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Preparation of substrate is crucial for maximum adhesion and performance of this material

- 1) Completely disassemble the item to be coated. If pins or parts are left in, they can produce runs and ruin the finish. Due to the thin finish produced by Cerakote®, everything except the inside of the barrel can be coated.
 - 2) Remove all coatings, oils, and contaminants from substrate with either a de-greasing chemical and/or by heating substrate to temperatures high enough to remove coatings or contaminants (do not exceed 300 °F).
 - 3) A blasted profile must be applied to the substrate to remove any rust, scale, or other coatings. This is required to ensure maximum adhesion. Remove any sharp edges or welding slag that may create thin areas or protrude through coating. For best results use a dry grit material such as aluminum oxide or garnet equivalent to an **100 - 120** mesh size. Glass beads are not recommended as they are not aggressive enough to produce a sufficient blast profile. Blasting with finer than recommended media may result in poor adhesion. Profile plastic, anodized and wood parts lightly (~ 40 psi). **Only Cerakote® approved solvents may be applied to the substrate after completing the blast profile.**
 - 4) Hang parts to allow for best view and application access. This can be done by using support wires and hooks. Make sure to place parts in such a way that they will not bump into each other. **Do not touch parts with bare skin.** Use **powder free** latex style gloves to handle parts. Alligator clips, magnets or 30-gauge wire are recommended for small parts such as screws and springs.
 - 5) Make sure the **H-Series** products are completely mixed and no solids remain in the bottom of the container. Mix **12:1**, 12 milliliters of the H Series product with 1 milliliter of the catalyst (**do not** mix any ratio other than **12:1**). Failure to completely disperse the product will result in poor chemical ratios and product failure. **Note:** Ensure product is adequately mixed immediately prior to spray. Pot life after mixing together the two components is 2 hours in an open container, 6 hours in a closed container. Due to limited pot life, do not mix more than you intend to use. **Only Cerakote® approved solvents may be used in the Cerakote® products.**
 - 6) Blow off substrate with a high-pressure air nozzle to remove any blasting dust left on the surface. Wear safety goggles or face shield for your protection. Work in a well-ventilated area. If ventilation is not available, wear a respirator – see SDS for additional information.
 - 7) Recommended spray equipment is a siphon-fed detail gun with a fine to medium tip. The use of a small spray tip pattern will aid in coating hard to reach areas without excessive build up in surrounding areas. **Material is ready to spray and does not need to be thinned. Use as received.**
 - 8) A single application of product is recommended for a final film thickness of 1.0 to 2.0 mil (1 mil = 0.001 inches). Work from the most difficult surface out to the easiest. This will aid in reducing runs or excessive build up.
 - 9) Allow to air-dry for 5-10 minutes (coating is still wet to the touch at this point – do not touch or bump parts). Carefully move each part into the oven and cure at 250°F for 2 hours. Alternatively, the parts can be cured 300°F for 1 hour. If the substrate material is heat-sensitive (such as plastic, anodized or wood) then a cure for 2 hours at 150 °F – 180 °F is adequate. Please refer to the individual tech data sheets available at www.cerakoteguncoatings.com/resource/downloads for product specific cure temperatures.
 - 10) After the cure process is complete, the finished goods may be shipped once they have cooled to the touch.
 - 11) Discard any unused product from the spray gun when finished – **do not pour any product that has been mixed together with the catalyst back into the bottle. This will render the remaining product unusable.**
 - 12) Clean tools and equipment with acetone or a Cerakote® cleaning solvent.
- Please contact a Cerakote® technician with questions on proper use and/or application. Onsite or offsite training courses are available for further instruction. Consult your SDS for proper handling, disposal, and precautions while using this product.*