

# Camokote C51 Series

## Acrylic Enamel Coating



**Product** Camokote C51 Series Acrylic Enamel Coating

**Item Class** General Touch Up Coating

Camokote C51 Series is an acrylic enamel touch up coating which offers good durability and easy of application. It is formulated for use on both interior and exterior aircraft applications.

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

MIL-PRF-81352C Ty I

**Additives** Thinner

CM155

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

**Surface Preparation** Prepare substrate per OEM requirements. Contact your local 3Chem representative for assistance.

**Mixing Instructions**

Base	Thinner (Optional)	Mix Ratio
C511-XXXX (Gloss)	CM155	1:.15 (Max)
C512-XXXX (SEMI-GLOSS)	CM155	1:.15 (Max)
C513-XXXX (Flat)	CM155	1:.15 (Max)

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

**Film Thickness** 1-1.5 Mils DFT (2 Coats @ 1-1.5 DFT) Wet film thickness should be 1.5-2 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

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### Application Instructions

#### Dry Times

Temperature (Min/Max)	Thinner	Dust Free	Dry Hard	Full Cure
52-95°F (11-35°C)	CM155	10 Minutes	30 Minutes	18 Hours

#### Gloss Colors:

Apply one coat of material using a uniform spray pattern. Take care not to leave any dry areas or spots. Wet these areas again if necessary, to assure a uniform finish. Wait appropriate dry to tape or dry to handle time based on chart above.

#### Semi-Gloss / Flat Colors:

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.

**Theoretical Coverage** 300-350 sq. ft / gallon @ 1 mil 8-9m<sup>2</sup> / liter @1 mil  
\*Coverage based on 100% transfer efficiency rate

**Color** Available in all color ranges

**Gloss**  
Gloss colors: 90 minimum @ 60 degrees  
Semi-Gloss colors: 17-30 @ 60 degrees  
Flat/Matt Colors: Less than 5 @ 60 degrees

**Volatile Organic Compound** 290 – 338 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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