

U-NAMEL®

A new method of enameling utilizing fast curing ultraviolet sensitive material

ADVANTAGES:

- Cures in 1-2 minutes
- Scratch, wear & shock resistant surface
- Does not chip, crack, flake, peel or shrink
- Easy to drill, grind, polish, carve or sand and can be turned on high speed lathes.
- Simple to mix colors, to create virtually any color, that won't fade
- Adheres to virtually any surface

USES:

- Inlaid into precious or non-precious metal, stone, glass, plastic, ceramic, enamel or U-NAMEL® itself.
- Can be layered to make cabochons
- Can be used next to other **U-NAMEL®** or mixed to make interesting designs.

INSTRUCTIONS FOR PROFESSIONAL USE

Thoroughly clean the surface, by either sandblasting or using a tool. Scratch or roughen the surface for better adhesion. Surface can be degreased by using an electrolytic degreasing method or by thoroughly cleaning with alcohol. Be certain that the alcohol has thoroughly evaporated before applying **U-NAMEL®**.

So that **U-NAMEL®** adheres to the surface better, it is advisable to sandblast the surface with 150-250 micron corundum at a pressure of 60-90psi (4-6 bar). Edge undercuts are the best method to keep **U-NAMEL®** in place. For large areas, it is best to drill anchor holes and allow **U-NAMEL®** to flow into them. **U-NAMEL®** must be used at room temperature.

CAUTION: Be certain to use the amber goggles(#10425) when using the UV lamp. Severe eye damage could occur if you look directly into the UV lamp without the protective goggles.

U-NAMEL® can be applied by slowly dripping the liquid into the application area. You can also use the optional micro brushes (#br405) . Always be sure to clean all tools and brushes ESPECIALLY the tips and optional dispenser needles with isopropyl alcohol after use.

Apply **U-NAMEL®** to the surface in thin layers (0.8mm for clear and light colors, 0.2mm for dark colors). Thick layers require longer UV curing times and may not cure thoroughly. Place the item with the wet **U-NAMEL®** under the curing light for 1-2 minutes. It is always best to leave the item in the curing light as long as possible until it is thoroughly hardened. Additional layers can be directly added to the cured first layer, to create special effects or to make cabochons.

Cured material can be removed by grinding or burning at 570-725°F (300-380°C). Metal surrounding **U-NAMEL®** can be

electroplated without affecting the surface. Polishing can be achieved by grinding the tacky surface and then polishing.

STORAGE: It is best to store **U-NAMEL®** in a light protected environment at temperatures between 59-70°f (15-21°c). **U-NAMEL®** is provided in UV block containers to protect the unused material.

KEEP OUT OF REACH OF CHILDREN!!