

CERAKOTE™ · A division of NIC Industries, Inc. 7050 Sixth Street, White City, OR 97503
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Preparation of substrate is crucial for maximum adhesion and performance of this material

- 1) V-Series Clear Coatings are intended primarily for use as a top-coat for chromed parts and should be applied following completion of the chroming process.
 - 2) 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, and/or by rinsing the parts with a high-temperature detergent wash.
 - 3) Place parts in an oven at 260°C (500°F) for approximately 30 minutes to evaporate any last minute moisture, oils, or contaminants that may be deposited on the surface. **Parts should be at ambient temperature during the application process.**
 - 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.**
 - 5) Strain the “V” Series using a filter with 145 mesh/in or smaller. Failure to completely filter the product may result in point defects, inconsistent coverage, or decrease clarity.
 - 6) Blow off substrate with a high-pressure air nozzle to remove any dust left on the surface. Wear safety goggles of 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) A single application of product is recommended for a dry film thickness of 0.3 mil. Work from the most difficult surface out to the easiest. This will aid in reducing runs or excessive build up.
 - 9) You may re-coat parts prior to pre-bake or cure cycle if needed. **Touch-up cannot be performed after the cure cycle.**
 - 10) Allow to air-dry for 5 minutes, and then place in an oven at 162°C (325°F) for 25 minutes.
 - 12) After cure cycle is complete, finished goods may be shipped once they cool to the touch.
 - 13) 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.