



## APPLICATION GUIDE

### MC-5100 CERAKOTE® CLEAR - ALUMINUM

**\*Preparation of aluminum surface is critical for maximum adhesion and performance of this product.**

**\*For best results, product should be applied immediately after surface preparation. Review the Safety Data Sheet (SDS) prior to using this product. Product should only be used in a well-ventilated area, using proper personal protective equipment (PPE).**

**\*This product is not intended to be applied over any other Cerakote products.**

1. Prepare aluminum surface by removing oil and other contaminants by thoroughly cleaning with Blue Dawn® dish soap and HOT water, using a non-abrasive microfiber type cloth to avoid scratching the aluminum surface. High polished aluminum scratches easily and should be hand washed with great care.
2. Dry surface using clean compressed air, ensuring no water spots are left behind.
3. MC-5100 Cerakote Clear - Aluminum is ready to spray and should not be thinned. Gently shake container and pour through a 325 mesh filter (Cerakote Part #SE-277) into a high quality HVLP spray gun with a 0.8 mm tip, such as an IWATA LPH-80 (Cerakote Part #SE-138). Set air pressure at 30 PSI.
4. A single wet coat is recommended for a 0.50 to 0.75 mil dry film thickness. For best results, work from the most difficult area to the easiest. Use of a mil gauge can aid in insuring proper coating thickness (Cerakote Mil Gauge Part #SE-321). If you encounter any surface defects during application, rinse immediately with acetone.
5. Allow parts to air dry. Parts will be tack free after approximately 15 to 30 minutes. Until this point the coating is still wet and should not be touched. Parts will be fully cured within 24 hours.
6. Clean equipment with acetone.

*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.

**INNOVATIONS OF NIC INDUSTRIES, INC.**  
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