

GlobalStar

L5.1.K1

High Gloss Acrylic Polyurethane

GlobalStar
INDUSTRIAL



US/08232016L5.1.K1

Technical Data Sheet

Description

L5.1.K1 is a medium solids high gloss urethane topcoat created for painting of all types of substrates on manufactured items, and refinish projects.

Suggested Uses

As a high performance topcoat over properly prepared primed or sealed substrates and sanded stable coatings, 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 durability and chemical resistance.
- Car finish appearance.
- Excellent DOI and leveling is required.
- Excellent performance when using air-assist airless, pressure pot, cup gun and Roller or brush application.

Field Applications

- Light to medium industrial equipment
- Recreational boat refinishes
- Construction equipment
- Airport ground support equipment
- Truck and Trailer Refinishing
- Bus and Transit refinish
- Commercial auto and van refinish.

Components

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Base

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GSR-F, GSR-M, GSR-S
AE.002

Fast, Medium, Slow, Urethane Reducer
Hardener

Mixing Ratio

Mix:

Mix three (3) parts base color to one (1) part AE.002 hardener.
Reduce 10%-20% with Selected Reducer.

Pot Life

1.5 hours @ 20° C (68° F)

Application

Apply:

Two medium wet coats, allow 10-20 minutes flash between 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:

50-62.5 microns – (2.0 – 2.5 mils.) when applied as directed.

Dry Times

Dust Free:

30 minutes @ 20° C (68° F)

Dry to Touch

1 hours @ 20° C (68° F)

Total Hardness

24 hours @ 20° C (68° F)

Force Dry

40 minutes @ 60° C (140° F)

Chemical Resistance

Maximum resistance after 7 days

Surface Preparation

Ferrous metals:

Best Case

SA2 sandblast Blow all dust and contaminants off and apply

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GlobalStar primer within 12 hours followed by topcoat as directed.

Second Best Case

Hot Phosphate wash system, blow dry and apply GlobalStar primer within 8 hours followed by topcoat as directed.

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 as directed.

Aluminum:

Clean surface with clean drying wax and grease remover. Apply 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 GlobalStar Epoxy Primer followed by topcoat as directed.

VOC

Regulatory VOC

578.7 g/l (4.8 lbs./gl.)

Actual VOC

578.7 g/l (4.8 lbs./gl.)

Solids

By Volume

33.7%

By Weight

39.2%

Specific Gravity

0.95 kg/l (7.9 lbs./gl.)

Coverage

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

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

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Repainting

After 24 hours @20° C (68° F). Light sand recommended for best adhesion. After force dry recommendations are completed, allow cool down for 1 hours before sand and recoat.

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)

ASTM Information:

| Test | Results | Test Methods |
|--|------------------------|---|
| Abrasion Resistance | Excellent | ASTM D 4060 |
| Adhesion | Excellent | ASTM D 4541 (1850 psi) ASTM D 3359 A/B (5/5) |
| Salt Spray Resistance | Excellent | ASTM B 117 (Pass 1500 hours) |
| Direct Impact Resistance | Very Good | ASTM D 2794 (140 in-lbs.) |
| Reverse Impact Resistance | Very Good | ASTM D 2794 (50 in lbs.) |
| Humidity Resistance | Excellent | ASTM D 2247 (Pass 1000 hours) |
| Film Hardness | 3H | ASTM D 3363 |
| Chemical Resistance (Rating Scale 1-10 with 10 best) | Very Good to Excellent | ASTM D 1308 |
| | 10 | 1% Sodium Hydrochloric Acid |
| | 10 | 5% Sodium Hydrochloric Acid |
| | 9 | 10% Sodium Hydrochloric Acid |
| | 10 | Ammonia |
| | 10 | Diesel Fuel |
| | 10 | 1% Hydrochloric Acid |
| | 10 | 1% Sulfuric Acid |
| | 9 | 10% Sulfuric Acid |
| | 10 | 100% Ethanol |
| | 10 | 1% Phosphoric Acid |
| | 9 | 10% Phosphoric Acid |
| | 10 | MEK (Methyl Ethyl Ketone) |

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| | | |
|---------------------|-----------|------------------------------|
| | 10 | Gasoline |
| | 9 | Skydrol |
| | 9 | DOT 3 Break Fluid |
| QUV A | Excellent | ASTM D 4587 (1500 hours-97%) |
| Initial Gloss @ 60° | 93 min. | ASTM D 523 |
| Solvent Resistance | Surpassed | ASTM D 4752 (1000 MHR) |
| Flexibility | Excellent | ASTM D 522 Mandrel |

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