

## APPLICATION GUIDE

# CERAKOTE FX WITH H-300 OR H-301

APPLYING A PROPER BASE COAT AND FOLLOWING EACH STEP OF THIS APPLICATION GUIDE IS CRUCIAL.

### BASE COAT APPLICATION

#### STEP 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.**

#### STEP 2

Ambiently flash your parts with an H-Series basecoat for a minimum of 15 minutes or until solvents have fully evaporated.

### MIXING CERAKOTE FX

#### STEP 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.*

#### STEP 4

Agitate bottle for 1 minute until Cerakote FX & H-Series clear are thoroughly mixed.

#### STEP 5

Pour the desired quantity into a [glass graduated cylinder](#) or [beaker](#).

#### STEP 6

Mix by weight, by using a scale that can measure down to a 1/10th of gram. Select H-300 / H-301 in the Cerakote Mixing calculator. Then select the catalyst ratio (i.e., 12:1 for higher gloss, 18:1 for recommended gloss, 24:1 for lower gloss.) Enter the weight of the coating prior to adding catalyst, and then click 'CALCULATE'. Add the amount of catalyst to your Cerakote that is displayed on the calculator.

#### STEP 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.

#### STEP 8

Strain through a [100-mesh strainer](#) (149-micron) into a high-quality spray gun, such as an [Iwata LPH-80](#).

### SPRAYING CERAKOTE FX

#### STEP 9

Adjust air pressure settings to 25-30 PSI and adjust your fan to a 2-3 inch oval fan pattern.

#### STEP 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.

#### STEP 11

After Cerakote FX has been applied, allow parts to ambiently flash for a minimum of 15 minutes or until solvents have fully evaporated.

#### STEP 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.**

## APPLICATION GUIDE

# CERAKOTE FX WITH MC-160 OR MC-161

PREP PARTS IN ACCORDANCE WITH THE CERAKOTE C-SERIES APPLICATION GUIDE.

APPLYING A PROPER BASE COAT AND FOLLOWING EACH STEP OF THIS APPLICATION GUIDE IS CRUCIAL.

### BASE COAT APPLICATION

#### STEP 1

Apply a [C-Series solid-tone](#) basecoat (non-metallic) at the recommended mil thickness (refer to the TDS). Before applying Cerakote FX, it is important not to cure, flash-cure, or allow the coating to become tackfree.

#### STEP 2

Ambiently flash your parts with a minimum of 5-10 minutes or until solvents have fully evaporated.

### MIXING CERAKOTE FX

#### STEP 3

Add full contents of one Cerakote FX container to one full 4 oz. bottle of C-Series Clear ([MC-160](#) or [MC-161](#)).

#### STEP 4

Agitate the bottle for 1 minute until Cerakote FX and C-Series clear are thoroughly mixed.

#### STEP 5

Strain through a [100-mesh strainer](#) (149-micron) into a high-quality spray gun, such as an [Iwata LPH-80](#).

### SPRAYING CERAKOTE FX

#### STEP 6

Adjust air pressure settings to 25-30 PSI and adjust your fan to a 2-3 inch oval fan pattern.

#### STEP 7

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 C-Series base coat will add an additional 0.25 – 0.50 mil to the overall finish.

#### STEP 8

Allow coated parts to air dry, they will be tack-free approximately 45-60 minutes following the application. 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 5 days after the application.

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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