

Cerakote FX Application Guide with H-300 or H-301

Applying a proper base coat and following each step of this application guide is crucial

BASE COAT:

1. Apply an [H-Series solid-tone](#) basecoat (non-metallic) at the recommended mil thickness (refer to the TDS) in accordance with the Cerakote H-Series and Elite Series [Training Manual](#), before Cerakote FX is applied. It is important that you **do not** cure, or flash-cure your parts. **Parts will NOT be placed into an oven until after Cerakote FX has been applied.**
2. Ambiently flash your parts with an H-Series basecoat for a minimum of 15 minutes or until solvents have fully evaporated.

MIXING:

3. Add full contents of one Cerakote FX container to one full 4 oz. bottle of H-Series Clear ([H-300](#) or [H-301](#)). **Cerakote FX is to be added to H-Series clear prior to catalyzing.** *Adding Catalyst prior to agitating Cerakote FX and H Series clear will cause clumping.*
4. Agitate the bottle for 1 minute until Cerakote FX and H-Series clear are thoroughly mixed.
5. Pour the desired quantity into a [glass graduated cylinder](#) or [beaker](#).
6. Mix by volume. Add H-100 Part B Catalyst using the standard mixing ratio of 18:1 (18ml of H-Series Clear with Cerakote FX to 1ml of H-100 Part B Catalyst). Load coating to catalyst in multiples of 18:1 (i.e., 18:1, 36:2, 54:3, etc.).
7. Use a [powder-free latex](#) or nitrile glove to tightly seal the graduated cylinder or beaker. Agitate the bottle for 1 minute until thoroughly mixed.
8. Strain through a [100-mesh strainer](#) (149-micron) into a high-quality spray gun, such as an [Iwata LPH-80](#).

SPRAYING:

9. Adjust air pressure settings to 25-30 PSI and adjust your fan to a 2-3 inch oval fan pattern.
10. Spray from a distance of 3-5 inches and apply 2-3 light coats of Cerakote FX to achieve best visual results. Applying Cerakote FX to an H-Series base coat will add an additional 0.25 – 0.50 mil to the overall finish.
11. After Cerakote FX has been applied, allow parts to ambiently flash for a minimum of 15 minutes or until solvents have fully evaporated.
12. Fully cure at 250° Fahrenheit (121° Celsius) for 2 hours.

*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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