



Simco Coatings Inc.

Manufacturer of Military Spec.,  
Corps of Engrs. Spec, Industrial, &  
Marine Coatings

## TECHNICAL DATA SHEET

### **MIL-C-46168 CARC (CHEMICAL AGENT RESISTING) ALIPHATIC POLYURETHANE COATING**

**DESCRIPTION:** A two-part lead & chromate free, CARC (Chemical Agent Resisting), polyester/aliphatic polyurethane coating for use as both a camouflage and non-camouflage finish coat on military combat equipment.

**CONFORMANCE:** Conforms to military specification MIL-C-46168 Rev. D, Type-II

#### **TECHNICAL DATA**

<b>COLORS &amp; FINISH:</b>	Fed-std-595 Camouflage/Lusterless Finish
<b>GENERIC TYPE:</b>	Polyester/Urethane
<b>MIXING RATIO:</b>	4: 1 by volume
<b>SOLIDS BY WEIGHT:</b>	65%
<b>SOLIDS BY VOLUME:</b>	55%
<b>VOLATILE ORGANIC COMPOUNDS (VOC):</b>	3.5 lbs./gallon or 420 g/l
<b>RECOMMENDED DRY FILM THICKNESS:</b>	1.5 – 2.0 mils
<b>FLASH POINT:</b>	22 °F
<b>THEORETICAL SPREADING RATE:</b>	250 sq. ft. /gal @ 2.0 Mil DFT
<b>DRYING TIME @ 75°F:</b>	
<b>(A) SET TO TOUCH, MINUTES:</b>	30 minutes
<b>(B) DRY HARD, HOURS:</b>	3 hours
<b>(C) DRY THROUGH, HOURS:</b>	4 hours
<b>SPECULAR GLOSS 60 DEGREES:</b>	0.5 TO 3.0 depending upon the color
<b>POT LIFE @ 25°C/77°F:</b>	2 hours
<b>RECOMMENDED PRIMERS:</b>	MIL-PRF-23377 & MIL-DTL-53022
<b>THINNER:</b>	MIL-T-81772 Type I Polyurethane Thinner

**RECOMMENDED SUBSTRATE CONDITION:** Apply over recommended primers: MIL-PRF-23377 or MIL-DTL-53022. Surface must be clean and free of grease, dirt, oil, rust and other contaminants that could interfere with proper adhesion.

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## **MIL-C-46168 CARC (CHEMICAL AGENT RESISTING)** **ALIPHATIC POLYURETHANE COATING**

### **MIXING & INDUCTION TIME REQUIREMENT:**

Using the proportion of 4:1 of Component A to Component B, do the following: Agitate Component A by itself with a hand spatula, and then slowly pour in Component B (Hardener/Activator) and mix till mixture is smooth and uniform. At a temperature range of 70°F – 80°F, let mixture stand for 15 minutes after mixing both components and before application. Colder temperatures will require a longer induction time. If using thinner, only use MIL-T-81772 Type I Polyurethane Thinner (maximum of 5% by volume) and only add it after Component A & Component B have been thoroughly mixed together.

### **APPLICATION DATA:**

Apply by conventional or airless spray, brush, roller. DeVilbiss MBC-510 gun with E: E tip and needle and 765 air cap.

Details for Airless Spray: Output fluid pressure: 120 bar (atm) 1740 PSI. Min. nozzle orifice: 0.013"

### **SAFETY PRECAUTIONS:**

- (A) Use normal precautions such as gloves and facemasks.
- (B) Adequate ventilation must be maintained.
- (C) Explosion proof lights and electrical equipment.
- (D) Non-sparking shoes and tools for workers in area.
- (E) This product contains flammable materials. Forbid all flames, smoking and welding in work area.
- (F) Avoid breathing of vapor, contact with skin and eyes. If product comes in contact with skin or eyes, wash thoroughly with water and obtain immediate medical attention.

### **NON-WARRANTY:**

The technical data listed herein has been compiled for your convenience and guidance, and is based upon our experience and knowledge. However, since we have no control over the use of this information or this product, no warranty, expressed or implied, is intended or given. Simco Coatings, Inc. assumes no responsibility whatsoever for coverage, performance or any other damages, including injuries resulting from us of this information or of products recommended herein.

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