

H-300 HIGH GLOSS ARMOR CLEAR & H-301 MATT ARMOR CLEAR

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

1. Completely disassemble the item to be coated. If parts are left in, they can produce runs and ruin the finish.
2. Prepare surface to remove oil, contaminants or any unwanted coatings from the substrate.
3. For polished metals that must retain a specific appearance, an organic solvent such as Tert-Butyl Acetate or Wax & Grease Remover should be used to clean the surface. Acetone, Alcohols, MEK and other organic solvents that carry moisture should be avoided.
4. Liberally and repeatedly flood the substrate with Tert-Butyl Acetate or Wax & Grease Remover and then wipe with a clean lint-free or microfiber rag. This process should be repeated until no residue is observed on the rag. Avoid touching parts at this point as this can leave surface defects in the finish.
5. 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.
6. 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 wear a respirator. See SDS for safety and handling information.
7. Prior to measuring coating, gently shake the container. Determine how much Cerakote you intend to use before adding catalyst. Standard mixing ratio for H-Series Clears are 18:1 (18ml Coating to 1ml Catalyst) Use table 1 pg. 11 on Training Manual for standard and custom ratios.
8. Pour the desired quantity of Cerakote into a glass graduated cylinder and add catalyst. Tightly seal glass graduated cylinder and thoroughly mix coating by shaking for approximately 30 seconds to 1 minute.
9. Once agitated, coating is ready to spray. Using a 325-Mesh strainer or 44-Micron strainer equivalent, filter coating into a high quality HVLP detail spray gun with a 0.8 mm tip, such as an IWATA LPH-80. The use of a small spray pattern will aid in coating hard to reach areas without excessive build up.
10. A single wet coat is recommended for a 0.25 to 0.50 mil dry film thickness. Work from the most difficult surface areas out to the easiest. This will help in reducing runs or excessive build up.
11. Allow parts to ambiently flash for 15 minutes followed by full cure at 250° Fahrenheit or 121° Celsius for 2 hours.
12. After curing is completed, remove parts from the oven and allow them to cool. Finished Goods may be handled, packed, reassembled or ready to use at this point.
13. Clean tools and equipment with Tert-Butyl Acetate or 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.

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7050 6TH Street, White City, OR 97503

866-774-7628