



## **PAINTING ONE SYSTEMS® INJECTION MOLDED LOUDSPEAKER ENCLOSURES**

One Systems® injection molded enclosures can be painted for custom color requirements. The One Systems factory can match customer colors for specifications and orders of 50 more of a type of speaker system, with at least a 90-day advance notice from the date of an order. If a contractor or venue chooses to modify the standard black or white colors of most One Systems speaker cabinets, this can be done by the venue/dealer/distributor, however, please note that the manufacturer's warranty on finish will not be covered any longer. Only the acoustical performance warranties would still apply.

One Systems enclosures are manufactured using a modified polypropylene material that requires some special "attention" prior to painting. Certain paint manufacturers offer specially formulated paint systems that are designed for use with polypropylene.

Regardless of the specific paint selected, it is important that the surface be very clean and free of dirt, debris and other foreign materials. The manufacturer's directions should be followed exactly. It is also recommended that a face mask be worn during the painting process. Use only the cleaning agent recommended by each paint manufacturer.

Prior to painting, take care to remove the grille set and stainless-steel screws/washers. Make sure that any components not removed in advance of painting are carefully covered with tape to ensure that only the injection molded cabinet is painted.

Below are two products that One Systems has tested and recommends for use with its injection molded speaker products. Please follow this sequence when customizing your own color for the polypropylene enclosure.

### **1. Rust-Oleum® (Specialty Series) PLASTIC PRIMER**

This material from Rust-Oleum is a base primer and is available only in a white color. It is available in most North American hardware "super stores". The surface must be well cleaned prior to use and the manufacturer's instructions should be followed.

After the plastic primer has dried (following the instructions on the can), a top coat of any outdoor rated oil based enamel paint may be applied.

It is also important to ensure that the primer coat be applied in a thin layer. Do not apply too thick of a base coat, as the primer will run and produce an uneven finish. Thin coats of primer and paint also provide faster curing.

**Note:** *The top coat should only be applied after a minimum of one (1) hour drying time!*

## 2. Krylon® FUSION for Plastic

FUSION paint from Krylon is available in most hardware stores. The material is designed for good adhesion to many plastic substrates and works well on One Systems injection molded series speaker enclosures. The paint is available in 32 colors. Krylon does **not** recommend that any top coat be sprayed over FUSION paint, unless it is another coat of FUSION paint.

### **Preparation for Painting One Systems Stainless Steel Speaker Grilles**

One Systems three-layer grilles from IM and CIM models consist of 304-grade stainless steel with paint over the grilles. From mid-2015 to the present, One Systems 304-grade grilles on its HTH, HTC, and HSB models are covered with a new, marine capable polyester coating. Painting over these newest generation grilles with conventional paint can only be done if the speakers are installed at least 10 miles (16 KM) inland from salt water.

In order to remove the inner 2<sup>nd</sup> and 3<sup>rd</sup> layers of the 3-layer grille design, an installer or technician must carefully remove the plastic tabs that hold the two-part inner grille assembly together. Use a thin, flat knife or scraping tool to remove the glue used in the original production and assembly, then thoroughly clean the remaining glue and residue from the stainless-steel grille part.

### **Paint the Stainless-Steel Grille**

Use only paint approved for application to stainless steel with evenly sprayed coats as needed for a uniform look. If the One Systems speakers are installed within 10 miles/16 kilometers of salt water bodies of water, a polyester based paint must be applied over the stainless-steel grille! Painting of the grille set by any aftermarket source will void the manufacturer's warranty against corrosion within five years of purchase.

### **Grille Set Re-Assembly**

Re-assembly of the 3-layer grille should be in the following steps:

The installer should apply Super 77 glue onto the edge of the two-part inner grille set (the outer perimeter of the rectangular Saati cloth section) to the grille. Then use the original black plastic clips to ensure that the reticulated foam stays attached to everything inside of the grille set.

**Note:** In the original manufacturing process, our factory uses a bead of glue around the edge of the foam of the inner grille layers to keep everything in place.

One Systems can supply replacement grille sets if installers damage grille sets during this process, but the cost of replacement grille sets are the responsibility of the venue, the dealer, or the distributor that provided the aftermarket paint service.

For additional information, please contact One Systems, Inc. by calling +1.615.823.1655, then dialing #1, or write to [orders@onesystems.com](mailto:orders@onesystems.com).