

H-SERIES GLOSS GUIDE

A GUIDE TO STANDARD & CUSTOM GLOSS LEVELS

Cerakote gives you the flexibility to customize your gloss levels across multiple substrates. This guide will assist you in achieving the gloss level that meets your requirements.

STANDARD GLOSS PROCEDURE

CATALYST MIXING RATIO:

18:1 (coatings: catalyst) by weight.
Mixing by volume is optional.

AMBIENT FLASH:

Best practice, set aside coated parts for a minimum of 15 minutes, but no more than 2 hours, before oven cure.

RECOMMENDED CURE SCHEDULE

SINGLE SUBSTRATE:

Coating a project with metal only, polymer or plastics only, etc.

Fully cure all parts according to cure schedule (see Figure A)

MULTIPLE SUBSTRATES:

Coating a project with metal and polymer or plastic pieces, etc.

Flash cure all parts at 150°F to 180°F until tack-free (10 to 25 minutes) to lock in gloss on all substrates (See Figure B and C)

Separate all parts according to substrate cure schedule and complete final cure (see Figure A)

NOTE:

Some Cerakote coatings require specific cure schedules. Always review the product specific Technical Data Sheet (TDS) prior to curing.

WHY DIFFERENT CURE TEMPERATURES?

Many items, for example firearms, are built from multiple substrates such as polymers and metals. Substrates, like plastic/polymers, have lower temperature stability, and therefore require lower cure temperatures. Always review the product specific Technical Data Sheet (TDS) prior to curing.

IMPORTANT: If you are unsure as to the temperature stability of your parts, contact the manufacturer prior to oven cure.

MATERIAL	TEMPERATURE	TIME
Metal H-Series (Standard)	250° F or 121° C	2 Hours
Metal Elite Series (Standard)	300° F or 148° C	1 Hour
Flash Cure (Stencils)/H-Series & Elite Series	150° - 180° F or 65° - 82° C	10 - 25 Minutes
Plastic or Polymer	150° - 180° F or 65° - 82° C	2 Hours
Wood	150° F or 65° C	2 Hours
Composites i.e. Carbon Fiber or Fiberglass	150° F or 65° C	2 Hours

FIGURE A

NOTE: Gloss units and levels are measured at a 60° angle, 18:1 Catalyst ratio, 1-2 mil dry film thickness, 15 minutes ambient flash after application, 250°F cure for 2 hours. Adjustments to these conditions will yield different results. Gloss is affected by spray technique and quality of preparation and finish.

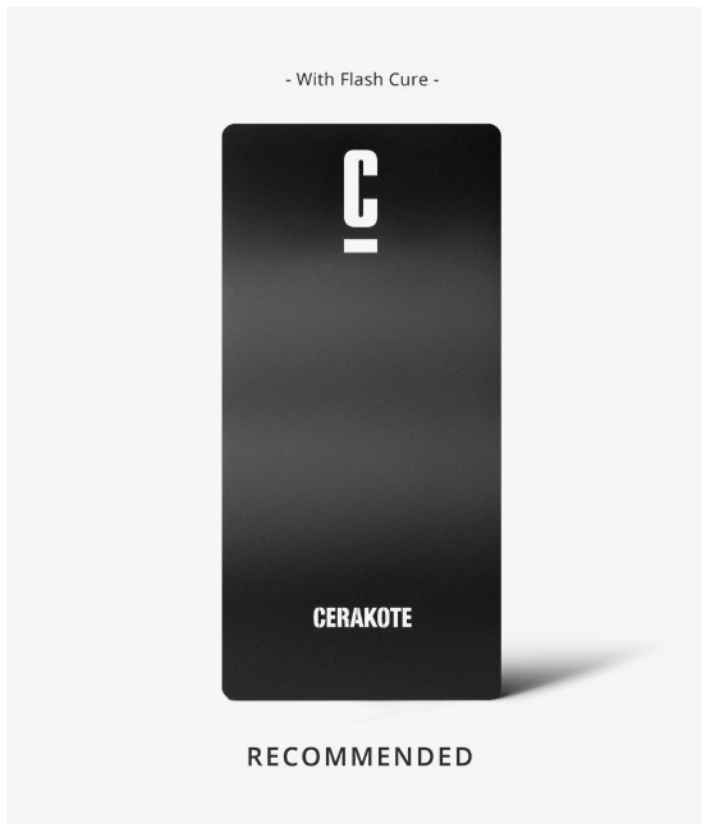


FIGURE B

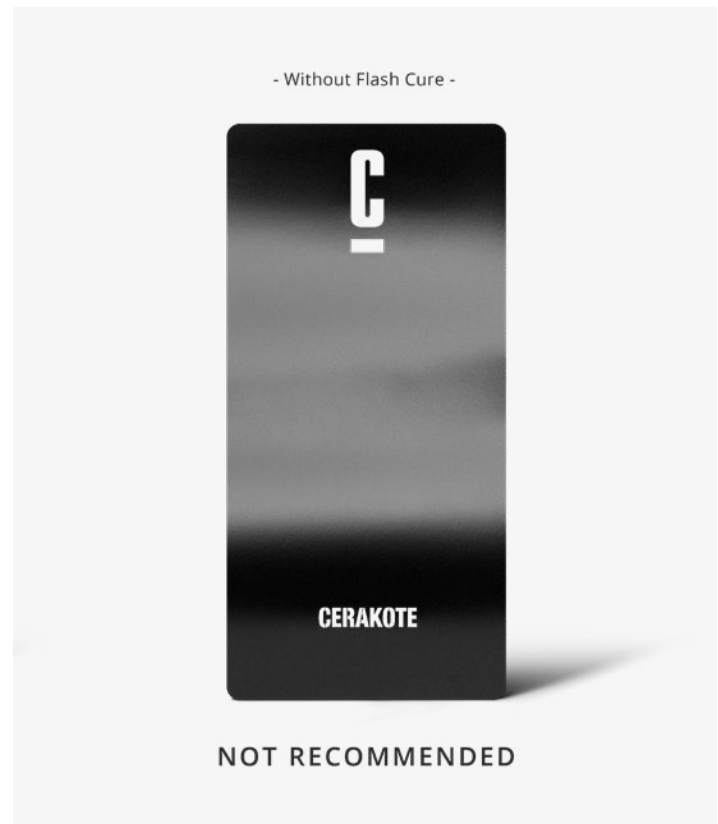
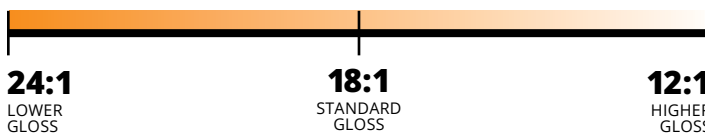


FIGURE C

CATALYST MIXING RATIO:

Adjust your Catalyst mixing ratio to achieve your desired gloss level.



CURE TEMPERATURE:

Increasing or decreasing cure temperature will raise or lower gloss level.

