



MICRO-CONE INSERTS

CLEANING & STORAGE

COLD TOOL

Clean inserts as needed with acetone and cotton balls (available in pharmacy)
Use cotton swab (Q-tips) for small traces.

AFTER MOLDING

Inserts are made of nickel and will not oxidize.
Do not apply anti-rust mold protection to inserts.
If mold protect is applied to the mold surface and some covers the insert, do NOT try to remove. It will be removed during normal molding.

HOT TOOL

Repeat the same operation but with alcohol.

STORAGE

For long term storage, only apply varnish protection. Wrap in tissue paper and store in original container box.

APPLICATION OF PROTECTIVE VARNISH

This operation must be done in a clean environment free from dust, metal chips etc.

LIST OF MATERIALS NEEDED :

- ◆ Small wood rod 2 to 5 mm in diameter
- ◆ Protective varnish (supplied with inserts)
- ◆ Tissue paper and bubble wrap

STEP #1:

Room must be clean and free of dust.

STEP #2:

Soak wood rod in varnish. Drip varnish on surface that is to be protected.
Repeat until surface is completely covered with varnish.

STEP #3:

Let dry for 4 hours.

STEP #4:

Repeat coating of varnish until tips of optical cones are completely covered.

STEP #5:

When insert is totally dry, wrap in tissue paper and bubble wrap. Store in a secure area.



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REMOVAL OF PROTECTIVE VARNISH

Inserts are delivered with a protective varnish. This varnish protects inserts from manipulation and abrasive particles such as metal chips, dust etc.

This is NOT a protection against impacts.

This operation must be done in a clean environment free from dust, metal chips etc.

LIST OF MATERIALS NEEDED :

- ❖ 2 polypropylene containers (supplied with inserts)
- ❖ 2 soft haired brushes (supplied with inserts)
- ❖ 10 liters of acetone
- ❖ 1 liter of alcohol
- ❖ Protective gloves and glasses

STEP #1:

Use a polypropylene container and fill with sufficient acetone to completely immerge the part that requires cleaning.

STEP #2:

Immerse the part for 45 minutes. Create turbulence by agitating the acetone every 15 minutes. Wait until varnish is completely dissolved.

STEP #3:

Remove insert from acetone and place in the clean second polypropylene container.

STEP #4:

Dip a new & clean soft haired brush in clean acetone. Brush part very lightly without applying pressure in order to remove any residual varnish.

STEP #5:

Immediately after step #4, wash part with warm water and immediately rinse with alcohol. Air blow and dry insert.

ATTENTION

Micro-cone inserts are fragile and can easily be damaged. Damage is usually visible on molded parts and generally irreversible on inserts.

**Treat inserts with the utmost care.
In case of doubt, contact DBM Reflex.**