

### MC-2200 MULTIPURPOSE CLEAR

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

#### Spray Application

1. Completely disassemble the item to be coated. If you are working with a mechanical part and are unfamiliar with the level of disassembly, have a trained professional perform the disassembly and reassembly.
2. Degrease parts to remove any oils or contaminants from the substrate with a degreasing chemical such as Acetone or Isopropyl Alcohol (IPA). Flush the surface of the parts and wipe with a clean lint-free towel or microfiber rag. Repeat this process until no residue is observed on the rag. Avoid touching parts at this point as this can leave surface defects in the finish.
3. Fixture parts to allow for the 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.
4. Gently shake the container and strain through a 325-mesh filter into a high-quality HVLP/LVLP detail spray gun with a 0.8 mm tip, such as an IWATA LPH-80 (NIC Part #SE-138).
5. Blow off the substrate with a high-pressure air nozzle to remove any dust left on the surface. Work in a well-ventilated area and always wear proper Personal Protective Equipment (PPE) when applying Cerakote products (e.g., gloves, safety goggles, and respirator.) See the Safety Data Sheet (SDS) for additional information.
6. For best application results, set spray gun pressure to 30 PSI and apply 2 – 3 light coats of product to achieve a recommended film thickness of 0.15 – 0.25 mil (0.00015" – 0.00025") dry film thickness. Work from the most difficult surface out to the easiest. The use of a small spray pattern will aid in coating hard-to-reach spots without excessive build-up in surrounding areas. Refer to the Technical Data Sheet (TDS) for coating composition specifics.
7. Allow coated parts to air dry, parts will be tack-free approximately 15 to 30 minutes following the application. Until this point, the coating is still wet and should not be touched. Coatings will be fully cured after 24 hours. Do not package parts airtight if shipped prior to the 24-hour full cure.
8. Clean tools and equipment with acetone or a similar degreasing chemical.

#### Wipe-On Application

1. Prepare the parts by following steps 1 – 5 in the **Spray Application** process.
2. Using a lint-free microfiber cloth, apply enough coating to evenly wet the cloth while avoiding oversaturation. For ease of application fold the cloth in quarters and apply more coating as needed during the application process.
3. Wipe the coating onto the intended surface and strive for a 50% overlap, always working from a wet edge. You should see that an even layer is being applied with this method, leaving no dry streaks. Using the wipe-on method will only require a single coat application, if areas have not been sufficiently coated, additional coats can be applied once tack-free (15 – 30 minutes).
4. Allow coated parts to air dry. Parts will be tack-free approximately 15 to 30 minutes following the application. Until this point, the coating is still wet and should not be touched. Coatings will be fully cured after 24 hours. Do not package parts airtight if shipped prior to the 24-hour full cure.

*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, and caution while using this product.***

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