

NUMMECH PRODUCTS – RAW PARTS & ANODIZING INSTRUCTIONS

Raw aluminum surfaces are very soft and can be easily scratched or dinged. All raw aluminum products are wrapped up to help avoid damage; we suggest you leave them wrapped and in a small zip-press bag before the anodizing takes place.

Raw parts can be sanded and/or buffed if you are inclined to do so. Most raw components come directly off the machine so they may have tool marks leftover from the machining process. If you wish to sand the items, we recommend you start with 300-400 grit sandpaper then increase to a higher grit once the surface is consistent. If you want to give the part a light brushed finish, use a Scotchbrite pad. This is equivalent to approximately 600-700 grit sandpaper.

Use of raw products; warranty restrictions:

Most products will function correctly even when raw, however they will tarnish over time and usually require being sanded every couple months in order to clean the surfaces.

Raw products carry a modified warranty. Improper anodizing procedures can alter the factory size specifications for critical features on the product. In the event you believe an item is defective, the typical limited warranty can be honored if the part is returned to Nummech so it can be inspected. Factory defects are covered under the Nummech warranty, however improper anodizing is NOT covered. In some cases we're able to help repair the issue however there is usually a fee for this.

Disassembly prior to anodizing:

If your product contains any set screws, they must be removed prior to anodizing. Steel components will dissolve when anodized and can damage nearby aluminum, possibly making the part un-useable.

Care must be taken when removing Loctited set screws that are used to seal internal air passages. This is because Loctited set screws are often not meant to be removed, thus they will require a large amount of force to unscrew. You can try heating up a pot of boiling water and dunking the product in to help loosen the Loctite hold.

Loctited set screw installation:

Parts that have internal air ports need to have the appropriate set screw Loctited in position. The required screw is packaged with raw products when you purchase it, but you will need to supply your own Loctite. We recommend Loctite 271 for small set screws.

1. Be sure the screw is clean and dry. If the screw has oil on it, the Loctite coat may not adhere properly.
2. Shake the Loctite container prior to use.
3. Place one drop of Loctite into the threaded hole, and another drop on the outside of the screw itself. Insert the screw so it will be flush with the outside of the part.
4. Clean off any excess Loctite from the outside of the part then set it aside to cure. Loctite will require several hours to fully cure before the part can be used; the cure time varies depending on the Loctite grade. We recommend you give the part at least 24 hours to cure, 48 hours if possible.
5. Once the Loctite has cured, you're ready to install the component and test the part to hold pressure. If the part leaks from the hole, remove the screw and try again. It's likely a contaminate is preventing the Loctite from adhering to it.

