CERAKOTE®

APPLICATION GUIDE FOR CERAKOTE CERAMIC CLEAR (MC-160) FOR POLISHED METALS WITH PC-148 CLEAR PRIMER

Compliance with all preparation steps necessary for maximum adhesion and performance of this material.

1) Remove all coatings, oils, polishing rouge and contaminants from the substrate by liberally and repeatedly spraying the substrate with *tert*-butyl acetate and then wiping with a clean lint-free, micro fiber rag. This process should be repeated, flooding the surface with *tert*-butyl acetate and then wiping with a clean lint-free, micro fiber rag, until no residue is observed on rag.
2) Apply a thin coat of Cerakote® PC-148 Micro Primer by spraying with an Iwata LPH-80 spray gun, or equivalent.
3) A thin film will give the best adhesion. If a white, chalky residue is noticed after several minutes of drying time, lightly wipe away the chalky residue with a clean lint-free, micro fiber rag.
4) At normal temperatures and humidity conditions (68 °F, 50% R.H.), PC-148 should be allowed to air dry for 20 minutes. Since PC-148 requires moisture in the air to cure, low temperature and humidity will necessitate a longer drying time. The optimal drying time is 20 minutes. PC-148 that is allowed to cure extensively before coating with MC-160, will no longer promote adhesion of the clear coat. Drying times of more than 2 hours at normal temperatures and humidity should be avoided.
5) MC-160 is ready to spray and should not be thinned. Gently shake the container and pour through a **145** mesh filter into an Iwata LPH-80 spray gun. The use of a 0.8 mm spray tip will yield a sufficiently narrow pattern that will aid in coating hard to reach areas without excessive build up in surrounding areas. Electrostatic application may also be an option.
6) A 0.5 to 1.0 mil dry film thickness is recommended. To achieve this dry film thickness, a single wet coat is recommended. Spray from the most difficult surface area to the easiest. This will aid in reducing runs or excessive build up.
7) Allow to air dry. Parts will be tack free after approximately 35-45 minutes. Until this point, the coating is still wet and should not be touched. Parts will be partially cured after 24 hours and fully cured 5 days after application.
8) Finished goods may be handled, packaged and shipped after 24 hours, when the coating is partially cured, provided that breathable packing material is used.
9) Clean tools and equipment with *tert*-butyl acetate.
10) Clean Micro Fiber Rags by washing in warm or hot water with mild detergent. Do not use alkaline containing detergents. Do not use fabric softener, it will clog the open spaces in the microfiber that do the cleaning, rendering the towel useless. Avoid washing with anything made of cotton. Wash microfiber only with other microfiber. Dry on low heat or no heat and only dry with other microfiber products.

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, and precautions while using this product.***