

Recommendations for the **APPLICATION OF PAINT** on Doxsteel Fasteners

Every plating, organic or inorganic, contains micropores, which after a period of time will start to produce stains of red rust on the fastener, especially in the most exposed areas of the outside nut. For this, polyurethane and epoxy paint systems add an additional layer of protection to fasteners in service and work, covering up damage that may occur during assembly or sandblasting. Polyurethane or epoxy paint may seal these micropores and add to the longevity of the coating system.

For the application of paint on doxsteelfasteners, it is highly recommended that the following procedures are followed after applying the final torque on the fasteners.

1. For new installations that need to be painted, sandblast the flange before the fasteners are installed. For in-service conditions flanges that need to be painted and the fasteners are already installed, the recommendation is covering the fastener before sandblasting. Be sure that the blast is not applied directly to the fasteners.
2. Remove dust or the excess of lubricant with a soft brush or cloth.
3. Remove dirt and grease with soapy water and a scouring pad. Wipe the metal dry with clean, lint-free cloths to avoid the formation of flash rust.
4. Fill a paint sprayer with primer. Use an etching primer on bare metal or a bonding primer on previously painted metal. Hold the spray gun about 1 foot from the metal, and spray a coat of primer using smooth, sweeping motions. Allow the primer to dry for the amount of time recommended by the manufacturer. Apply a second coat of primer and allow it to dry completely. This step can be omitted if you are using DTM (direct to metal) paint.
5. Clean the spray gun and hose with paint thinner to remove the primer. Fill the paint sprayer with epoxy metal paint. Hold the spray gun about 1 foot from the metal, and spray a coat of paint using smooth, sweeping motions and overlapping strokes. Maintain a consistent distance from the metal to ensure uniform paint coverage. Allow the paint to dry for the amount of time recommended by the manufacturer, and apply a second coat of paint, using strokes perpendicular to those used for the first coat.

If the Doxsteel Fasteners are not painted, red rust stains may show on the surface; however, these do not compromise the product's functionality and performance, including the engagement between the nut and the torquing tool, the thread engagement between nut and stud, and much less the service life of the part.

FOR OPTIMAL PERFORMANCE DOXSTEEL FASTENERS SHOULD ALWAYS BE PAINTED AFTER ASSEMBLY