

## C-SERIES AMBIENT CURE CERAMIC COATINGS

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

- 1) Remove all coatings, oils, and contaminants from substrate with either an approved degreasing chemical and/or by heating substrate to temperatures high enough to remove coatings or contaminants.
- 2) We recommend, but do not require, that the metal parts are placed in an oven at 300°F for approximately 30 minutes to evaporate any last minute moisture, oils or contaminants.
- 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 that may create thin areas or protrude through the coating. For best results, use a dry grit material such as aluminum oxide or garnet equivalent to a 100 - 120 mesh size. Glass beads are not recommended as they are not aggressive enough to produce a sufficient blast profile. Profile plastic 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 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) Shake the **C-Series** product until the coating is **completely** mixed and no solids remain at the bottom of the container. Failure to completely disperse the product will result in poor chemical ratios and product failure.
- 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 high quality HVLP spray gun with a 0.8 mm tip, such as an IWATA LPH-80 (Cerakote Part #SE-138). The use of a small spray tip pattern will aid in coating hard to reach areas without excessive build up in surrounding areas. Use a 100 mesh filter inside the gun cup. Electrostatic application may also be an option. **Material does not need to be thinned. Use as received.**
- 8) A single application of product is recommended for a 1.0 - 2.0 mil film thickness. 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. Parts will be tack free after approximately 45 - 60 minutes. Until this point the coating is still wet, so take care to not bump or touch the parts. Parts will be partially cured after 24 hours and fully cured 5 days after application.
- 10) Finished goods may be shipped after 24 hours when the coating is partially cured.
- 11) Clean tools and equipment with acetone or **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, cautions while using this product.***

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The information contained in this bulletin we believe to be correct to the best of our knowledge and testing. The recommendations and suggestions herein are made without guarantee or representation as to results. We recommend that you make adequate tests in your laboratory or plant to determine if this product meets all your requirements.