



# APPLICATION GUIDE

## W-400 GLACIER CHROME

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

1. Degrease the parts with a liquid degreaser then heat the parts to a minimum temperature of 500°F for 60 minutes
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. Remove any sharp edges or welding slag that may create thin areas or protrude through coating. For best results use a dry grit material such as aluminum oxide or garnet equivalent to an 80 mesh size. Glass beads are not recommended as they are not aggressive enough to produce a sufficient blast profile. Blasting with finer than recommended media may result in poor adhesion.
3. Hang parts to allow for best view and application access. This can be done by using support wires and 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. Use powder free latex style gloves to handle parts.
4. Place parts in an oven at 500°F for approximately 60 minutes. With mild steel a purple tint will indicate a layer of oxide has formed which is critical for proper adhesion.
5. Make sure the W-Series products are completely mixed and no solids remain in the bottom of the container. Failure to completely disperse the product will result in poor chemical ratios and product failure. Note: Product separation and settling occurs quickly. Ensure product is adequately mixed immediately prior to spray. 5 to 10 minutes on a paint shaker is recommended. Strain product through a disposable automotive filter.
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 HVLP gun with a 1.2 mm tip. Material is ready to spray and does not need to be thinned. Use as received. For complex parts such as exhaust headers and collectors set air pressure to 15 psi. For large diameter tubes, adjust pressure to approximately 30 psi for best results. Spray parts from approximately 3 to 5 inches away with a 2 to 3 inch wide fan pattern.
8. W-400: A single application of product is recommended for a final film thickness of 2.0 mils. Multiple coats should only be applied wet on wet. Do not allow product to dry between coats. Work from the most difficult surface out to the easiest, always working off of your last wet edge. This will aid in reducing dry spray, runs, or excessive build up.
9. Allow to air dry for 20 to 30 minutes, and then place in an oven at 175°F for 20 minutes to allow excess moisture from the coating to out-gas. Ramp the oven up to 500°F (minimum) to 700°F. After desired temperature is reached, cure parts for 60 minutes.
10. After curing, inspect parts for any runs or dry spray which can be lightly sanded out with 600 to 1000 grit wet or dry sandpaper.
11. Cured parts should be polished in a vibratory polisher for 15 to 30 minutes or until desired finish is achieved.
12. Clean tools and equipment with water.

*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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