CERAKOTE®

APPLICATION GUIDE

MC-161 MATTE CERAMIC CLEAR

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

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. Plug/mask off any areas you do not want to be coated. Improper masking on certain mechanical parts may cause tolerance or functionality issues.

3. Degrease parts to remove any oils or contaminants from the substrate using a degreasing solvent such as 99% Isopropyl Alcohol (IPA), Wax and Grease Remover, or High-Grade Acetone. 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.

4. 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.

5. Gently shake the coating and pour through a 100-mesh filter into a high-quality HVLP/LVLP detail spray gun with a 0.8 mm tip, such as an IWATA LPH-80 (Cerakote Part #SE-138).

6. Blow off the substrate with a high-pressure air nozzle to remove potential surface dust. 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.

7. Apply two to three light coats to achieve a recommended film thickness of 0.05 – 0.25 mil (0.00005” – 0.00025”).
   - **NOTE:** Set the spray gun air pressure between 25 and 30 PSI for best application results. Work from the most difficult surface out to the easiest. Refer to the Technical Data Sheet (TDS) for coating specifics.

8. Allow coated parts to cure ambiently (air dry). The coating will be tack-free after approximately 45 to 60 minutes; until this point, the coating is still wet, so take care not to bump or touch the parts. The coating will be partially cured after 24 hours and fully cured in five days.

9. Finished goods may be handled, packaged, and shipped after the 24-hour partial cure.
   - **NOTE:** Do not package parts airtight if shipped before the 5-day full cure.

10. Clean tools and equipment with Acetone or comparable cleaning solvent.

*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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