



## CAMOKOTE C20 SERIES - HIGH SOLID POLYURETHANE TOPCOAT

### 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 80% solid per gallon; it also offers better coverage than most other polyurethane coatings on the market. This product is also formulated to surpass conventional polyurethanes with superior chemical resistance and flexibility

### Specifications

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

- Z-12.390/MIL-PRF-85285
- MIL-PRF-85285E, Ty I-IV CI H
- GP110AEE - GP110AEF
- G37.5531
- SP-J-513-C-0083 Ty I, CI B
- 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, CI A

\*\* (Please check 3chem.com for complete specifications list)

### Catalysts & Additives

CATALYSTS	THINNERS	ADDITIVES
410	CM120 (SLOW DRY)	PS40 ACCELERATOR
415 (SEMI-GLOSS AND FLAT)	CM100 (MEDIUM)	CRL25 (ROLLING ADDITIVE)
	CF1 (FAST DRY)	

\* Available in various sizes and containers (W=Quart, X=Gallon, Y=Gallon Plastic)

### Use of Primers

3Chem recommends use of P1019 (High Solid Epoxy Primer) with this system. 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 Glair application guide for detailed instructions or contact your local 3Chem representative for assistance.

### Mixing Instructions

BASE	CATALYST	THINNER	MIX RATIO
C201-XXXX(GLOSS)	410	See Chart Below	1:1:.25
C202-XXXX(SEMI-GLOSS)	415	See Chart Below	1:1:.25
C203-XXXX(FLAT)	415	See Chart Below	1:1:.25

\*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.

### 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

16-18 SECONDS WITH #2 ZAHN CUP



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**Pot Life**

7 HOURS (21 DEGREES C, 70 DEGREES F)

\*Pot life is reduced depending on amount of fast solvent and accelerator used.

**Film Thickness**

2-3 MILS (1-1.5 MIL per coat wet film thickness)

**Application Instructions**

**Temperature and Humidity**

	MIN	MAX
TEMPERATURE C	11	35
TEMPERATURE F	52	95
HUMIDITY	33%	74%

**Spray equipment**

SPRAY GUN TYPE	TIP SIZE	CAP PRESSURE	POT PRESSURE
CONVENTIONAL AIR GUN	1.2 - 1.8 mm	45 – 60 psi	10 – 20 psi
HVLP	1.0 to 1.4 mm	10 – 12 psi	10 – 20 psi
ELECTROSTATIC AIR GUN	1.2 or 1.5 mm	45 – 60 psi	15 – 20 psi

**Dry Times:**

(Thinner Options)

Temperature
52-65°F (11-18°C)
66-85°F (19-29°C)
86-95°F (30-35°C)

Thinner	Wet-Edge	Time Between Coats	Dry to Tape	Dry to Handle	Full Cure
CF3	40 Min	30-50 Min	5-6 Hours	7-8 Hours	6 Days
CM100	45 Min	30-50 Min	5-6 Hours	7-8 Hours	6 Days
CM120	45 Min	30-50 Min	8 Hours	8-10 Hours	6 Days

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 to 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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### Application Instructions

PS40 Accelerator (Fast dry additive mix option)

PS40 Accelerator
2% By Volume
3% By Volume
5% By Volume

Dry Between Coats	Dry to Handle	Dry Hard	Pot Life	Full Cure
15 Min	2 Hours	4 Hours	4 Hours	6 Days
12 Min	1.5 Hours	3.5 Hours	3.5 Hours	6 Days
8 Min	1 Hour	2.5 Hours	1.5 Hours	6 Days

**DO NOT USE PS40 WHEN COATING A COMPLETE AIRCRAFT OR LARGE SURFACE.** This additive is only intended for applications on small areas, parts, or touch ups.

PS40 Accelerator should only be added to admixed material (meaning comp A paint, comp B Catalyst and thinner). Volumes indicated in chart above are represented in total admixed amount of material used. For example: If mixing total 30oz of material plus required PS40 @2%; mix will be as follows: 14oz comp A paint, 7oz comp B catalyst, 7oz of thinner, plus .56oz of PS40 (actual yield will be 28.56oz).

### Force Cure

First air dry applied product for one hour @ 75° F (24° C)

### Recommendations:

Then, force cure for 2 hours @ 120° F (49° C)

### Theoretical Coverage

850-900 sq. ft. / gallon @ 1 mil  
20-22 m2 / liter @ 1 mil  
\*Coverage based on 100% transfer rate

### Color

AVAILABLE IN ALL COLOR RANGES

### Gloss

90 MINIMUM @ 60 DEGREE

### Volitile Organic Compound

C20-XXXX (CLEAR) 400g/l  
C20-XXXX (ALL OTHER COLORS) 400g/l  
C20-XXXX (SEMI-GLOSS) 400g/l  
C20-XXXX (FLAT) 400g/l

### Shelf Life

24 MONTHS (IF STORED IN CLIMATE CONTROLLED ENVIRONMENT BETWEEN 60-80 F) \*Product may be re-certified upon inspection by 3Chem.

### Safety Instructions

READ SAFETY DATA SHEET (S.D.S) AND PRODUCT LABEL BEFORE UTILIZING THIS PRODUCT. SDS IS AVAILABLE AT [www.3chem.com](http://www.3chem.com).