GlobalStar
6B.4.K1
Matt DTM
Industrial Acrylic Polyurethane

EU/ROW082320166B.4.K1

Technical Data Sheet

Description

6B.4.K1 is a two pack industrial matt acrylic urethane DTM topcoat created for painting of all types of ferrous metals. Care must be taken in surface preparation when DTM applications are used. An appropriate primer is always the best way to insure a longer life and finer finish.

Suggested Uses

As a high performance topcoat over suitable primers or over properly prepared substrates, including: Hot and Cold roll steel, Galvanized Steel, Aluminum, fiberglass, plastics and wood where:

- Outstanding Gloss and color retention are desired.
- Outstanding adhesion and flexibility is required.
- Excellent DOI and leveling is required.
- Excellent performance when using air-assist airless, pressure pot, cup gun.
- Can be applied in small areas with roller or brush.

Field Applications

- Heavy industrial equipment
- Oil Field equipment
- Construction equipment
- Airport ground support equipment
- Truck and Trailer Refinishing
- Furniture
- Machine tools
- Metallic doors
- Concrete coatings
- Plastics

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Components

6B.1. K1	Base
0G.013	Polyurethane Reducer Standard
0G.030	Polyurethane Reducer Slow
0A.014	Hardener

Mixing Ratio

Mix: Mix four (4) parts base color to one (1) part OA.014 hardener.
Reduce up to 5 - 10% with Selected Reducer.

Pot Life

4 hours @ 20° C (68° F)

Application

Apply: One or two crossed coats

Spray Gun:
HVLP Gravity Feed – 1.4 – 1.6mm tip and needle
Pressure Pot HVLP – 1.0 – 1.1mm tip and needle
Air Assist Airless - 1.0 – 1.1mm tip and needle
Conventional – 1.4 – 1.7mm tip and needle
Airless Not recommended.

Film Build: 60-90 microns – (2.4 – 3.6 mils.) when applied.

Dry Times

Dust Free:	20-30 minutes @ 20° C (68° F)
Dry to Touch	2-4 hours @ 20° C (68° F)
Total Hardness	24 hours @ 20° C (68° F)
Force Dry	30 minutes @ 60° C (140° F)
Chemical Resistance	Maximum resistance after 7 days

Surface Preparation

Ferrous metals:

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Best Case	SA2 sandblast Blow all dust and contaminates off and apply Globalstar primer followed by topcoat.
Second Best Case	Hot Phosphate wash system, blow dry and apply Globalstar primer followed by topcoat.
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. Blow dry and apply Globalstar primer followed by topcoat. Apply topcoat within 8 hours.
Aluminum:	Clean surface with clean drying wax and grease remover. Apply suitable Globalstar Epoxy Primer followed by topcoat as recommended.
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 Globalstar Epoxy Primer follow by topcoat as recommended.

VOC

Actual VOC	500.0 g/l

Solids

By Volume	64%
By Weight	52%

Specific Gravity

1.34 kg/l

Coverage

8m2 / Kg

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Salt Spray Test
(ASTM B 117)

200 hours with dry film of 80 microns (3.1 mils.)
Sprayed directly on bare sand blasted steel.

Impact Test
(ASTM D 2794)

36 kg direct, 10 kg reverse, on sanded steel. (Passed).

Yellowing
(ASTM D 4587)

After 1000 hours ΔE≤3 (with 2% of 03.007 anti UV additive inside)

Repainting

Can be recoated up to 6 hours from application, after 24 hours light sanding recommended for best adhesion. After force dry recommendations are completed light sanding is recommended

Storage Stability

One year for A (base) component, 6 months B (Hardener) Component in closed package, in cool dry place, away from any heat source.

Heat Resistance

Once cured 180° C (356° F)

Chemical Resistance:

Test	Results	Cure Time
HCl Solution 10%	4	7 days
HNO_3 Solution 10%	2	7 days
H_2SO_4 Solution 10%	4	7 days
Acetic acid solution 10%	5-4	7 days
Mix of NaCl 10%, Lactic acid 5%	5-4	7 days
Synthetic sweat	5	7 days
H_2O_2 35%	1	7 days

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NH_3 Solution 30%	5	7 days
NaOH Solution 10%	5	7 days
Acetone	4-3	7 days
Cycloexanone	1	7 days
HiSol 100	4-3	7 days
Ethyl Acetate	4-3	7 days
Ethanol	4-3	7 days
Synthetic oil	4	7 days
Idraulic oil	5	7 days
Transmission oil SEA 30	5	7 days
Engine oil 15W40	5	7 days
Viakal	5	7 days
Unleaded gasoline	5	7 days