



114 Trellis Lane  
Ladson, SC 29456

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## INSTRUCTIONS FOR USE

- 1- Make sure battery is fully charged. Initial charge may take 24 hrs. Charging should be done every night after use.
- 2- Attach new or cleaned CDMP panel. Tighten knob no more than hand tight!
- 3- Test to see if there is conductivity between the panel and the hook
- 4- Place in tank on the same circuit as the work load with the DC power supply off.
- 5- Set volts to maximum based on the rectifier in use.
- 6- Slowly raise the amps until the reading on the PAS II~III reads the desired ASF, 1-2 ASF will not cause any noticeable difference in oxide thickness. There may be some fluctuation in the readings, this is normal. Once the slow ramp is over the total AMP draw should be held by the power supply for the cycle regardless of what is showing on the ITU



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- 7- Set time based on the 720 rule for 6000/5000 alloy. For 2000 and 7000 series alloy deduct 5-6 % from the required time. This is a general guide and is not to be considered exact since every operation is different.
- 8- Most anodizing runs do not require more than 35 ASF. The PAS II~III unit can handle up to 50 ASF for short periods of time, it is not designed to run at the higher current densities so remain below the maximum for normal runs
- 9- When the run is complete shut the power supply off. Then remove the ITU. Once removed from the tank remove the CDMP and replace with an unused or cleaned CDMP. Strip the old CDMP before using again.
- 10- Never handle any part of the PAS II~III unit while the rectifier/current is still on.