



## 342 CAMOUFLAGE ENAMEL

Alkyd, Disruptive Pattern Paint (DPP)

### PRODUCT DESCRIPTION

A low gloss, heat and petrol resistant alkyd finishing enamel with specified Infra Red Reflectance (IRR) properties for use on service vehicles and equipment to provide a disruptive pattern (DPP) system. Approved to APAS – 0165/1

### AVAILABLE COLOURS

342-1166 Camouflage Green  
342-5265 Camouflage Brown  
342-7165 Camouflage Black

### PRODUCTS

342 Camouflage Enamel	Colour	
Reducer	AER20	Alkyd Enamel Reducer Normal
	AER30	Alkyd Enamel Reducer Slow (For hot Conditions)

### SUBSTRATES AND PREPARATION



Apply over an APAS-0162/1 Zinc Phosphate Primer

Ensure that all surfaces to be coated are clean and dry and free from all traces of oil and grease.



- **Bare Steel:** Treat new steel sheet with 971 metal Conditioner and degreaser then prime with 456 Zinc Phosphate Metal Primer.
- **Bare Aluminium:** Bare aluminium surfaces should be thoroughly cleaned using AA-6822 Heavy Duty Wax and Grease remover before sanding. If necessary use a high grade scouring pad to remove heavy areas of grease and imperfections. All this is to be done in a wipe on wipe off motion using clean rags.

Once dry, thoroughly abrade the surface using P240 grit on an orbital sander or by hand rubbing using P320.

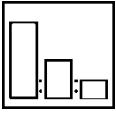
Once sanded the aluminium should be thoroughly blown down then cleaned with a 1:1 solution mix of Methylated Spirits and clean water, using a wipe on wipe off action this must be repeated until no residue shows on the cleaning cloths.

**\*NOTE:** The prepared aluminium must be primed within 6 hours after the preparation process; failure to do this will allow the aluminium to re-oxidise.

Application of EPR Etchpro etching primer is recommended prior to the application of 456 Zinc Phosphate Metal Primer.

- **Existing Paintwork:** Wash thoroughly with AA-6822 Heavy Duty Wax and Grease Remover and sand with P320 grit sandpaper. Treat all bare metal areas with 971 Metal Conditioner and degreaser then prime with 456 Zinc Phosphate Metal Primer.

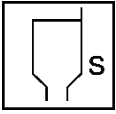
## MIXING RATIO BY VOLUME



By volume:

342 Camouflage Enamel	100 Parts
Reducer	15 - 20%

## SPRAY VISCOSITY



16 – 20 seconds (DIN 4) at 25°C

## SPRAYGUN



### **Conventional Setup**

- Suction 1.4 – 1.6 mm
- Gravity 1.6 – 1.8 mm

### **Spray Pressure**

30-36 psi  
200 - 300 kPa

## APPLICATION & FLASH OFF



Spray out a light even coat and allow to flash off for 10-15 minutes before applying another coat.

AVOID HEAVY COATS.

**\*NOTE:** Do not apply when temperature is either below 10°C or within 3 degrees above the dew point or relative humidity exceeds 85%.

10-15 minutes between coats @ 25°C.  
(dependant of film build – ensure the first coat has dried completely eggshell before application of the 2<sup>nd</sup> coat)

## DRYING TIMES



Drying of 342 Camouflage Enamel is very dependent on temperature and humidity and it will not cure at temperatures below 5°C, or within 3°C of the dew point.

**Air Dry Only:**

Surface Dry – 30 minutes
Hard Dry – 3-4 hours
Recoat – 48 hours

## RECOAT



Tape and recoat times refer to a 40 micron dry film dried for a minimum of 48 hours at 25°C and 60% relative Humidity.

## TOTAL DRY FILM BUILD

40 - 50µm

## TECHNICAL PARAMETERS

**Theoretical Coverage:** 10 sq. metres per litre at 30µm dry film thickness  
**Volume Solids:** 35%

Material losses during mixing and application will vary and must be considered when estimating requirements.

### Performance Guidelines

- Drying times will vary dependent on temperature, flash off between coats, number of coats used.
- Is suitable for brush application in small areas.
- 35% Volume Solids (Depending on Colour).
- Apply 90-100 microns WFT/30 microns DFT
- Avoid heavy coats as this will result in high gloss levels.
- DO NOT attempt to wash the painted surface unless thoroughly dry, a 3-4 week drying period is recommended.
- DO NOT use 103 All Purpose Thinner in 342 Camouflage Enamel as this could lead to wrinkling and re-coat problems.
- Do not leave painted surfaces in hot sun to dry.

## EQUIPMENT CLEANING

## HEALTH AND SAFETY

Please refer to Material Health and Safety Datasheets 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 20°C/68°F. Film thickness, humidity and shop temperature can all affect drying times.

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