

## **H-301 Matte Armor Clear Cerakote Ceramic Clear Coating**

*Preparation of substrate is crucial for maximum adhesion and performance of this coating. **Wear powder-free latex style gloves throughout the entire process. Do not touch parts with bare hands.***

- 1) Completely disassemble the item(s) to be coated.
- 2) Parts should be thoroughly degreased to remove all oils and contaminants from the substrate. For substrates that must retain a specific appearance, such as polished metals, thoroughly clean the parts with an organic solvent such as *tert*-butyl acetate or toluene. **NOTE: Acetone, Alcohols, MEK and other organic solvents that carry moisture should be avoided.**
- 3) Hang parts to allow for best view and application access. This can be done by using support wires or hooks. Make sure to fixture parts in such a way that they will not bump into each other. Do not touch parts with bare hands.
- 4) Blow off substrate with a high-pressure air nozzle to remove any dust left on the surface. This step should be done just before coating to ensure the substrate is free of any dust. Parts should be coated in a well-ventilated, dust free environment.
- 5) Gently shake the H-300 Armor Clear and the H-101 Hardener. Avoid excessive shaking which can cause air bubbles to form in the coating. The coating should not be thinned.
  - a. **The H-101 Hardener provided is specific to H-301 Armor Clear and should NOT be used as a hardener for any other H series Coating.**
  - b. **To achieve optimal results the H-301 must be mixed at a 9:1 ratio by volume of coating to hardener.**
- 6) Pour the mixed coating through a 100 mesh filter into a high quality HVLP detail spray gun with a 0.8mm tip, such as an IWATA LPH -80 (NIC Part# SE-138) or a siphon-fed detail spray gun with a fine to medium tip.
- 7) Prior to coating, ensure that you are working in a well-ventilated area and are following all safety and handling information as described in the H-300 MSDS.
- 8) A single wet coat is recommended for a 0.5 to 2.0 mil dry film thickness. Work from the most difficult area to the easiest. This will aid in reducing runs or excessive build up.
- 9) Place the coated parts in a 200°F oven and cure for 2 hours or 1 hour at 250°F.
- 10) Cured parts may be handled, packaged and shipped as soon as they are cool enough to handle.
- 11) Clean tools and equipment with *tert*-Butyl acetate or acetone.

*Please contact a Cerakote<sup>™</sup> Technical Advisor 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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