



## SKYKOTE K1 SERIES - HIGH IMPACT COATING



### Item Class

High Impact Coating

Skykote K1 Series is a two-component high solid impact resistant polyurethane top coat which provide 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:

BSX34 Ty B

BAEP 3545

SMI 70089.1

AIMS 04-04-012

ASN A4196

I.C. TO-37.05

MEP 10-058

PQ 10050 H - 110

Z-12.412/AIMS 04-04-023



### Catalysts & Additives

CATALYSTS	THINNERS	ADDITIVES
321 (GLOSS)	CS28 (SLOW DRY)	PS40 (Accelerator)
322(SEMI-GLOSS AND FLAT)	CM100 (MEDIUM)	CRL25 (ROLLING ADDITIVE)
	CF1 (FAST DRY)	



### Use of Primers

Recommended primers are P-1000 (conventional epoxy green) and P-1004 (conventional epoxy yellow).



### 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
K11-XXXX (Gloss colors)	321	See Chart Below	1:1: .25
K12-XXXX (Semi-Gloss colors)	322	See Chart Below	1:1: .25
K13-XXXX (Flat colors)	322	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.

**Note:** When using CM120 thinner an additional 2.5% may be required in order to achieve required viscosity. (1:1: .30 MIX RATIO)



### 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.



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### Spraying Viscosity

16-18 SECONDS WITH #2 ZAHN CUP

### 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 PRESSUR
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

#### (Thinner Options)

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	45 Min	30-50 Min	5-6 Hours	7-8 Hours	6 Days
86-95°F (30-35°C)	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).

### Theoretical Coverage

850-900 sq ft / gallon @ 1 mil  
\*Coverage based on 100% transfer rate

### Color

AVAILABLE IN ALL COLOR RANGES

### Gloss

90 MINIMUM @ 60 DEGREE

### Volatile Organic Compound

400 g/l (Admixed)  
\*\*\*Actual VOC varies by color

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