

CamoKote C303 Series

High Solid Polyurethane Top Coat



Product CamoKote C303 Series High Solid Polyurethane Topcoat

Item Class High Solid Polyurethane Top Coat

CamoKote C303 Series is a high solid polyurethane topcoat formulated to provide superior resistance and excellent coverage for military and defense applications. It is offered in most federal standard 595 flat colors with a guaranteed gloss reading under 5 GU. This product is formulated to surpass conventional polyurethanes with superior chemical resistance and flexibility.

Specifications Product is manufactured to meet the performance requirements of the following specifications:

MIL-C-46168

Catalyst & Additives Catalyst/Activator Thinner Additive

445	CS28 (SLOW DRY)	PS40 ACCELERATOR
	CM100 (MEDIUM DRY)	CRL25 (ROLLING)
	CF3 (FAST DRY)	
*AVAILABLE IN VARIOUS KIT SIZES		

Use of Primers Please contact your local 3Chem representative for a complete list of epoxy primers which may be utilized with this system.

Surface Preparation Prepare substrate per OEM requirements. Refer to product application guide for detailed instructions or contact your local 3Chem representative for assistance.

Mixing Instructions

Base	Catalyst/Activator	Thinner	Mix Ratio
C203-XXXX (Flat)	445	None	1:1

Shake (Base) for 15 minutes to assure no solid settlement remains in can. Add component B catalyst to component A paint first. Mix ratio for material is 1 part component A paint, 1-part component B catalyst. No thinner should be added to semi-gloss or flat colors. (Kit yield either 2 gallons or 2 quarts). Must insure mix ratio is exact to obtain desired semi-gloss or flat finish.

Induction Time Although no induction time is needed. Once mixed together, insure that admixed material is continuously stirred for at least 5 minutes before proceeding.

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Spraying Viscosity Gloss Colors: 17-19 Seconds with #2 Zahn cup, Semi-Gloss/Flat Colors: 19-22 Seconds with #2 Zahn cup

Pot Life 7 Hours @ 21° Celsius, 70° Fahrenheit

Film Thickness 2-3 MILS DFT (2 Coats @ 1-1.5 DFT) Wet film thickness should be 4-6 MILS total between 2 coats

Application Instructions

Temperature and Humidity	Minimum	Maximum
Temperature Celsius	11°	35°
Temperature Fahrenheit	52°	95°
Humidity	33%	74%

Spray Equipment

Spray Gun Type	Tip/Nozzle Size	Cap Pressure	Pot Pressure
Conventional Air	1.3 - 1.6 mm	40 to 60 psi	10 to 20 psi
HVLP	1.4 - 1.6mm	10 psi Maximum	10 to 20 psi
Electrostatic	1.2 - 1.5mm	45 to 60 psi	10 to 40 psi

Dry Times: ***Thinner Options for Gloss Colors Only

Temperature	Thinner	Wet-Edge	Time Between Coats	Dry to Tape	Dry to Handle	Full Cure
52-65°F (11-18°C)	CF3	40 Min	30-50 Min	5-6 Hours	7-8 Hours	6 Days
66-85°F (19-29°C)	CM100	35 Min	30-45 Min	5-6 Hours	7-8 Hours	6 Days
86-95°F (30-35°C)	CS28	30 Min	30-40 Min	6-7 Hours	7-8 Hours	6 Days

Semi-Gloss / Flat Colors:

Only mix enough material to be applied on initial coat. Always add component B activator to component A paint. Complete kit of material will yield 2 US Gallons (7.5 liters). 1-gallon component A paint, 1-gallon component B activator.

Apply one even wet coat of material using a uniform spray pattern. Cross coat may be used to achieve 100% coverage in one single coat depending on color. Note: Apply only one coat of material to achieve proper gloss requirement of product.

Application Instructions PS40 Accelerator (Fast dry additive mix options)

PS40 Accelerator	Dry Between Coats	Dry to Handle	Dry Hard	Pot Life	Full Cure
2% By Volume	12 Minutes	2 Hours	4 Hours	4 Hours	6 Days
3% By Volume	10 Minutes	1.5 Hours	3 Hours	3 Hours	6 Days
5% By Volume	5 Minutes	45 Minutes	1 Hour	45 Minutes	6 Days

*Note: Over use of PS40 additive may affect product gloss and finish

Theoretical Coverage 800-900 sq. ft / gallon @ 1 mil 20-22m² / liter @1 mil
*Coverage based on 100% transfer efficiency rate

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Color	Available in most FED-STD 595 Flat colors
Gloss	Flat/Matt Colors: Less than 5 @ 60 degrees
Volatile Organic Compound	300 – 390 g/l
Shelf Life	24 Months (When stored in climate-controlled environment between 60-80° F) *Product may be re-certified upon inspection by 3Chem.
Safety Instructions	Always read material safety data sheet (SDS) and product label before utilizing this product. Product SDS is available upon request.

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