

**GlobalStar**

**P9.3.K1**

**HS Gray Epoxy Primer**

**GlobalStar**  
**INDUSTRIAL**



Rev: 05222026

## Technical Data Sheet

### Description

P9.3.K1 is a 2K, South Coast compliant, high build, anti sag epoxy primer with built in corrosion resistance and excellent adhesion onto properly prepared hot or cold roll steel, aluminum and many other non-ferrous metals, fiberglass and over properly prepared 2K painted surfaces.

### Suggested Use

As a wet on wet sealer or a full bodied sand-able primer.

Over any of the above mentioned properly prepared substrates where:

- High level of corrosion resistance is needed.
- Excellent adhesion is needed.
- High productivity is required.
- Excellent performance when applied with airless, air-assist airless pressure pot, cup gun or brush or rolled.

### Components

P9.3.K1

GSR-F, GSR-M, GSR-S

EH.001

Base

Fast, Medium, Slow Reducer for National Rule Applications  
Hardener

### Field Applications

- Semi-trucks
- Structural steel
- Coachworks (Buses)
- Work panel trucks
- Trailers and frames
- Construction equipment

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- Cement trucks and snow plows
- Many OEM applications
- Oil Field Equipment
- Aircraft and marine

### **Mixing Ratio**

**Mix:**

One (1) part P9.3.K1 Epoxy Base to one (1) part EH.001 Epoxy Hardener. Reduce 0%-25% with selected reducer.

### **Application**

**Apply:**

one to two medium wet coats, allow 10-20 minutes flash between coats.

Or Apply one medium light coat followed by a medium cross coat.

**Spray Gun:**

HVLP Gravity Feed – 1.4 – 1.7mm tip and needle  
Pressure Pot HVLP – 1.0 – 1.2mm tip and needle  
Air Assist Airless – 1.0 – 1.2mm tip and needle  
Conventional – 1.5 – 1.8mm tip and needle  
Airless – 310 – 610 – 313 – 613 nozzle

**Film Build:**

50-100 microns – (2.0 – 4.0 mils.)

### **Dry Times**

**Dust Free:**

20-30 minutes @ 20° C (68° F)

**Dry to Touch**

3-4 hours @ 20° C (68° F)

**Total Hardness**

48 hours @ 20° C (68° F)

**Force Dry**

30 minutes @ 60° C (140° F)

### **Surface Preparation**

**Ferrous metals:**

**Best Case**

SA2 sandblast Blow all dust and contaminates off and apply P9.3.K1 primer within 8 hours.

**Second Best Case**

Hot Phosphate wash system, blow dry and apply P9.3.K1 primer

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Within 8 hours.

Third Best Case

Careful mechanical abrasion. Clean all dust, oil residue, finger prints and contaminates before and after mechanical abrasion with a clean drying wax and grease removal solvent making sure all residue is removed then apply P9.3.K1 primer within 4 hours.

**Aluminum:**

Clean surface with clean drying wax and grease remover, apply P9.3.K1 Epoxy Primer within 4 hours.

**Galvanized Steel:**

Clean all dust, oil residue, and contaminates from surface using a Clean drying wax and grease remover. Light Sanding (320P grit) Clean again with clean drying wax and grease remover using a wipe and dry process, apply P9.3.K1 epoxy primer as directed.

**VOC**

VOC  
As Mixed

458.68 g/l (3.82 lbs./gl.)  
475.32 g/l (3.96 lbs./gl.)

**Solids**

By Weight  
As Mixed

64.8%  
48.98% 1.3 kg/M3 (10.88 lbs/gl)

**Specific Gravity**

**Coverage**

313.0 square feet per gallon @ 100% transfer efficiency  
@ 50 microns (2 mils.)  
58.1 square meters per gallon @ 100% transfer  
efficiency @ 50 microns (2 mils)

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**Repainting**

After 48 hours @ 20° C (68° F) light sanding needed.

**Adhesion**

(ASTM D 4541)

(ASTM D 3359)

1850 psi - Excellent

A/B (5/5) – Excellent

**Salt Spray**

(ASTM B 117)

Pass 1500 hours

**Direct Impact**

(ASTM D 2794)

Very Good (140 in-lb.)

**Reverse Impact**

(ASTM D 2794)

Very Good (50 in-lb.)

**Humidity Resistance**

(ASTM D 2247)

Pass 1000 hours

**Flexibility**

(ASTM D 522)

Excellent (Mandrel)

**Storage Stability**

One year, stored in closed package, in cool dry place, away  
From any sources of heat.

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