

SURFACE PREPARATION

The performance of any coating or treatment applied to copper-base alloys is dependent upon the care with which the metal surface has been prepared prior to the application of the coating. The following general conditions of the surface to be protected must be considered:

The surface of **new metal** must be thoroughly buffed and made chemically clean. The metal should be treated with a copper cleaner. After removal of the cleaner, it should be possible to wipe the metal with a cloth which has been dampened with a solvent compatible with that cleaner. The surface will then be sufficiently clean for the application of the coating.

The surface of **old metal** that is to be refinished must be completely free of all minute traces of old coating, and all surface stains removed. **IF THE OLD COATING IS INCRALAC®, NO STRIPPING IS REQUIRED. AFTER REMOVAL OF ACCUMULATED DUST AND GRIME, SIMPLY APPLY A NEW COATING OF INCRALAC®.** When other coatings had been used, a lacquer stripper is generally best. The thickened material is spread on the surface to be stripped and allowed to soak for a few minutes. A scouring pad may be used to apply the lacquer remover. (Steel wool should not be used on copper-base alloys.) Rubbing should be with the “grain” of the metal not across the metal’s rolling direction.

The stripper should then be allowed to stand on the old coating for a few minutes, then removed by wiping with clean cloth and flushed with appropriate solvents. In many instances, multiple applications of the stripper are necessary to completely remove all traces of the coating from the metal. After removal of the stripper, a cleaner is applied to the surface of the metal using a cloth wetted with the cleaning compound.

To avoid **staining**, the cleaner should be applied to a limited area of the surface and quickly wiped off with a clean cloth or scouring pad. Should staining occur, it can be removed by additional applications of cleaner. In cases where stains persist it may be necessary to use the more abrasive scouring pads to mechanically abrade badly corroded areas.

If the metal has been severely stained, it can frequently be restored to its initial appearance by the application of a solution containing about 5% oxalic acid dissolved in a mixture of 3 parts water and 1 part butyl cellosolve. With using oxalic acid solutions as stain removers, care must be taken to remove all traces of the acid by repeated washing with clean water or water with butyl cellosolve, and wiping dry with clean cloth.

HIGH HUMIDITY CONDITIONS WILL ACCELERATE CORROSION OF THE COPPER SUBSTRATES. INCRALAC® SHOULD BE APPLIED WITHIN ONE HOUR OF CLEANING THE METAL TO A DRY SURFACE, OR CLOUDING WILL OCCUR.