



**Luxon**  
Distinctive Color Design ■■

## Print Design

Step by step to success

### Equipment:

- LED light curing (TwinLux Dual)
- HeatingPlate 2.0 or PreHeater 1.0

### Consumables:

- Luxon Clear, can 50gr or 20gr
- Printfoil (polypropylene, self-adhesive)
- Bond II, syringe 3gr, bottle 40gr
- Polishing paste (f.e. Merard products)
- High grade corundum 110µm

**NOTE:** Always wear gloves and keep your workplace clean

Step by step to success:

1. Choose a high-resolution graphic or photo for your design. (for example, from Shutterstock)
2. Print your design on the printfoil with a laser printer
3. Cut out the exact size (for example, with a CO<sup>2</sup> laser machine)
4. Prepare matching inlays into the metal blank (ideal inlay depth 0,8mm),  
Tip: Undercuts in the metal prevents visible outer edges of the foil
5. Sandblast the sidewalls with high grade corundum 110µm.  
We recommend SANDURET 2 sandblaster from Reitel  
<http://www.reitel.com/en/products/sandblasting>
6. Clean jewelry blanks very precisely. (Ultrasonic cleaning, distilled water and alcohol).
7. We recommend SONIRET from Reitel  
<http://www.reitel.com/en/products/ultrasonic-cleaning>
8. Peel off the protective film from the printfoil and apply carefully into the base of the inlay and press firmly. Especially at corners and edges
9. Wet corners and edges with Bond II and cure with LED light (TwinLux Dual) for at least 60 seconds per segment
10. Warm up Luxon Clear material with the Invicon HeatingPlate 2.0 or PreHeater 1.0 to approx. 60°C. As a result, Luxon flows smoothly and runs well into edges and angles. In addition, air bubbles can be avoided.
11. Tip: The jewelry piece may also be preheated on the HeatingPlate 2.0 or on the PreHeater 1.0 for an even better flow of the material.

12. Carefully apply Luxon Clear into the Inlay.  
Please note to apply Luxon Clear in layers followed by lightcuring in between. This avoids a run off the Luxon Clear material along the sides.  
Important! Make sure to overfill the inlays.
13. Always pay attention to air bubbles and if necessary flame over with a torch prior lightcuring to burst them
14. Cure well with LED light (TwinLux Dual) (recommended: approx. 5-10 minutes) until the „yellow tinge,, of Luxon Clear has completely disappeared.  
  
**Large-format light curing unit CeraLux: available from April 2018**
15. Turn off excess with turning lathe or mill by CNC machine.  
Alternatively, manually remove the surplus with sandpaper. (from grain size 1000 over 1500 to 2000)  
We recommend sanding cloths from Sia Karat  
<https://www.siaabrasives.com/ch/de/siaabrasives-ocs/coatings.../7240-siacarat-14383>
16. Polish the surface as usual by appropriate polishing compounds.  
We recommend polishing compounds EXTREME S10/S20/S30 from Merard  
<https://www.merard.com>  
  
We recommend two-spindle polishing units from Reitel POLIRET TWIN  
<http://www.reitel.com/en/products/polishing>
17. If desired, realize the final metal color by appropriate electroplating.
18. Finished.

#### **General note**

All devices from Reitel and polishing compounds from Merard are available from Invicon or from your Invicon dealer company.