



PAS II~III © Pending

SET UP INSTRUCTIONS

- **Select a CDMP (Current Density Monitoring Panel) similar to the alloy of the parts to be anodized**
- **Clean contact area making sure of good contact/conductivity to CDMP**
- **Add Titanium spacers if using Titanium racks/contacts**
- **Clean CDMP panel with solvent or pretreatment chemistries**
- **Mount CDMP panel and tighten-hand tight/snug - don't over tighten**
- **Using a conductivity meter, assure conductivity between PAS II~III spline below black box and CDMP panel**
- **Mount PAS II~III on the same anode bar as work, making sure there is good contact with PAS II~III unit**
- **Add work to the same anode bar/circuit**
- **Make sure operators are clear and not in contact with any part of electrical system**
- **Raise voltage to maximum with amps/current at zero**
- **Slowly ramp amps/current to desired amps on PAS II~III unit**
 - **8-15 amps for type II clear or dyed**
 - **20-35 amps for type III hardcoat**
- **Run for time based on 720 rule and desired oxide build up**
 - **(720 ÷ ASF = # of minutes for 1 mil oxide)**
- **When you have reached your calculated minutes, turn off amps/current**
- **Remove parts and continue process**
- **Remove PAS II~III rinse and remove CDMP panel and strip for reuse**