

Skykote K30 Series

High Impact Coating



Product Skykote K30 Series High Impact Coating

Item Class High Solid Polyurethane Topcoat

Skykote K30 Series is a two-component high solid impact resistant high solid polyurethane topcoat which provide high gloss and superior D.O.I. Skykote K30 has been formulated to resist hydraulic fluids and many other chemicals. It offers excellent color, gloss retention and increased flexibility.

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

AVN 7-004 - AVP 3-001 - AVP 3-006 - BAMS 565-009, Ty II, Cl A, Gr B -
BSX 34 Ty A & B - DMS 2143, TY I, CL I, Comp C - DOL 256 - MEP 10-061
- SMS 92, Ty 2, Gr B - STD 2932E Ty I & II

Catalyst & Additives

Catalyst/Activator	Thinner	Additive
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335	CS28 (Slow Dry)	PS40 Accelerator
323 (Semi-Gloss/Flat)	CM100 (Medium Dry)	CRL25 (Rolling/Brushing))
	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 application guide for detailed instructions or contact your local 3Chem representative for assistance.

Mixing Instructions

Base	Catalyst/Activator	Thinner	Mix Ratio
K31-XXXX (Gloss)	335	See Chart Below	1:1:.25
K32-XXXX (SEMI-GLOSS)	323	None	1:1
K33-XXXX (Flat)	323	None	1:1

Gloss Colors:

Shake (Base) for 15 minutes to assure no solid settlement remains in can. Add component B catalyst to component A paint first. Then add recommended thinner from chart below. Use of thinner depends on environmental conditions. Refer to thinner option chart below for detailed mixing information. Mix ratio for material is 1 part component A paint, 1-part component B catalyst and .25 parts thinner. (Kit including thinner should yield either 2.25 gallons or 2.25 quarts.

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 yield either 2 gallons or 2 quarts). Must insure 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, insure 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

Gloss Colors:

Only mix enough material to be applied on initial coat. Always add component B catalyst to component A paint then add recommended reducer based on environmental condition. Refer to thinner option chart above. Complete kit of material will yield 2.25 US Gallons (8.5 liters). 1-gallon component A paint, 1-gallon component B catalyst, 1 quart thinner (32 US oz. / 946 ml).

Apply one tack coat of material using a uniform spray pattern. Wait recommend time between coats based on chart above. Initial coat should be tacky before applying second coat. Applying second coat too early will lead to possible running of material. Waiting too long will lead to a dull finish. Mix enough material to be applied on second coat. Use same mixing instruction from initial coat above.

Apply a second medium wet coat using a uniform spray pattern. Second coat must appear wet and uniform once complete. Take care not to leave any dry areas or spots. Wet these areas if necessary, to assure a uniform finish. Wait appropriate dry to tape or dry to handle time based on chart above.

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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

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 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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