

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

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 a 100 - 120 mesh size. Glass beads are not recommended as they are not aggressive enough to produce a sufficient blast profile.
 - 3) Place parts in an oven at 500°F for approximately 30 minutes to evaporate any last minute moisture, oils, or contaminants that blasting or contact with skin have deposited on surface.
 - 4) Hang parts to allow for best view and application access. This can be done by using support wires and hooks. Place the parts in such a way that they will not bump into each other. **Do not touch parts with bare skin.**
 - 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.
 - 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 HVLP 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. **Material does not need to be thinned. Use as received.**
 - 8) A single application of product is recommended for a final film thickness of 0.5-1.0 mil. Work from the most difficult surface out to the easiest. This will aid in reducing runs or excessive build up. Base coat thickness must be 0.5-1.0 mil to avoid surface defects in the final product.
 - 9) You may re-coat parts prior to pre-bake or cure cycle if needed. **Touch-up cannot be performed after the cure cycle.** If the parts need to be touched up after the cure cycle, the coating will need to be removed down to bare metal with the entire coating process repeated.
 - 10) Allow to air-dry for 20 minutes, and then place in an oven at 175°F for 20 minutes to allow excess solvents from the coating to out-gas.
 - 11) Ramp the oven up to 550°F. After the part metal reaches this temperature, cure parts for 60 minutes.
 - 12) Once the cure cycle is complete, lightly **etch** the base coat and blow off with air to remove any sediment. **Take care to not remove the W-211 base coat.**
 - 13) Apply the C-Series topcoat at 1.0-2.0 mil.
 - 14) Following application, allow the coating 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 high temperatures.
 - 15) **W-Series** coating and equipment should be cleaned with **water**.
 - 16) **C-Series** coating and equipment should be cleaned with **acetone** or other Cerakote™-approved **solvents**.
- 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.