

GlobalStar
3G.1.K1
High Gloss Alkyd

GlobalStar
INDUSTRIAL



EU/ROW082320163G.1.K1

Technical Data Sheet

Description

1K High Gloss Alkyd Topcoat

Suggested Uses

As a high gloss topcoat over the following primers.

21.3.70121 2K Grey Epoxy Primer, 6I.4.70133 2K Acrylic Primer Filler, 7I.2.70121 1K Nitro Resistant Primer, on steel, Coachwork (Buses) work panel trucks, frames, trailers, and wood where:

- Outstanding gloss is required.
- Outstanding flexibility is needed.
- Excellent performance when applied with airless, air-assist airless pressure pot, cup gun or brush or rolled.

Components

3G.1.K1
0G-005
0A.014
0C.003

Base
Synthetic Reducer for Quick Dry Reducers
Hardener (optional)
Drier for Synthetics (optional)

Mixing Ratio

Mix:

Base is Ready for use by adding 5%-20% Reducer from above.

*Option, to speed up dry time, add 0%-5%, 0C.003 drier accelerator.

*Option to enhance gloss retention, durability and performance add up to 10% 0A.014 Hardener.

Application

Apply:

Two medium wet coats, allow 25-35 minutes flash between coats. or apply one medium light coat followed by a medium cross coat.

Spray Gun:

HVLP Gravity Feed – 1.4 – 1.6mm tip and needle
Pressure Pot HVLP – 1.0 – 1.1mm tip and needle

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Air Assist Airless - 1.0 – 1.1mm tip and needle
Conventional - 1.4 – 1.7mm tip and needle
Airless - 310 – 610 – 312 – 612 nozzle

Film Build: 50-75 microns – (2.0 – 3.0 mils.)

Dry Times

Dust Free: 60 minutes @ 20° C (68° F)
Dry to Touch 4-8 hours @ 20° C (68° F)
Total Hardness 24-48 hours @ 20° C (68° F)
Force Dry 45 minutes @ 60° C (140° F)
Chemical Resistance Maximum resistance after 7-14 days

Surface Preparation

Ferrous metals:

Best Case SA2 sandblast Blow all dust and contaminates off and apply Globalstar primer within 12 hours, apply topcoat.
Second Best Case Hot Phosphate wash system, blow dry and apply suitable Globalstar primer within 8 hours, apply 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. Apply suitable Globalstar primer followed by topcoat.

Aluminum:

Clean surface with clean drying wax and grease remover. Apply suitable Globalstar Epoxy Primer followed by topcoat.

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 Etch Primer follow by a suitable Globalstar Primer and Topcoat.

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VOC

Regulatory VOC

500 g/l (4.17 lbs./gl.)

Actual VOC

500 g/l (4.17 lbs./gl.)

Solids

By Volume

52%

By Weight

60%

Specific Gravity

1.15 kg/l (9.5 lbs./gl.)

Coverage

417.3 square feet per gallon @ 100% transfer efficiency, @ 50 microns (2 mils)

38.74 square meters per gallon @ 100% transfer efficiency, @ 50 microns (2 mils)

Repainting

Can be repainted without sanding within 4-6 hours

Otherwise wait 2-3 weeks @ 20° C (68° F) before recoating

(without hardener) and 3-5 days @ 20° C (68° F) with hardener).

Storage Stability

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

From any sources of heat.

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