



Same instructions used for all Ciloxide Products

Application Instructions for Ciloxide Black

Ciloxide Black is a 2 part coating system. Ciloxide has better coverage, is more forgiving in application, has many of the properties of our Cilgen line of coatings, allows for user adjustment of the surface finish by adjusting the amount of activator used. This coating requires a mix of the coating and an activator giving you more than 4 hours of pot life. The following are general instructions to help you achieve the best results using this product. As these instructions will be more general in nature, if you have any questions beyond what is covered here feel free to contact our technical support group.

Surface preparation:

- The parts to be coated must be clean and free of all oils, grease, moisture, dust, scale or corrosion.
 - If the part has oils, grease or other contaminants it must be cleaned to allow the coating to adhere to the substrate. This can be done by pre-baking the part. Solvents can be used if they will completely evaporate without any residue. The part should be free of oils before sand blasting.
- Sand blast with 120 grit aluminum oxide or similar.
 - After sand blasting clean any residue off with high pressure air. Protect yourself with safety shield, goggles and respirator.
 - If needed a rinse with acetone or lacquer thinner can be done to further clean the part.

Preparation of the coating:

- Use caution the chemicals used in this product are considered Hazardous, it is important that you read the SDS before using this product.
- Shake and stir the coating before use. A number of clean ball bearings may be added to the coating to help agitate the coating while you shake or roll the container.
- The activator and the coating must be well mixed before application. Mix in the following ratio: 1 part activator to 10 parts coating. Example: 10 milliliters of coating to 1 milliliter of activator.
- Allow the mixed coating and activator to sit for a few minutes, then stir and use.

Tips on Preparing the Coating:

- The ratio of activator to coating is based on testing we have done. Additional activator can be added to the coating, however when doing this the coating has lost gloss and had a slight textured appearance, other properties have not been observed.
 - Increasing the activator will give a more matt finish than satin.
- When mixing the coating and activator you can either stir or shake the mix or both. This should be done in a separate container from the one the material was supplied in.
- The minimum 4 hour pot life is based on our testing, however we have seen the mix last as long as 2 days and more. The coating will turn to a solid gel when the pot life is exceeded.

Equipment:

- Use an airbrush or detail touch-up spray gun with a 1 mm or smaller tip, to apply the coating.
- Use a respirator with the correct NIOSH filter (consult the SDS before using). Wear safety glasses or goggles. Wear gloves to protect your hands from the coating and from solvents
 - Use caution the chemicals used in this product are considered Hazardous, it is important that you read the SDS for both the coating and the activator before using this product.

Spraying the coating:









- Spray the coating in all hard to reach areas first then move out to the other areas. Spray a thin wet coat, at about 35 psi depending on the spray gun you use. Your finished cured coating thickness should be about .001".
- Inspect part for complete coverage. Part should be glossy wet without runs or sags.

Tips on Spraying:

- Prior to curing the coating can be reapplied to missed or light areas. After curing reapplication is not advised.
- Excessive thickness can lead to mud cracking and the coating failing to stick to the part. Avoid putting too much on.

Curing the Coating:

- Ciloxide Black **Partial** cures at 400° F for one hour.
 - Note: For Full Cure, the part will have to see 750° F for one hour.
- Cure can be done in an industrial oven, or heat can be from the exhaust of the motor maintaining the temperatures and time indicated above.

Hazard Information	Danger	For Industrial Use Only
	<p>Highly flammable liquid and vapor</p>	
	<p>Harmful in contact with skin</p>	
	<p>Toxic if inhaled</p>	
	<p>Causes skin Irritation</p>	
	<p>Causes Serious Eye Damage</p>	
	<p>Suspected of causing genetic defects</p>	
	<p>Suspected of causing cancer</p>	
	<p>Suspected of damaging fertility or the unborn child</p>	
	<p>May cause damage to organs; brain, liver, kidney, bladder, central nervous system</p>	
	<p>May be fatal if swallowed and enters airways</p>	
<p>Keep away from heat / sparks / open flames / hot surfaces. - No Smoking. Ground / bond container and receiving equipment. Use explosion proof electrical / ventilating / lighting equipment. Use only non-sparking tools. Take precautionary measures against static discharge.</p>		
<p>In case of fire use alcohol-resistant foam, dry chemical or carbon dioxide</p>		
<p>Wear protective gloves / protective clothing (chemical proof). Wear eye protection and face protection. Wash hands, face and any exposed skin thoroughly after handling. Obtain special instructions before use. Do not handle until all safety precautions have been read and understood. Do not eat drink or smoke when using this product. Do not breath fumes / mist / vapors / spray. Use only outdoors or in a well ventilated area.</p>		
<p>If swallowed: immediately call a poison center / doctor for medical advice. Rinse mouth with water.</p>		
<p>If on skin: wash with plenty of water. Call a poison center / doctor if you feel unwell or if irritation occurs. Immediately take off all contaminated clothing and wash it before reuse.</p>		
<p>If in eyes: Rinse cautiously in water for several minutes. Remove contact lenses, if present and easy to do. Continue rinsing. Immediately call a poison control center / doctor.</p>		