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

- 1) Completely disassemble the item to be coated. If pins or parts are left in, they can produce runs and ruin the finish.
- 2) Prepare surface to remove oil, contaminants or any unwanted coatings from the substrate.
- 3) For surfaces that must retain a specific appearance (such as wheels) denatured alcohol may be used.
- 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) 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.
- 6) Recommended spray equipment is a high-quality HVLP gun (such as IWATA) or 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.**
- 7) A single application of product is recommended for a 12 to 19 microns film thickness. Work from the most difficult surface out to the easiest. This will aid in reducing runs or excessive build up.
- 8) Allow to air-dry. Parts will be tack free after approximately 40 minutes. Until this point the coating is still wet, and care should be taken to not bump or touch the parts. Parts will be partially cured after 24 hours and fully cured 5 days after application.
- 9) Finished goods may be shipped after 24 hours when the coating is partially cured.
- 10) 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 information sheets 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.

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