The liquid film is clear and slimy like a butter coating on your part. Warm water will rinse it more quickly than cold. This must ALL be washed away. 5 to 7 minutes of fresh water will usually do the job. Lightly touch the part with wet fingers to feel for the slime.
3. Allow part to air dry or help it with a fan or air compressor.

Touch Up Imperfections

1. Touch up any imperfections that may exist. Place a few drops of activator on a small piece of film. Using the cap of your aerosol can spray a small amount of activator into it. Use your dabber as a paint brush to collect the color of ink you desire from the film. Dab this ink on areas you feel need a little help. Speckles, spots, air bubbles etc. Additionally you can use paint, markers, colored pencils and other items to help touch up. Air brushes work great!

Apply Protective Matte or High Gloss Clear Coat

1. **MIX BY SHAKING CAN VIGOROUSLY.** Allow metal ball to mix clear coat thoroughly for one minute. Repeat during use.
2. **COVER NEARBY AREAS TO PROTECT FROM SPRAY MIST.**
3. **Insure part is completely dry and clean, free from debris**
4. **PRACTICE SPRAY TECHNIQUE.**
5. **CLEARCOAT YOUR ITEM.** Spray can upright 10"- 11" away from surface using sweeping motion side to side with slight overlap. Apply a light tack coat, wait 5 min, apply medium wet coat, wait 10 min, apply final wet flow coat.
6. **AFTER USE:** To prevent clogs, hold can upside down and spray until clear gas appears. To clean overspray or if nozzle becomes clogged, wear eye protection and wipe with mineral spirits following solvent manufacturer's instructions. **DO NOT** stick a pin in spray tip opening.

Post Decoration Card

1. Allow several hours for clear coat to dry before handling. Handling parts before clear coat is dry may result in damage to the new coating. Your coating will continue to harden for the next 30 days. Keep freshly painted items at room temperature during this time. When temps drop below 50 degrees F curing will cease.
2. For cleaning, please handle this coating as you would the paint on your car. You can wash and dry with soap and water. Do not wax during the first 30 days.
3. If you have any troubles please contact us at (541) 523-6700 or email us at hydrodiptm@gmail.com