

GlobalStar

P6.3.K1

1K Low VOC

High Performance Primer

GlobalStar
INDUSTRIAL



US/11082021P6.3.K1

Technical Data Sheet

Description

P6.3.K1 is a 1K low VOC, Phenolic Alkyd Primer with built in corrosion resistance and excellent adhesion onto properly prepared hot or cold roll steel and over properly prepared 2K painted surfaces.

Suggested Uses

As a wet on wet sealer or primer surfacer.

Over hot roll or cold roll steel, fiberglass and sanded 2K coatings 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, airless, pressure pot, cup gun, brush or rolled

Components

P6.3.K1

GSOR-F, GSOR-M,
GSOR-S

Base

Fast, Medium, Slow Reducer

Field Applications

- Structural steel
- Work panel trucks
- Trailers and frames
- Construction equipment
- Many OEM applications
- Oil Field Equipment

Mixing Ratio

Mix:

P6.3.K1 1K Low VOC High Performance Primer comes ready for use, but can be reduced 0%-10% with selected reducer.

GlobalStar Industrial

Division of Lusid Technologies, Inc. | Salt Lake City, UT | Phone 877-973-7600 | Fax 801-966-6876

GlobalStar

P6.3.K1

1K Low VOC

High Performance Primer

US/11082021P6.3.K1

Application

Apply:

One to two medium wet coats, allow 5-10 minutes flash between coats.

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:

50-75 microns – (2.0 – 3.0 mils.)

Dry Times

Dust Free:

20-30 minutes @ 20° C (68° F)

Dry to Topcoat:

30-45 minutes @ 20° C (68° F)

Force Dry

30 minutes @ 60° C (140° F) light sanding needed.

Surface Preparation

Ferrous metals:

Best Case

SA2 sandblast Blow all dust and contaminates off and apply P6.3.K1 primer within 8 hours.

Second Best Case

Hot Phosphate wash system, blow dry and apply P6.3.K1 primer 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 P6.3.K1 primer within 4 hours.

Aluminum:

Only suitable if GlobalStar Epoxy Primer is applied first

GlobalStar Industrial

GlobalStar

P6.3.K1

1K Low VOC

High Performance Primer

US/1108202P6.3.K1

Galvanized Steel:

Only suitable if GlobalStar P10.3.K1 Primer is applied first.

VOC

Regulatory VOC

238.3 g/l (1.98 lbs./gl.)

Actual VOC

131.3 g/l (1.09 lbs./gl.)

Solids

By Volume

51.7%

By Weight

40.6%

Specific Gravity

1.51 kg/l (12.66 lbs./gl.)

Coverage

304.86 square feet per gallon @ 100% transfer efficiency

@ 50 microns (2 mils.)

28.3 square meters per gallon @ 100% transfer efficiency

@ 50 microns (2 mils)

Repainting

After 24 hours @ 20° C (68° F) light sanding needed.

Storage Stability

One year, stored in closed package, in cool dry place, away

From any sources of heat.

All technical advice, recommendations and services are rendered by the seller gratis. They are based on technical data which they believe to be reliable, and are intended for use by persons having skill and know-how at their own discretion and risk. Seller assumes no responsibility for the results obtained or damages incurred from their use by Buyer in whole or part. Such recommendations, technical advice or services are not to be taken as a license to operate under or intended to suggest infringement of any existing patent.

GlobalStar Industrial

Division of Lusid Technologies, Inc. | Salt Lake City, UT | Phone 877-973-7600 | Fax 801-966-6876