CamoKote C20 Series

Semi-Gloss & Flat Colors

High Solid Polyurethane Topcoat

Product

CamoKote C20 Series High Solid Polyurethane Topcoat - Semi-Gloss & Flat Colors

Item Class

High Solid Polyurethane Topcoat

CamoKote C20 Series is a high solid polyurethane topcoat formulated to provide superior resistance and excellent coverage for military and defense applications. With an average 50% solid per gallon; it also offers better coverage than most other polyurethane coatings on the market. 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:

DMS 2115 Ty I - DPM 6330-01 - G37.5531 - GP110AEE - GP110AEF - MEP 10-69 - MIL-PRF-85285F Ty I-IV, Cl H, Form M, Gr N - Z-12.390/MIL-PRF-85285 - Z-12.520/SP-J-513-A-0014 Ty I - Z-12.380/SP-J-513-B-0309 - SP-J-513-C-0083 Ty I, Cl A - SP-J-513-C-0083 Ty I, Cl B

Catalyst & Additives

Catalyst/Activator	Additive
415 (Semi-Gloss/Flat)	PS40 Accelerator
	CRL25 Rolling/Brushing
	CRL28 Rolling/Brushing High Temperatures

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	Mix Ratio
C202-XXXX (Semi-Gloss)	415	1:1
C203-XXXX (Flat)	415	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, ensure that admixed material is continuously stirred for at least 5 minutes before proceeding.

Spraying Viscosity Semi-Gloss/Flat Colors: 18-22 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°	38°
Temperature Fahrenheit	52°	100°
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

Temperature	PS40	Wet-Edge	Time Between Coats	Dry to Tape	Dry to Handle	Full Cure
52-65°F (11-18°C)	0.25%	50 Min	1-1.5 Hours	8-10 Hours	12 Hours	6 Days
66-75°F (19-23°C)	0.20%	40 Min	45-60 Min	7-8 Hours	9-10 Hours	6 Days
76-85°F (24-29°C)	0.10%	40 Min	45-60 Min	7-8 Hours	9-10 Hours	6 Days
86-100°F (30-38°C)	N/A	30 Min	45-60 Min	6-7 Hours	7-8 Hours	6 Days

*** Do not use PS40 accelerator in temperatures over 85°F (29°C)**

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.

For organic yellow, orange, red, and some green, and blue colors it is necessary to apply a coat of solid white or light gray C20 Series prior to final color application.

Application Instructions PS40 Accelerator (Fast dry additive mix options for touch up applications)

PS40 Accelerator	Dry Between Coats	Dry to Handle	Dry Hard	Pot Life	Full Cure
0.25% By Volume	12 Minutes	2 Hours	4 Hours	4 Hours	6 Days
0.30% By Volume	10 Minutes	1.5 Hours	3 Hours	3 Hours	6 Days
0.40% By Volume	5 Minutes	45 Minutes	1 Hour	45 Minutes	6 Days

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

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

Gloss Semi-Gloss colors: 17-30 @ 60 degrees
Flat/Matt Colors: Less than 5 @ 60 degrees
*Also available is custom gloss ranges

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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