

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.
- 2.) Prepare surface to remove oil, contaminants or any unwanted coatings from the substrate.
- 3.) For polished metals that must retain a specific appearance, an organic solvent such as tert-Butyl acetate should be used to clean the surface. Acetone, Alcohols, MEK and other organic solvents that carry moisture should be avoided.
- 4.) Hang parts to allow for best view and application access. This can be done by using support wires or 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.
- 5.) Blow off substrate with a high-pressure air nozzle to remove any dust left on the surface. Work in a well-ventilated area and wear a respirator - see MSDS for safety and handling information.
- 6.) Coating is ready to spray and should not be thinned. Gently shake container and pour through a **325** mesh filter into a high quality HVLP detail spray gun with a .8mm tip, such as an IWATA LPH -80 (NIC Part# SE-138) or a siphon-fed detail spray 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. Electrostatic application may also be an option.
- 7.) A single wet coat is recommended for a 0.5 to 1.0 mil dry film thickness. Work from the most difficult surface out to the easiest. This will aid in reducing runs or excessive build up.
- 8.) Allow to air-dry. Parts will be tack free after approximately 35 to 45 minutes. Until this point the coating is still wet and should not be touched. Parts will be partially cured after 24 hours and fully cured 5 days after application.
- 9.) Finished goods may be handled, packaged and shipped after 24 hours when the coating is partially cured.
- 10.) Clean tools and equipment with tert-Butyl acetate or acetone.

Please contact a Cerakote™ Technical Advisor with questions on proper use and/or application. Onsite or offsite training courses are available for further instruction. Consult your MSDS for proper handling, disposal, and precautions while using this product.

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All information provided is believed to be correct, to the best of our knowledge and testing. We recommend that you make adequate tests in your laboratory or plant to determine if this product meets your requirements.