

HOW TO ENGRAVE METAL BADGES

1. **Mount** - Secure metal badge in fixture. Apply a piece of Scotch Tape over the metal badge without removing the paper mask that comes on the product. The Scotch Tape will keep the paper mask from balling up as you work and aid in removing the paper after engraving. An oversize nose cone may replace the need for Scotch Tape.
2. **Adjust Depth** - In order to easily paint fill, you will need to engrave your badges to a depth of .012. This may or may not be accomplished in one pass, depending on whether you are engraving leaded brass, 70/30 brass or nickel silver. If the letters seem rough when you run your finger across the surface of the badge, a second pass is needed. Simply lower your cutter .001 and run again.
3. **Dust Off** - If you have an air hose, blow off the badges prior to removing the mask, and again after you remove the masking. This will help eliminate any scratches to the badge surface. Next, fill the letters with an enamel paint such as Testor. You don't have to be neat, just make sure the letters are completely filled.
4. **Remove Excess** - Take a squeegee and remove the excess paint and set the badges aside to dry. If possible, allow product to dry overnight, this will make cleaning easier without removing any paint from inside the lettering.
5. **Finishing Up** - Put odorless mineral spirits on a lint-free paper towel and lay it on a flat surface. Simply buff the badge, face down, across the paper towel until the remaining paint on the badge has been removed. You can polish any residue from the mineral spirits with a clean lint-free paper towel.

