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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 blasted profile must be applied to the substrate to remove any rust, scale, or other coatings. This is required to ensure maximum adhesion. Remove any sharp edges or welding slag that may create thin areas or protrude through coating. For best results use a dry grit material such as aluminum oxide or garnet equivalent to an **80 - 100** mesh size. Glass beads are not recommended as they are not aggressive enough to produce a sufficient blast profile. Blasting with finer than recommended media may result in poor adhesion.

3) Place parts in an oven at 500 °F for approximately 60 minutes to prepare the surface for coating.

4) Hang parts to allow for best view and application access. This can be done by using support wires and 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.** Use **powder free** latex style gloves to handle parts.

5) Make sure the **W-Series** products are 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. **Note:** Product separation and settling occurs quickly. Ensure product is adequately mixed immediately prior to spray.

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 SDS for additional information.

7) Recommended spray equipment is a HVLP gun with a 1.2 mm tip. **Material is ready to spray and does not need to be thinned. Use as received.**

8) Product Application:

Note: For easiest application and best performance we recommend W-400 Glacier Chrome.

W-400 & W-211: A single application of product is recommended for a final film thickness of 2 mils. Multiple coats should only be applied wet on wet. Do not allow product to dry between coats. Work from the most difficult surface out to the easiest. This will aid in reducing runs or excessive build up.

W-207 & W-206: Two applications of product are recommended for a final film thickness of 2 mils. Apply a wet first coat and allow the applied product to turn from green to grey (Approx. 15-20 min), then apply a wet second coat.

9) Allow to air-dry for 20 minutes, and then place in an oven at 175 °F for 20 minutes to allow excess moisture from the coating to out-gas. Ramp the oven up to 500 °F (minimum) to 700 °F. After desired temperature is reached, cure parts for 60 minutes. Higher cure temperatures are recommended for extreme application requirements.

10) After curing, inspect parts for any runs which can be lightly sanded out with 600 grit wet or dry sandpaper.

11) Cured parts should be polished in a vibratory polisher for 20 to 30 minutes or until desired finish is achieved.

12) Clean tools and equipment with water.

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.