

GlobalStar

P12.3.K1

2.1 HS Gray Epoxy Primer

Rev: 05222026

Technical Data Sheet

Description

P12.3.K1 is a 2K, VOC 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.
- VOC restrictions are present.
- Excellent performance when applied with airless, air-assist airless pressure pot, cup gun or brush or rolled.

Components

P12.3.K1

GS0R-F, GS0R-M, GS0R-S

EH.001LV

Base

Fast, Medium, Slow Zero VOC Reducer for Compliant

LV 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 P12.3.K1 Epoxy Base to one (1) part EH.001LV 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 contaminants off and apply P12.3.K1 primer within 8 hours.

Second Best Case

Hot Phosphate wash system, blow dry and apply P12.3.K1 primer

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Within 8 hours.

Third Best Case

Careful mechanical abrasion. Clean all dust, oil residue, finger prints and contaminants before and after mechanical abrasion with a clean drying wax and grease removal solvent making sure all residue is removed then apply P12.3.K1 primer within 4 hours.

Aluminum:

Clean surface with clean drying wax and grease remover, apply P12.3.K1 Epoxy Primer within 4 hours.

Galvanized Steel:

Clean all dust, oil residue, and contaminants 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 P12.3.K1 epoxy primer as directed.

VOC

VOC
As Mixed

214.76 g/l / 1.79 lbs
208.3 g/l / 1.73lbs

Solids

Solids
As Mixed

66.39%
45.81%

Specific Gravity

Coverage

1.29kg / 10.78 lbs

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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