

## NEUTRAL PEROXIDE BASED COMPOSITE SAFE PAINT REMOVER

DEKOTE is a next generation chemistry for paint removal products that will obsolete the old method of chemical paint stripping. DEKOTE works by entering the pores or cross-linking of the coating to penetrate to the substrate where it reacts to release the coating. This product is approved by the Air Force for removing composite coatings from E-3 AWACS weapon system. DEKOTE has been tested for use on various composite substrates including fiberglass / epoxy resin, quartz / polyamide resin, graphite / epoxy resin, and Kevlar / phenolic resin.

### Qualified Product Listing:

USAF T.O. 1-1-24

USAF T.O. 1E-3A-3-1

### Unique Product Features

- Environmentally Safe and Effective Paint Removal Product
- Stable, non-hazardous and non-toxic components, HAPS free product
- Available in five and fifty-five gallon and 275 gallon Tote containers
- DEKOTE's unique formula offers a safe and effective alternative to the sanding method saving numerous labor hours for end users.



DEKOTE also works great on all powder and e-coatings, including:

- Thermoset: epoxies, epoxy-polyester hybrids, urethane polyesters, acrylic-urethane, and TGIC polyesters
- Thermoplastic: polyurethane, polypropylene, nylon, PVC, polyester
- Alkyds, polysulfidated, polyamide, and polyamine

### Surface Preparation and Application Instructions

Prior to chemical stripping, mask any opening and damaged areas with broken skin on the working surface, as necessary to prevent any stripped coating or stripping chemicals from contaminating the non-working or damaged areas of the work part. Use aluminum foil tape and plastic sheeting to mask the edge of work part prior to applying chemical strippers. In addition, plug any attachment bushings and mask with aluminum foil tape.

1. Apply chemical stripper, P/N DEKOTE, so the area to be stripped is completely covered with a thin tack coat, and allow dwelling for 45 minutes. Then apply a second much heavier, thicker application of the chemical stripper; **making sure the entire surface is coated**. Spray application using airless spray equipment listed as below is recommended to achieve uniform coverage:
  - Pump assembly, 5:1 ratio, MONARK, 224343, GRACO, or equivalent
  - Spray gun, manual, airless, Model 510, 236995, GRACO, or equivalent
  - Spray tip nozzle, HD RAC Tip #3, GRACO, or equivalent
  - Spray tip extension wand, 243295, GRACO, or equivalent

2. Operating pump pressure should be adjusted between 60 and 90 psi in order to provide the best spray pattern at the nozzle tip without atomizing the stripper. **Reapply as necessary to keep areas wet in order to achieve optimum stripping efficiency**. Within 2-4 hours both the rain erosion coat and anti-static coatings should break their adhesive bond completely away from the base primer coating (Red wash primer or MILPRF23377) as seen in the picture below.

Required dwell time is dependent, in part, on the following factors:

- Temperature: The recommended temperature range for chemical stripping is (70 – 75) degree F. Generally, increasing the temperature at which stripping is performed will increase stripping effectiveness. However, higher ambient temperature will also cause the solvents in the stripper to evaporate more quickly. Accordingly, more frequent reapplication of the stripper may be required at

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### 3. Surface Preparation and Application Instructions (continued)

higher temperature. Lower temperature will decrease stripping effectiveness and increase the time required to strip. A temperature of 55 degrees F may require twice the time as that required at 75 degree F

- Coating age
  - Exposing of coating to ultraviolet radiation
  - Air flow: Increasing the air flow will increase the solvent evaporation; thus slowing down the stripping activity
  - Coating type and its thickness
  - Allow the stripper dwelling on the working surface until the coating is disbonded and can be easily scraped. The dwell time required is approximately 4 hrs for this to occur.
4. Use a plastic or wooden scraper to scrape the disbonded coatings; being careful not to damage the composite substrate surface. Avoid scraping perpendicularly across edges of the surface plies.
  5. Reapply stripper and allow a dwell time of no longer than 30 minutes, at which time the red wash primer will become soft. Abrade stripper and red wash primer using very fine or fine grade Scotch-Brite pads as pictured below. A soft bristle brush may also be used in place of the Scotch-Brite pads (also pictured below).
  6. Remove final application of stripper by pressure spray rinsing with hot water (110 – 115) degree F.
  7. After pressure spray hot water rinse, solvent wipe clean the working surface using MPK (Methyl Propyl Ketone).
  8. Rinse thoroughly with clean water. Hot water (120 degree F maximum) is preferred, but not required. Rinse at least three (3) times using a pressure spray or flushing.

**OPTION:** Rinse by swabbing with clean wet rags or sponges.

9. Remove minor paint residue, such as around attachment holes, by scuff sanding using very fine grade Scotch-Brite pads.

**\* IMPORTANT NOTE:** Once the Rain Erosion Coating and Anti-Static have been removed it is not necessary to completely remove the primer from the composite substrate. Simply reapply the Dekote for 30 minutes and follow the above written procedure to clean-up the surface of any paint residue. This will ensure protection of the substrate and prevent removal of resin from the composite matrix.



### Health and Safety

Always read material safety data sheet before using this product. Product should always be used with adequate ventilation. Proper safety equipment should also be utilized. Skin will bleach when it comes in contact with product. If skin exposure occurs, rinse with water for 10-15 minutes.