

CERAKOTE™ · A division of NIC Industries, Inc. 7050 Sixth Street, White City, OR 97503  
Phone: 541-826-1922 / Fax: 541-826-6372 / [www.nicindustries.com](http://www.nicindustries.com)

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

- 1) Remove all coatings, oils, and contaminants from substrate with either a de-greasing chemical and/or by heating substrate to temperatures high enough to remove coatings or contaminants.
- 2) A lightly blasted profile (~40 psi) must be applied to the substrate to remove any rust, scale, or other coatings. This is also required to ensure maximum adhesion. For best results use a dry grit material such as aluminum oxide or garnet equivalent to a 100 - 120 mesh size. Glass beads are not recommended as they are not aggressive enough to produce a sufficient blast profile.
- 3) We recommend, but do not require, that the metal parts are placed in an oven at 250°F for approximately 30 minutes to evaporate any last minute moisture, oils, or contaminants. **Only Cerakote™ approved solvents may be applied to the substrate after completing the blast profile.**
- 4) Hang parts to allow for 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. **Do not touch parts with bare skin.**
- 5) Shake the product until the coating is completely mixed and no solids remain in the bottom of the container. Failure to completely disperse the product will result in poor chemical ratios and product failure.
- 6) Blow off substrate with a high-pressure air nozzle to remove any blasting dust left on the surface. Wear safety goggles or face shield for your protection. Work in a well-ventilated area. If ventilation is not available, wear a respirator-see MSDS for additional information.
- 7) Recommended spray equipment is a siphon-fed detail gun with a fine to medium tip. The use of a small spray tip pattern will aid in coating hard to reach areas without excessive build up in surrounding areas. Electrostatic application may also be an option. **Material does not need to be thinned. Use as received.**
- 8) Two applications of product is recommended for a 1.5 - 2.0 mil film thickness. Work from the most difficult surface out to the easiest. This will aid in reducing runs or excessive build up.
- 9) Allow to air-dry. Parts will be tack free after approximately 35 minutes. Until this point the coating is still wet, so take care to not bump or touch the parts. Parts will be partially cured after 24 hours and fully cured 5 days after application. Allow parts to cure for at least 60 hours before exposing to thermal detonation.
- 10) Finished goods may be shipped after 24 hours when the coating is partially cured.
- 11) Clean tools and equipment with acetone or Cerakote™ 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 MSDS for proper handling, disposal, and precautions while using this product.*

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The information contained in this bulletin we believe to be correct to the best of our knowledge and testing. The recommendations and suggestions herein are made without guarantee or representation as to results. We recommend that you make adequate tests in your laboratory or plant to determine if this product meets all your requirements. 071008