LUSID TECHNOLOGIES
4725 S. Camp Kearns Rd.
Kearns, UT 84118 | (801) 966-5300
www.lusidtechnologies.com

TECHNICAL DATA SHEET

GTC625 DTM (DIRECT TO METAL) CLEAR COAT

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GTC625 DTM CLEAR is a 2K ready to spray premium quality overall clear that meets the National Rule for Low VOC compliance. GTC625 possesses a "water white" color that eliminates c oncerns of color change over some basecoat colors, especially white. GTC625 has excellent buffing capabilities and a superior gloss for a ultimate appearance.

COMPONENTS

• GTC625	DTM Clear Coat
• GH065/GH075/GH085	Fast/Medium/Slow - Activators
• GH045W/GH055W	Very Fast/Super Fast - Winterized Activators

MIXING RATIO

Mix four (4) parts GTC625 with one (1) part selected activator. GTC625 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

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.

GreenTec

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