

# Generation 4 User Guide & Technical Data Sheet

**What is XAR?** XAR stands for eXtreme Air Release, and is our version of the latest in air release protocol technology in epoxy based casting resins. The first thing you will notice about GEN4 guide wrap finishes is that compared to other finishes it offers greater resistance to the entrapment of bubbles due to improper mixing. Second, air that is introduced into the mixture during the blending process is released in a much more effective and efficient manner during application. Additionally, we have extended the pot life of GEN4 by about 12 minutes to allow more time for air displaced in the threads to release on its own. Of course the XAR air release chemistry is limited by the amount of time the mixed resin stays viscous enough for bubbles to move to the surface. To that end, best practices in blending the resin and catalyst (read; slow and deliberate) must be exercised in order to keep the amount of trapped air to a minimum to begin with.

**What is TruBlu Measure/Mix:** TruBlu Measure & Mix is an additive we put in the resin (part A) side of the formula to help differentiate between the resin and catalyst. Several of my former OEMs noted that the two sides were so clear that it would be easy for one to accidentally mix two parts resin or two parts hardener instead of one of each. To alleviate any confusion, we have added a "disappearing" blue dye to visually differentiate between the two components. Additionally it functions as a visual indicator as to when the mixture is properly blended. If the blue hasn't completely disappeared, the mixing process is not complete.

## **GEN4 Working Properties**

Mix Ratio: 1:1

Pot-life: 30 min at 70 degrees Fahrenheit

Re-Coat Time: Minimum re-coat time is 4 hours at 70 degrees Fahrenheit. Maximum re-coat time is 24 hours at 70 degrees Fahrenheit

Sag free (rotation time): 3 hours at 70 degrees Fahrenheit

Tack free time: 10 hours at 70 degrees Fahrenheit

Fishable after 24 hours, but we recommend 48 hours to allow for full crosslinking

**Instructions:** Measure with provided syringes a minimum of 3cc of each component. Mix SLOWLY AND DELIBERATELY for a minimum of 3 minutes. If any cloudiness or hint of blue dye remains, continue blending until mixture is water clear. Pour out on a flat surface to allow the XAR protocol to release any remaining bubbles. Apply with brush or spatula until desired film thickness is achieved. Rotate for a minimum of 3 hours, CONTINUALLY CHECKING for bubbles, as XAR will continue to push bubbles to the surface even when the mixture begins to thicken. To ensure that no bubbles become trapped in the changing surface tension, you will need to check the rod every few minutes to monitor and eliminate any air that may not release on its own due to the thickening viscosity. XAR is only effective through a specific viscosity. As the mixture continues to crosslink, the thickening viscosity will be the only barrier that does not allow for the bubbles to continue to release