

CERAKOTE[®]

AN INNOVATION OF **NIC INDUSTRIES, INC.**

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STEP-BY-STEP

M81

APPLICATION GUIDE

[M81 TRAINING VIDEO](#)

[M81 SMALL VINYL STENCIL PATTERN](#)

[M81 LARGE VINYL STENCIL PATTERN](#)

M81 CAMOUFLAGE

FOUR COLOR, HIGH CONTRAST DISRUPTIVE PATTERN



M81

M81 CAMOUFLAGE

The Cerakote Training Department has developed this M81 pattern with our customers in mind. It was created to ensure that you, our customer, will have an excellent camouflage pattern with supported application documentation. Our easy-to-follow, step-by-step instructions, as well as informative videos, will guide you through the entire process. This pattern can be applied to firearms, knives, bicycles, cups, golf clubs, or anything you can

Cerakote that your customer may want to showcase.

Trainers have developed, tested, and specified every inch of this pattern. Once approved by training, the pattern is vectorized and digitally developed for easy plotting on our Cerakote 15" vinyl cutter.

Be sure to upload your projects in our Gallery!

Technical Support Questions? Contact us at:

TechnicalSupport@cerakote.com
Phone: 1-866-774-7628

CERAKOTE USED

Make sure you have everything you need to start your project. After you have all the tools, files, and equipment, prepare your parts in accordance with the Cerakote Training Manual: H-Series and Elite Series available at Cerakote.com.

Feel free to reach out to our Cerakote Technical Support at TechnicalSupport@Cerakote.com if you have any questions about the application process, patterns, or getting help with M81.



GRAPHITE BLACK

[H-146](#)



NOVESKE TIGER EYE BROWN

[H-187](#)



MIL SPEC O.D. GREEN

[H-240](#)

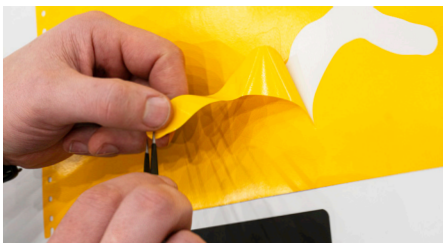


PLUM BROWN

[H-298](#)

EQUIPMENT USED

For the M81 application the following tools were used. High Tack Vinyl, M81 Vinyl Stencil, Anti-Static Tweezers and Plastic Razor Blades.



M81 VINYL STENCIL

Download the MCP Vinyl Pack containing the MCP Large Pattern and MCP Small Pattern.

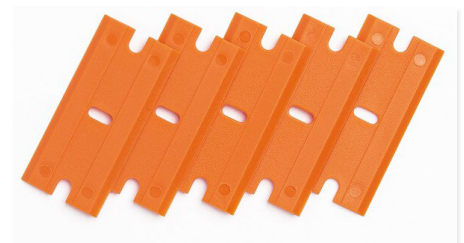
[M81 SMALL VINYL STENCIL PATTERN](#)

[M81 LARGE VINYL STENCIL PATTERN](#)



ANTI-STATIC TWEEZER

SE-366 Great for peeling, weeding, picking or laying high bake vinyl.

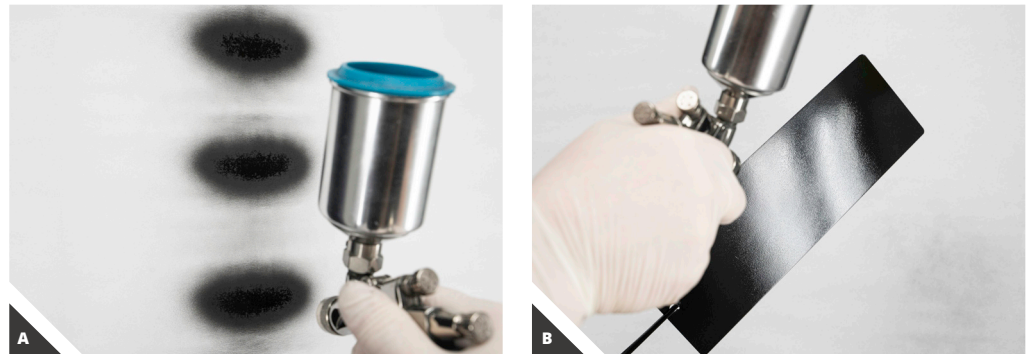


PLASTIC RAZOR BLADES

SE-367 Double edged blades soft enough to preserve your coated project, but firm enough to remove stencils or score edges.

STEP 1

Base Coat, H-146 Graphite Black



PRO TIP: IWATA LPH80 baseline settings for achieving a 2-3" oval fan pattern.

- Pattern Adjustment Knob – 1 Turn Counterclockwise (from a closed position)
- Fluid Adjustment Knob – 2 Turns Counterclockwise (from a closed position)
- Air Pressure – 25 PSI (set at the air regulator)
- Mix **H-146 Graphite Black** at the standard 18:1 mixing ratio.
- Adjust your spray gun settings to achieve a 2-3" wide oval fan pattern (*Image A*) while spraying from a distance of 3-5 inches. Adjust the spray gun to a narrower fan pattern with moderate-sized splatter to coat hard-to-reach areas.
- Apply a base coat (*Image B*) to the item with a dry film thickness of 1 mil.
- **Ambiently flash** for 15 minutes. Before moving on to the next step, visually inspect the coating to ensure the solvents have completely flashed off. The coating should appear dry once complete.
- **Flash Cure** at 150-180°F (65-82°C) for 10 to 30 minutes, or just to the point of tack-free (dry to the touch). Allow the items to cool to room temperature before moving to the next step.

STEP 2

M81 Small Vinyl Stencil Pattern, H-187 Noveske Tiger Eye



PRO TIP: IWATA LPH80 baseline settings for achieving a 1" oval fan pattern with moderate splatter.

- Pattern Adjustment Knob – 1 Turn Counterclockwise (from a closed position)
- Fluid Adjustment Knob – 1/2 Turn Counterclockwise (from a closed position)
- Air Pressure – Adjust PSI until a 1" oval is achieved.

- **Apply the M81 Small Vinyl Stencil Pattern. (Image C)** Cover approximately 25% or 1/4 of the H-146 Graphite Black base coat.
- Inspect all edges of the vinyl to ensure the edges are pressed down firmly. This will help eliminate any possible blowouts in the pattern.
- Mix **H-187 Noveske Tiger Eye Brown** at the standard 18:1 mixing ratio.
- Adjust your spray gun settings to achieve a 1" oval fan pattern (*Image D*) with moderate splatter.

(NOTE: These will be your spray gun settings for all remaining coats).

- Apply a light coat of **H-187 Noveske Tiger Eye Brown** to the open areas (*Image E*). Apply just enough Cerakote for coverage with little to no transparency.
- **Ambiently flash for 15 minutes.** Before moving on to the next step, visually inspect the coating to ensure the solvents have completely flashed off. The coating should appear dry once complete.

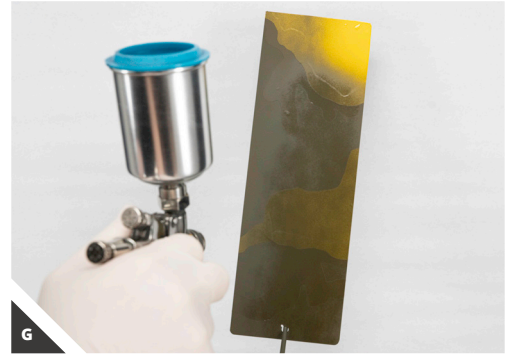


- Flash Cure at 150-180°F (65-82°C) for 10 to 30 minutes, or just to the point of tack-free (dry to the touch). Allow the items to cool to room temperature before moving to the next step.

DO NOT REMOVE THE VINYL STENCILS!

STEP 3

M81 Large Vinyl Stencil Pattern, H-240 Mil Spec O.D. Green



- Apply the M81 Large Vinyl Stencil Pattern. **(Image F)** Slightly overlap the previous layer of vinyl stencils and cover approximately 33% or 1/3 of the H-187 Noveske Tiger Eye Brown.
- Inspect all edges of the vinyl to ensure the edges are pressed down firmly. This will help eliminate any possible blowouts in the pattern.
- Mix H-240 Mil Spec O.D. Green at the standard 18:1 mixing ratio.
- Adjust your spray gun settings to achieve a 1" oval fan pattern with moderate splatter (previous spray gun settings).
- Apply a light coat of H-240 Mil Spec O.D. Green to the open areas **(Image G)**. Apply just enough Cerakote for coverage with little to no transparency.
- Ambiently flash for 15 minutes. Before moving on to the next step, visually inspect the coating to ensure the solvents have completely flashed off. The coating should appear dry once complete.
- Flash Cure at 150-180°F (65-82°C) for 10 to 30 minutes, or just to the point of tack-free (dry to the touch). Allow the items to cool to room temperature before moving to the next step.

DO NOT REMOVE THE VINYL STENCILS!

STEP 4

M81 Large Vinyl Stencil Pattern, H-298 Plum Brown



- Apply the M81 Large Vinyl Stencil Pattern. (*Image H*) Slightly overlap the previous layer of vinyl stencils and cover approximately 50% or 1/2 of the H-240 Mil Spec O.D. Green.
- Inspect all edges of the vinyl to ensure the edges are pressed down firmly. This will help eliminate any possible blowouts in the pattern.
- Mix H-298 Plum Brown at the standard 18:1 mixing ratio.
- Adjust your spray gun settings to achieve a 1" oval fan pattern with moderate splatter (previous spray gun settings).
- Apply a light coat of H-298 Plum Brown to the open areas (*Image I*). Apply just enough Cerakote for coverage with little to no transparency.
- Ambiently flash for 15 minutes. Before moving on to the next step, visually inspect the coating to ensure the solvents have completely flashed off. The coating should appear dry once complete.
- Flash Cure at 150-180°F (65-82°C) for 10 to 30 minutes, or just to the point of tack-free (dry to the touch). Allow the items to cool to room temperature before moving to the next step.
- Carefully remove the vinyl stencils. It is best to remove the vinyl with a plastic razor blade to avoid damaging the Flash-Cured Cerakote (*Image J*).

Fully cure the part in accordance with the H-Series & Cerakote Elite Series Training Manual.



ALTERNATIVE COLOR PALATES

01

Layer 1: H-298 Plum Brown
Layer 2: H-256 Desert Verde
Layer 3: H-203 McMillan Tan
Layer 4: H-139 Steel Grey



02

Layer 1: H-146 Graphite Black
Layer 2: H-213 Battleship Grey
Layer 3: H-345 Multicam Dark Grey
Layer 4: H-188 Magpul Stealth Grey



★★ FINISH ★★
CERAKOTE

★★ STRONG ★★