



E4C SERIES - HIGH SOLID EPOXY TOP COAT



Item Class

High Solid Epoxy Top Coat

E4C Series is a two component, chemically cured high solid epoxy top coat formulated per aerospace and military requirements. It provides excellent resistance to various chemicals including hydraulic fluids, solvents, aerospace fuels, phosphates, and many other corrosion causing agents. It also good coverage and excellent adhesion.



Specifications

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

BMS 10-11, Ty II, Cl A & B, Gr A & D
DMS 2433, Ty I, Comp C
DHMS C4.11
EMS 93284 C Cl A
MIL-PRF-22750 Ty I-II, Cl H Gr A & B
MCS 9010
Z-12.361/BMS 10-11, Ty II, Cl B
DEF-STAN-80-161



Catalysts & Additives

530/540 (GLOSS / SEMI-GLOSS & FLAT)	CM100 (MEDIUM)
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Use of Primers

Recommended for use with 3Chem primers P-1000R (green), P-1004 (yellow) conventional epoxy and P-1019 high solid epoxy.



Surface Preparation

Prepare substrate per OEM requirements. Proper treatment and cleaning of surface is important to insure good adhesion.



Mixing Instructions

BASE	CATALYST	SOLVENT	MIX RATIO
E4C11-XXXX (GLOSS)	530	CM100	1:1:.25
E4C12-XXXX (SEMI-GLOSS)	540	CM100	1:1:.25
E4C13-XXXX (FLAT)	540	CM100	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. Mix ratio for material is 1 part component A paint, 1 part component B catalyst and .25 parts thinner. (Admixed material 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 5-10 minutes before proceeding.



Spraying Viscosity

17-21 SECONDS WITH #2 ZAHN CUP



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Pot Life

6 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)

Application Instructions

Temperature and Humidity

	MIN	MAX
TEMPERATURE C	14	37
TEMPERATURE F	52	110
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:

Dry to touch:	45 minutes
Dry to tape:	6-8 hours
Full cure:	7 days

**Since environmental conditions vary and play a vital role in determining the appearance of the final product, 3Chem recommends the spraying of test panels before applying this product.

Theoretical Coverage

325 - 575 sq. ft. / gallon @ 1 mil *Coverage based on 100% transfer rate

Color

AVAILABLE IN ALL COLOR RANGES

Gloss

90 MINIMUM @ 60 DEGREE FOR GLOSS COLORS

Volitile Organic Compound

340 g/l max per U.S gallon

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.