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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.

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 blasting or contact with skin have deposited on surface. **Only Cerakote™ approved solvents may be applied to 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 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) 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 (0.8mm or smaller). 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) Two applications of product are recommended for a final film thickness of 50 microns (2 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.** 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 80°C (175°F) for 20 minutes to allow excess solvents from the coating to out-gas.

11) Ramp the oven up to 260°C (500°F) (minimum) to 370°C (700°F). After desired temperature is reached, cure parts for 60 minutes. Higher cure temperatures are recommended for extreme application requirements. The material will cure in a 205°C (400°F) oven after 2 hours and the final cure can take place at higher temperatures, such as running on a high-temp exhaust.

12) After cure cycle is complete, the parts need to be lightly buffed with super fine steel wool (0000 or 4/0) then polish in a vibratory polisher.

13) 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 MSDS for proper handling, disposal, and precautions while using this product.***

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