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

1) All oils and contaminates must be removed from substrate with either a de-greasing chemical and or by heating substrate to temperatures high enough to result in contaminant removal.

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. A dry grit material such as aluminum oxide or garnet equivalent to a 100 - 120 mesh size is recommended for best results.

3) Place parts in an oven at 450 F for approx 30 min to evaporate any last minute moisture, oils, or contaminates that blasting or contact with skin has deposited on surface. **Do not apply any solvents to substrate after a blast profile has been applied.**

4) Make sure that **Artic Black P202** is completely mixed and there are no solids in the bottom of the container. Failure to completely disperse the product will result in poor chemical ratios and product failure.

5) Hang parts to allow the applicator to easily view and rotate for application. **Do not touch parts with bare skin.** Remove any sharp edges or welding slag that may create

thin areas or protrude through coating.

6) Recommended spray equipment is a HVLP (gravity fed) spray gun. 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.**

7) Two light applications of product is recommended for a 0.30 to 0.60 mil film thickness. In some cases a single coat will suffice for a particular application. Work from the most difficult surface out to the easiest.

8) Parts will cure in a 350F oven for 1 hour.

9) Clean up with acetone or xylene.

Please contact a *Cerakote* technician with questions on application and usage.

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.