



APPLICATION GUIDE

P-202 ARCTIC BLACK

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

1. All oils and contaminants must be removed from substrate with either a degreasing chemical and or by heating substrate to temperatures high enough to result in contaminate removal.
2. A blasted profile must be applied to the substrate to remove any rust, scale, or other coatings. This is required to ensure maximum adhesion. A dry grit material such as aluminum oxide or garnet equivalent to a 100 - 120 mesh size is recommended for best results.
3. Place parts in an oven at 300°F for approximately 30 min to evaporate any last-minute moisture, oils, or contaminants that blasting or contact with skin has deposited on surface. Do not apply any solvents to substrate after a blast profile has been applied.
4. Make sure that P-202 Arctic Black is completely mixed and there are no solids in the bottom of the container. Failure to completely disperse the product will result in poor chemical ratios and product failure.
5. Hang parts to allow the applicator to easily view and rotate for application. Do not touch parts with bare skin. Remove any sharp edges or welding slag that may create thin areas or protrude through coating.
6. 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). Use a 325 mesh filter in the gun cup. The use of a small spray tip pattern will aid in coating hard to reach areas without excessive build up in surrounding areas. Material does not need to be thinned. Use as received.
7. Two light applications of product is recommended for a 0.25 to 0.50 mil film thickness. In some cases, a single coat will suffice for a particular application. Work from the most difficult surface out to the easiest.
8. Parts will cure in a 300°F oven for 1 hour.
9. Clean up with acetone or xylene.

*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.

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