



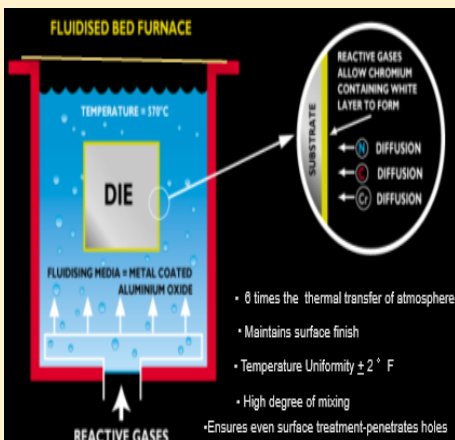
DYNA-BRITE™ A DYNA-BLUE® Process for Lens/Lighting molds.



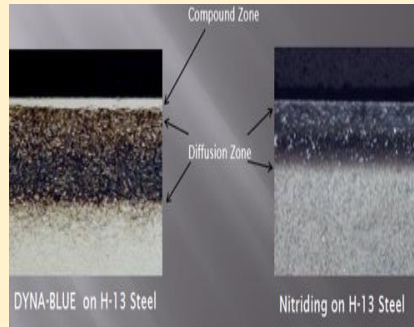
DYNA-BRITE™ is a proprietary process to minimize or eliminate polishing time after DYNA-BLUE on Lens/Lighting Molds and Class "A" Finishes. DYNA-BRITE™ is a DynaBlue process with a nitrogen cooling cycle to reduce the oxide layer. For Lens/Lighting Molds a glossy, mirror-like surface is highly recommended* (A-1).



Comparing the results of DYNA-BRITE™, a DYNA-BLUE® low temperature thermal chemical diffusion process [ferritic carbonitriding], to other surface treatments: DYNA-BLUE®, is a fluidized bed process, not a line of sight process like Chrome/Nickel Plating and Ion/Gas Nitriding. Chrome plating and ion nitriding are limited to areas accessible by an anode increasing cost.



Wear tests have shown that the DYNA-BRITE™ process resists wear and corrosion better than Ion/Gas Nitride, Chrome, Nickel and other coatings due to the hard wear resistant compound layer (75+ HRC) which is supported by a nitrogen rich diffusion layer (65 HRC).



DYNA-BRITE™, a DYNA-BLUE® Process Protects against Corrosion:

Water leaks contacting 'untreated surfaces' seeping through micro cracks

Condensation in the mold (perhaps due to chillers running too cold)

Pillage from ill-fitting O-rings and pipe fittings or from hoses during hook up

Resins and Additives can become corrosive due to overheating.

Inadequate venting also causes accelerate corrosion by causing trapped gases to score tooling components

Corrosion from abrasive fillers and unreacted polymers that release acids- DYNA-BLUE is resistant to acids, salt water.

*Lense molds may need additiional buffing after DYNA-BRITE™.

KNOW YOUR MOLD FINISHES:

A-1 Grade #1: Diamond Buff. The finest diamond finish mostly used for clear lenses and lighting molds.

B-1 600 Grit Paper: The highest finish before diamond process.

C-1 600 Stone Finish: Fine smooth finish where a paper finish is not feasible.

"Keep in mind that paper finishes are not equivalent to their stone counterparts. Ex:

B 320 is approximately equal to C 600 stone."

The Benefits of DYNA-BRITE™, a DYNA-BLUE® Process:

1. Surface Hardness: 75+ HRC Compound Layer with a Nitrogen Rich Supporting Zone 65 HRC – No brittleness
2. Depth of Hardness - .0001"-.002" Compound Layer with a Nitrogen rich" supporting zone .005"-015".
3. Low dimensional variation, less than .0002"/side growth due to low temperature process.
4. Corrosion Resistance
5. No Flaking since the process is a diffusion process and not a coating – with uniform application on all complex geometries.
6. No build up on edges like Chrome/Nickel Plating.
7. Enhanced die repair and weldability. Can be welded without pin porosity as experienced with Nitriding.
8. Capacity 75"x120" –up to 30,000 lbs.