



PU-601 Barthane Polyurethane Enamel Camouflage Colours APAS 0502

PRODUCT DESCRIPTION

A two pack non-yellowing polyurethane finish that provides an extremely tough, hard, durable and chemical resistant coating. For camouflage purposes it is used in conjunction with EX-408 Zinc Phosphate Epoxy Primer 408-6916. PU-601 Barthane colours are designed to be in compliance with APAS-0502/1 and EX-408 Zinc Phosphate Epoxy Primer to APAS – 0502/5.

SUBSTRATES & PREPARATION



Substrates should be prepared in accordance with APAS 0502 specifications. Specifications can be found at: www.apas.gov.au/SpecList.asp

As per APAS 0502, ferrous and non-ferrous substrates must then be primed with 408-6916 EX-408 GREY prior to application of the PU-601 Barthane topcoat. Refer to the 408-6916 EX-408 GREY Technical Data Sheet for full details. For other substrate types contact a PPG Technical Representative for advice.

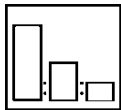


Before and after any sanding operation, the substrate must be thoroughly degreased using AA-6822 *Protec* Heavy Duty Wax & Grease Remover to remove all traces of dirt, oil, grease, silicone, wax etc.

PRODUCTS

PU-601 Camouflage Colours Pack A		601-1556 Camouflage Green US Fed 595 # 34088 601-5419 Camouflage Brown US Fed 595 # 30219 601-5409 Pilbara Brown US Fed 595 # 30109 601-7238 Black US Fed 595 # 37038 601-8775 White (Interior) US Fed 595 # 37875
PU-601 Pack B		601-9074 Barthane Hardener
Potlife Extender		636-9419 Barrier Potlife Extender
Reducers	<i>Normal conditions</i>	145 Barthane Reducer 195 Barthane Electrostatic Reducer
	<i>Hot conditions</i>	178 Barthane Extra Slow Reducer
	<i>For Brushing</i>	PUR20 Polyurethane Normal Reducer

MIXING RATIO BY VOLUME



PRODUCT

PU-601 Pack A

601-9074

Reducer

PARTS

3

1

20-30%

30-40%

30-40%

Green and Brown, Single colour application

Black, Single colour application

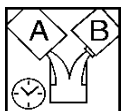
Brown and Black, DPP application

Refer to 601 Reducer Guide for suggested reducer selection for application temperature.

Mix Pack A and Pack B. Stir thoroughly.

Add reducer and stir thoroughly.

POTLIFE



Catalysed material is useable for up to 4 hours at 25°C

In temperatures greater than 32°C, 636-9419 Barrier Potlife Extender can be added to the mixed paint to increase potlife. At this temperature or above, mix 636-9419 at 40 parts to 60 parts by weight with reducer, before thinning the mixed PU-601 Barthane. Use of the 178 Barthane Reducer Extra Slow will also improve the open time of the film at high temperatures. 636-9419 Barrier Potlife Extender and mixtures of this with reducer must be stored in plastic containers as the 636-9419 Barrier Potlife Extender will react with metal.

SPRAYGUN



CONVENTIONAL

SETUP

- GRAVITY 1.4 mm - 1.6 mm
- SUCTION 1.4 mm - 1.8 mm
- CAMOUFLAGE 1.2 mm SATA MINIJET RP

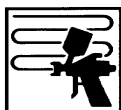
SPRAY PRESSURE

- CONVENTIONAL 1.5 - 3.0 bar (150 - 300 kPa, 22 - 44 psi)

PRESSURE POT / DOUBLE DIAPHRAGM (GREEN ONLY)

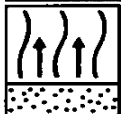
- SATA 1000K 1.1 mm - 1.3 mm
- SATA 3000K 1.1 mm - 1.3 mm

APPLICATION & FLASH OFF



SPRAY:

- FOR 601-1556 CAMOUFLAGE GREEN, APPLY 1 MEDIUM + 2 FULL COATS TO DRY FILM THICKNESS 50 - 75 MICRONS.
- FOR OTHER DISRUPTIVE PAINT PATTERN COLOURS, APPLY 2 FULL TO WET COATS TO DRY FILM THICKNESS 35 - 50 MICRONS.



Allow 30 - 45 minutes flash off between coats or until completely eggshell in appearance (dependent on film build and ambient conditions) .

BRUSH APPLICATION:

No thinning is required, although up to 10% PUR20 Polyurethane Reducer Normal may be added for easier brushing on large areas.

SPECIAL NOTE FOR 0502 SYSTEMS DISRUPTIVE PAINT PATTERN (DPP):

Application of the DPP should be applied in a precise manner with minimal overspray when colours are overlapped.

After the application of the 601-1556 Green the surface should be thoroughly dry before attempting to apply the DPP. It is recommended to allow to dry overnight or bake for 1 hour at 25°C before applying the DPP. When a unit has been left for longer than 72 hours, a thorough sand is necessary, some applicators will then camouflage using all 3 colours on the same application.

The pattern can be mapped out several ways depending on the applicator. Stencils are a very accurate method of chalking out the pattern, and laser images are another way of mapping out the pattern.

Colour identification lettering should always be applied to each section to ensure the correct camouflage colours are used.

First coat camouflage application requires adjusting the gun fan to spot painting, pointing the gun to the inner center of the pattern follow the outline of the pattern, ensuring minimal overspray on the outer edge. Continue to work the edge towards the center of the pattern, once there is enough distance away from the edge the gun fan can be adjusted to a larger fan so you can successfully complete the fill with minimal overspray beyond the outer edge. Continue this method over the whole vehicle rotating the camouflage colours, once completed all camouflage areas must be thoroughly dried to a uniform eggshell appearance before the second coat is applied and a 35-50µm dry film thickness is achieved.

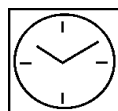
FILM BUILDS AND COLOUR SEQUENCE



**APAS 0502/1
CONVENTIONAL NIRR CARC COATING**

	35-50um	601-5419 or 601-7238
	50-75um	601-1556
	35-50um	408-6916
Total Film Build	120-175um	Full DPP coating

DRYING TIMES



AIR DRY (25°C)

- SURFACE DRY: 1 hour
- HARD DRY: 8 hours

Note: Drying times will vary dependent on temperature, flash off between coats and the number of coats used.

FORCE DRY

Please contact your local PPG Representative to discuss baking times and temperatures, as these vary depending on metal thickness and oven performance. Typical bake requirement is 45 minutes at 60°C (metal temperature).

Coating becomes fully cured after seven days.

RECOAT



Can be re-coated after a minimum of 16 hours.

After maximum recoat time of 72 hours at 25°C, a thorough sand with mechanical means is necessary before re-coating. Use P240-320 grade abrasive.

Before and after any sanding operation, the substrate must be thoroughly degreased using AA-6822 Protec Heavy Duty Wax & Grease Remover to remove all traces of dirt, oil, grease, silicone, wax etc.

TECHNICAL PARAMETERS

VOLUME SOLIDS

601-1556 Camouflage Green US Fed 595 # 34088	35.7%
601-5419 Camouflage Brown US Fed 595 # 30219	34.3%
601-5409 Pilbara Brown US Fed 595 # 30109	33.5%
601-7238 Black US Fed 595 # 37038	33.8%
601-8775 White (Interior) US Fed 595 # 37875	41.9%
601-9074 Barthane Hardener	70.3%

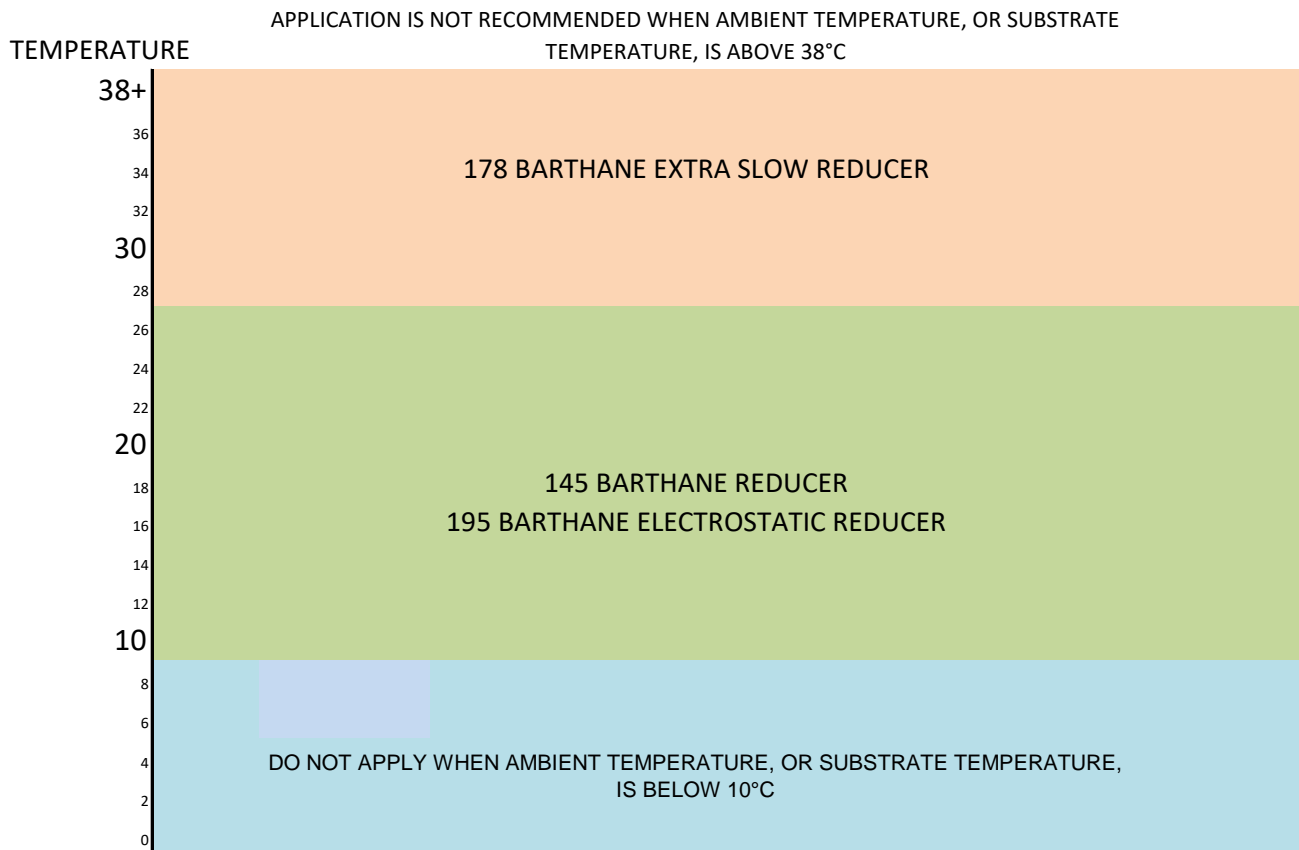
COVERAGE (RFU)

APAS 0502 11.7 - 12.7 metres squared per litre (m²/L) depending on colour

EQUIPMENT CLEANING

After use, clean all equipment thoroughly with cleaning solvent or thinner.

601 BARTHANE REDUCER GUIDE



This chart is provided as an approximate guide to when the different thinners should be used. Differences in application technique and the size of the components being painted will influence the optimum thinner choice.

HEALTH AND SAFETY

Please refer to Safety Data Sheet (SDS) for full Health and Safety details, as well as product can labels.

PPG 2K PU hardeners and activated products contain isocyanate and therefore particular safety precautions must be taken; please refer to SDS for full health and safety details.

This product is for professional use only. The information given in this sheet is for guidance only. Any person using the product without first making further inquiries as to the suitability of the product for the intended purpose does so at his or her own risk and we can accept no liability for the performance of the product or for any loss or damage (other than death or personal injury resulting from our negligence) arising out of such use. The information contained in this sheet is liable to modification from time to time in the light of experience and our policy of continuous product development. Drying times quoted are average times at 25°C/77°F. Film thickness, humidity and shop temperature can all affect drying times.

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