



HANDLING INSTRUCTIONS

Steps for Coating Assembled Aluminum Profiles with Technoform Bautec Strips

1. **Clean the assembled profiles** using conventional cleaning and/or pre-treatment baths.
2. **Dry the profiles** using compressed air to blow out excess liquid or by tipping profiles and allowing them to drain.

Note: No residues from the bath can remain in the profile cavities or gaps. Moisture can lead to blistering or rupturing of the strips during heating.

3. **Suspend the profiles for coating and heating.** To avoid excessive bending in a horizontal coating process, profiles may have to be supported at points other than the ends.

To prevent uneven coating and to keep the assembled profile as straight as possible, suspend the assembled profile from the heavier aluminum extrusion.

4. **Coat and heat the profiles.** The approximate temperature range is 360°F - 390°F (180°C - 200°C) and oven time of approximately 20 minutes. At time and temperatures beyond this, the Bautec strips may suffer permanent deformations. The final coating process may be affected by the size and location of the strip within the assembly, the mass and thickness of the aluminum surfaces and should be tested prior to final approval.

Please contact Technoform Bautec at 330-487-6600 for further information.