

Application Information - (Hot Bonding Treatment)

FASTEX® HBSM is a surface modifier hot bonded onto metal surfaces, using hot water, hot air or an oven as the heat source. **FASTEX® HBSM** will bond to high speed steels, tungsten carbide and TiN or TiCN coatings.

HOT WATER:

This method is the preferred method of application and will achieve a 100% surface treatment within seconds of application.

1. Take the product to be treated and immerse into very hot water for a period of approximately 1 min. Please note the times will vary with mass of object to be treated. Check that the surface temperature exceeds 55°C (132°F) with IR thermometer.
2. Remove product from hot water and wipe, spray, brush or dip **FASTEX® HBSM** onto the surface immediately while still hot.
3. Repeat steps 1 & 2.

WARM AIR:

1. Using a hot air blower (such as a paint stripper), heat the area to be treated until the product's surface has been heated to 55°C (132°F) or above. Please note the times will vary with the mass of object to be treated. Check that the surface temperature exceeds 55°C (132°F) with IR thermometer.
2. Wipe, brush, spray or dip **FASTEX® HBSM** over the heated area and reapply the warm air for a period of 1 to 2 minutes.
3. Repeat step 1 & 2.

OVEN:

Care should be taken when heating the product as only the surface temperature is required to reach the bonding stage (overheating may cause annealing to commence on hardened tools). **Do not overheat.**

1. For best results tool parts should be coated with a thin film of **FASTEX® HBSM** and placed in a preset oven at 100°C (212°F) for 10 minutes.
2. Remove product from oven and wipe, spray, brush or dip with a second coating of **FASTEX® HBSM** onto the surface immediately.
3. Return product to the oven and for a further 30 minutes.

Notes:

Ensure surfaces to be treated are clean.

Do not use any flames such as oxy-acetylene or propane gas for warming component surfaces as these will generate surface contamination prior to treating with **FASTEX® HBSM**. Caution should always be taken when handling heated products.