

CERAKOTE CLEAR MC-5100

Preparation of aluminum surface is critical for maximum adhesion and performance of this product. For best results, product should be applied immediately after surface preparation. Review the Safety Data Sheet (SDS) prior to using this product. Product should only be used in a well-ventilated area, using proper personal protective equipment (PPE).

Important: This product is not intended to be applied over any other Cerakote products.

1. Prepare aluminum surface by removing oil and other contaminants by thoroughly cleaning with Blue Dawn® dish soap and **HOT** water, using a non-abrasive micro fiber type cloth to avoid scratching the aluminum surface.

TIP: High polished aluminum scratches easily and should be hand washed with great care.

2. Dry surface using clean compressed air, insuring no water spots are left behind.

3. MC-5100 Cerakote Clear (Aluminum) is ready to spray and should not be thinned. Gently shake container and pour through a 325 mesh filter (Cerakote Part #SE-277) into a high quality HVLP spray gun with a 0.8mm tip, such as an IWATA LPH-80 (Cerakote Part #SE-138). Set air pressure at 30 PSI.

4. A single wet coat is recommended for a 0.25 to 0.5 mil dry film thickness. For best results, work from the most difficult area to the easiest. Use of a mil gauge can aid in insuring proper coating thickness (Cerakote Mil Gauge Part #SE-321).

5. Allow parts to air-dry. Parts will be tack free after approximately 15-30 minutes. Until this point the coating is still wet and should not be touched. Parts will be fully cured within 24 hours.

6. Clean equipment with acetone.

*TIP: If you encounter any surface defects during application, rinse **immediately** with acetone.*

Contact Cerakote Technical Support for alternative preparation and application methods to meet your unique requirements.

As always, give us a call at 1-866-774-7628 if you need any assistance.