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TECHNICAL DATA SHEET


GTC625LV DTM (DIRECT TO METAL) CLEARCOAT

05122026


 GTC625LV DTM Clear is a premium 2K ready-to-spray overall clearcoat formulated to meet low-VOC compliance requirements. Its high-clarity appearance helps minimize color shift over certain basecoat colors, particularly white. GTC625LV also delivers excellent buffing characteristics and outstanding gloss for a refined, high-quality finish.


 **COMPONENTS**

• GTC625LV	DTM Clear Coat
• GH065/GH075/GH085	Fast/Medium/Slow - Activators
• GH045W/GH055W	Very Fast/Super Fast - Winterized Activators

 **MIXING RATIO**
Mix four (4) parts GTC625LV with one (1) part selected activator. GTC625LV is ready to spray after activation. A566 accelerator may be used up to 1 ounce per gallon or ¼ ounce per quart for enhanced drying. .

 **POT LIFE**
2 hours (without accelerator)

 **CLEAN UP**
Use NORTHSTAR Lacquer Thinner or zero VOC solvents. (Check local regulation)

 **PHYSICAL DATA**

Solids wt. (as mixed)	29.0% (as mixed 33.4%)
VOC as mixed (restricted areas)	2.09
Color	Water white

 **DRY / FLASH TIMES**


Air Dry at 77° F/25°C	
Flash between coats	10-20 minutes
Dust free	35 minutes
Tack free	20-30 minutes
Sand & Buff	12 hours

Force Dry

Flash before force dry	15 minutes minimum
Force dry time	35 minutes at 140° F
Sand & Buff	After 2 hour cooldown

SUBSTRATES

- | | |
|---|--|
| <input checked="" type="checkbox"/> Plastic | <input checked="" type="checkbox"/> Galvanized Steel |
| <input checked="" type="checkbox"/> Original Paint | <input checked="" type="checkbox"/> Stainless Steel |
| <input checked="" type="checkbox"/> E-Coat | <input checked="" type="checkbox"/> Aluminum |
| <input checked="" type="checkbox"/> Properly Prepared Steel | <input checked="" type="checkbox"/> Brass |

 **COLOR SANDING**
Sand with P1200/P1500/P2000 sand paper; polish with appropriate compounds and glazes to achieve a high gloss finish.

 **GUN SETUPS**

Compliant


Gravity Feed	1.3 mm – 1.5 mm
Siphon Feed	1.3 mm – 1.5 mm

AIR PRESSURES


Conventional at Gun

Gravity Feed	30-40 psi
Siphon Feed	35-45 psi
HVLP at cap	8 – 10 psi

 **SURFACE PREPARATION**
Use NORTHSTAR Clean Wipe (S10) to clean substrate free of grease, dirt, and foreign contaminants.

 **APPLICATION AT 77° F/25°C**

- Apply 2-3 medium wet coats over substrate to desired film thickness
- Allow 10-20 minutes between coats
- Scuff after 24 hours before applying topcoat or recoating
- Clean gun after spraying is completed

 **SAFETY**
Refer to Material Safety Data Sheet (MSDS) for complete safety instructions. The technical data sheet listed has been compiled in good faith for your convenience and guidance. No warranty, expressed or implied, is intended or given by the information on this sheet.

