STEP 1: CLEANING
Clean the part to be coated from heavy dirt with water and washing up liquid. Next rub down the part with a fine abrasive pad.
Clean the part off with a lint-free cloth (dust free surface).
NB: Use latex gloves for protection!

STEP 2: BONDING
Now with a primer spray (e.g Black Carbon Look), spray the parts to be coated.
(Do not breathe primer spray fumes!).
Before the next process you leave the surfaces about 15 minutes to dry. Avoid touching the primed area now. During the waiting period you can continue with the following steps.

STEP 3: PREPARING FILM
Now take the water transfer print film and cut it about 5cm larger than the surface of the part to be coated. Cut several 5 to 6 cm long strips from the roll of tape and stick them a distance apart of about 10cm with half their length off the edge of the water transfer print film. Fold the tape in half and stick it to itself.
TIP: For best results: apply the tape completely over the four sides of the water transfer print film as well as large tape each corner.
(The attachment of the tape strips prevents the water transfer print film from rolling up on itself when it is placed on the water surface!).
IMPORTANT: Before you place the film in the water you must check for the correct orientation of the film. Moisten your fingers and to take the film at a corner between the thumb and index finger.
The side of the water transfer print film, which sticks easily to your finger, will be placed on the water surface.

STEP 4: DIPPING
Fill the container or tub with hot and clean water. The water temperature should be about 30 °C, +/-2 °C. Check the water temperature with a thermometer. Make sure that the container or tub is only slightly larger than the cut-water transfer print film piece, since the film is dissolved by the activator and is spread over the water surface
TIP: If possible orientate the water transfer print film together with a second person, onto the water surface, ensure there are no air bubbles under the film!
The best way to achieve this, is if the film sheet is held at the four edges where the tape are placed and then pulled taught.
One edge of the film is carefully placed on the water surface. Then the rest of the film can be slid slowly onto the water surface.
IMPORTANT: Do not allow water on top of the film. Leave the film for 90 seconds to soak.

STEP 5: ACTIVATOR
Shake the spray activator for 30 seconds. After soaking the film for 90 seconds, spray the activator as a thin layer on the surface of the film.
Spraying the activator liquefies the film. (Don't breathe in spray fumes! Work in a well ventilated area!)
IMPORTANT: Immerse the part to be coated within 20 seconds.

STEP 6: IMMERSION
Take the part to be coated and immerse the part slowly and evenly down the slide into the water. The immersion process should depending on the size and shape of the part, be between 2 and 10 seconds. When immersing ensure you have an angle of about 20° to 40° between water surface and part to be coated.
Next, remove the part out of the container or tub. It does not matter if there are still remnants of the film on the part.
Now leave the coated part for at least 3 minutes alone. During this time the film connects with the part.

STEP 7: RINSING
In order to remove the excess film remnants, wash the coated part for 3-5 minutes under running warm, clean water.
With the latex gloves on, you can gently rub over the coated surface. When the gel-like film remnants are washed away completely, the coated part can then be dried.

STEP 8: SEALING
In order to achieve an extremely durable sealed surface, 1 to 2 layers of clear laquer can be applied at an auto paint shop.
Finished!

POSSIBLE FAULT / REMEDY
After the film has been transferred onto the part, bubbles have formed in some areas.
- When the film was placed on the water, bubbles were trapped under the film.
Due to this at the places of the bubbles the film does not adhere to the part.
The laying of the film on the water should be carried out by 2 persons as described previously.

After the film has been transferred onto the part, very small bubbles have formed.
- It was sprayed too little activator. With a wet latex glove lightly and carefully rub over the bubbles. Defects usually after the spraying of the special sealant are not or hardly visible.
- Another reason may be that the coated part was immersed in a too shallow angle. You must have a larger dipping angle.

When rinsing the part the pattern of the film smudged.
- The coated part is rinsed off too quickly. Leave the part for about 15 minutes and then rinse off with warm water.

The pattern of the film is very rough, crooked and distorted on the coated part.
- The part was not immersed in a steady way. This happens easily with large and heavy parts. Try to be careful when immersing.

There is no pattern of the film in a corner or in a narrow angled or radiused area of the part.
- When dipping the part use a steeper angle to remove all air bubbles.

TIP: If you fail during a coating, you can repeat the process again..

Let the parts dry after washing and carry out the bonding process (black primer) again.After this you can then proceed with the coating.
NOTE: If you want to coat several parts, after each dipping process, the water in the tank or trough must be moved for at least 2 minutes so that the excess activator can evaporate.

The previously sprayed activator is otherwise still on the water surface and would dissolve a "new" film immediately.