

Skykote K1 Series

Semi-Gloss & Flat Colors

High Solid Polyurethane Topcoat



Product Skykote K1 Series Polyurethane Topcoat – Semi-Gloss & Flat Colors

Item Class High Solid Polyurethane Topcoat

Skykote K1 Series is a two-component impact resistant polyurethane topcoat which provides high gloss and superior D.O.I. Skykote has been formulated to resist hydraulic fluids and many other chemicals. It offers excellent color and gloss retention.

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

58465/47 - AER-M-P.039 - AIMS 04-04-012 - ASN B77601 - BAEP 3529 - BAEP 3538 - BAEP 3540 - BAEP 3545 - BAEP 3546 - BS 2660 - BSX34 Ty B - DMS 2143, TY I, CL I, Comp C - DPS 4.50-187 - I.C. TO-37.05 - IFC 30-117-03 - OS 00 CD2 007 004 - PQ 10050 H – 004 - PQ 10050 H – 027 - PQ 10050 H – 075 - SMI 70068 - SMI 70070 - SMI 70089.1 - STD 175438 - TH 33.0150 Ty 1, Cl B - TH 5.721/1 - TH 5.721/5 - TH 5.721/6 - TN A.007.10012 G - TN A.007.10113 I Gr A - TN A.007.10158 - VV0605-51 - Z-12.380/AIMS 04-04-003 - Z-12.380/AIMS 04-04-012

Catalyst & Additives **Catalyst/Activator** **Additive**

322 (Semi-Gloss/Flat)	PS40 Accelerator
	CRL25 (Rolling/Brushing))

Use of Primers 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 application guide for detailed instructions or contact your local 3Chem representative for assistance.

Mixing Instructions

Base	Catalyst/Activator	Mix Ratio
K12-XXXX (Semi-Gloss)	322	1:1
K13-XXXX (Flat)	322	1:1

Semi-Gloss and Flat Colors:

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 yields either 2 gallons or 2 quarts). Must ensure mix ratio is exact to obtain desired semi-gloss or flat finish.

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- Induction Time** Although no induction time is needed. Once mixed together, ensure that admixed material is continuously stirred for at least 5 minutes before proceeding.
- 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
.5% By Volume	12 Minutes	2 Hours	4 Hours	4 Hours	6 Days
1% By Volume	10 Minutes	1 Hours	2.5 Hours	3 Hours	6 Days
1.5% By Volume	5 Minutes	30 Minutes	1 Hour	45 Minutes	6 Days

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

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Force Cure: If deemed necessary oven curing is possible to reduce dry to tape and handle times. After application, allow coating to air dry for 1 hour at room temperature (75° F), then force cure for 2 hours at 120° F.

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

Color Available in all color ranges

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

Volatile Organic Compound 340 – 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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PRODUCT TECHNICAL DATA SHEET