CERAKOTE

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SPLINTER CAMO APPLICATION GUIDE

SPLINTER CAMO APPLICATION VIDEO

SPLINTER CAMOUFLAGE VINYL STENCIL PATTERN



SPLINTER CAMOUFLAGE

The Cerakote Training Department has developed the Splinter Camouflage pattern with our customers in mind. It was created to ensure that you, our customer, will have an excellent camouflage pattern with supported application documentation. Our easy-to-follow, step-by-step instructions, as well as informative videos, will guide you through the entire process. This pattern can be applied to firearms, knives, bicycles, cups, golf clubs, or anything you

can Cerakote that your customer may want to showcase.

Trainers have developed, tested, and specified every inch of this pattern. Once approved by training, the pattern is vectorized and digitally developed for easy plotting on our Cerakote 15" vinyl cutter.

Be sure to upload your projects in our Gallery!

Technical Support Questions? Contact us at:

TechnicalSupport@cerakote.com Phone: 1-866-774-7628

CERAKOTE USED

Make sure you have everything you need to start your project. After you have all the tools, files, and equipment, prepare your parts in accordance with the Cerakote Training Manual: H-Series and Elite Series available at Cerakote.com.

Feel free to reach out to our Cerakote Technical Support at TechnicalSupport@Cerakote.com if you have any questions about the application process, patterns, or getting help with Splinter Camo.







EQUIPMENT USED

For the Splinter Camouflage application, the following tools were used: High Tack Vinyl, Splinter Camouflage Vinyl Stencil, Anti-Static Tweezers and Plastic Razor Blades.



SPLINTER CAMO STENCIL

Download the Splinter Camouflage Vinyl Pack.

SPLINTER CAMOUFLAGE VINYL STENCIL



ANTI-STATIC TWEEZER

SE-366 Great for peeling, weeding, picking or laying high bake vinyl.



PLASTIC RAZOR BLADES

SE-367 Double edged blades soft enough to preserve your coated project, but firm enough to remove stencils or score edges.

STEP 1

Base Coat, H-340 Multicam Light Green





• Mix **H-340 Graphite Black** at the standard 18:1 mixing ratio.

PRO TIP: IWATA LPH80 baseline settings for *achieving a 2-3" oval fan pattern*.

- Pattern Adjustment Knob 1 Turn Counterclockwise (from a closed position)
- Fluid Adjustment Knob 2 Turns Counterclockwise (from a closed position)
- Air Pressure 25 PSI (set at the air regulator)
- Adjust your spray gun settings to achieve a 2-3" wide oval fan pattern
 (Image A) while spraying from a distance of 3-5 inches. Adjust the spray gun
 to a narrower fan pattern with moderate-sized splatter to coat hard-to-reach
 areas.
- Apply a base coat (Image B) to the item with a dry film thickness of 1 mil.
- **Ambiently flash** for 15 minutes. Before moving on to the next step, visually inspect the coating to ensure the solvents have completely flashed off. The coating should appear dry once complete.
- **Flash Cure** at 150-180°F (65-82°C) for 10 to 30 minutes, or just to the point of tack-free (dry to the touch). Allow the items to cool to room temperature before moving to the next step.

STEP 2

Splinter Camouflage Vinyl Stencil Pattern, H-264 Mil Spec Green





PRO TIP: IWATA LPH80 baseline settings for achieving a 1" oval fan pattern with moderate splatter.

- Pattern Adjustment Knob 1 Turn Counterclockwise (from a closed position)
- Fluid Adjustment Knob 1/2 Turn Counterclockwise (from a closed position)
- Air Pressure Adjust PSI until a 1" oval is achieved.

- **Apply the Splinter Camouflage Vinyl Stencil Pattern.** Cover approximately 33% or 1/3 of the H-340 Multicam Light Green with the stencil. Lay the vinyl shapes in a random orientation, evenly spaced across the part. (*Image C*)
- Inspect all edges of the vinyl to ensure the edges are pressed down firmly. This will help eliminate any possible blowouts in the pattern.
- Mix **H-264 Mil Spec Green** at the standard 18:1 mixing ratio.
- Adjust your spray gun settings to achieve a 1" oval fan pattern (*Image D*) with moderate splatter.

(NOTE: These will be your spray gun settings for all remaining coats).

- Apply a light coat of **H-264 Mil Spec Green** to the open areas (*Image E*). Apply just enough Cerakote for coverage with little to no transparency.
- Ambiently flash for 15 minutes. Before moving on to the next step, visually
 inspect the coating to ensure the solvents have completely flashed off. The
 coating should appear dry once complete.



• Flash Cure at 150-180°F (65-82°C) for 10 to 30 minutes, or just to the point of tack-free (dry to the touch). Allow the items to cool to room temperature before moving to the next step.

DO NOT REMOVE THE VINYL STENCILS!

STEP 3

Splinter Camouflage Vinyl Stencil Pattern, H-343 Multicam Light Bright Green







- Apply the Splinter Camouflage Vinyl Stencil Pattern. Cover approximately 33% or 1/3 of the surface area (*Image H*). Lay the vinyl shapes in a random orientation evenly spread out across the part.
- Inspect all edges of the vinyl to ensure the edges are pressed down firmly. This will help eliminate any possible blowouts in the pattern.
- Mix H-343 Multicam Light Bright Green at the standard 18:1 mixing ratio.
- Adjust your spray gun settings to achieve a 1" oval fan pattern with moderate splatter (previous spray gun settings).
- Apply a light coat of H-343 Multicam Light Bright Gree to the open areas (Image G). Apply just enough Cerakote for coverage with little to no transparency.
- Ambiently flash for 15 minutes. Before moving on to the next step, visually inspect the coating to ensure the solvents have completely flashed off. The coating should appear dry once complete.
- Flash Cure at 150-180°F (65-82°C) for 10 to 30 minutes, or just to the point of tack-free (dry to the touch). Allow the items to cool to room temperature before moving to the next step.
- Carefully remove the vinyl stencils. It is best to remove the vinyl with a plastic razor blade to avoid damaging the Flash-Cured Cerakote (*Image J*).

Fully cure the part in accordance with the H-Series & Cerakote Elite Series Training Manual.





ALTERNATIVECOLOR PALATES





* * FINISH * * CERAKOTE

* * STRONG * *