

GlobalStar

3G.1.K1

High Gloss Alkyd

US/082320163G.1.K1

Technical Data Sheet

Description

1K High Gloss Alkyd Topcoat

Suggested Uses

As a high gloss topcoat over the following primers.

P9.3.K1 2K Epoxy Primer, P8.3.K1 1K Alkyd Primer. Over primed steel substrate where:

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

Components

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GSR-F, GSR-M, GSR-S

AE.002

OC.003

Base

Fast, Medium, Slow Reducer

Hardener

Drier for Synthetics

Field Applications

- Coachwork or bus frames, undercarriage and bumpers.
- Work trucks, panel trucks trailers.
- truck and trailer frames.
- wood

Mixing Ratio

Mix:

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

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

*Option, to enhance gloss retention, durability and performance add up to 15% AE.002 Hardener.

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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
Air Assist Airless - 1.0 – 1.1mm tip and needle
Conventional – 1.4 – 1.7mm tip and needle
Airless - 310 – 610 – 312 – 612 nozzle
50-75 microns – (2.0 – 3.0 mils.)

Film Build:

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 suitable Globalstar primer within 12 hours. Apply topcoat as directed

Second Best Case

Hot Phosphate wash system, blow dry and apply suitable Globalstar primer within 8 hours, apply 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, apply topcoat as directed.

Aluminum:

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

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Galvanized Steel:

Clean all dust, oil residue, and contaminants 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 directed.

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 wet on wet or behind within 4-6 hours
Otherwise wait 2-3 weeks @ 20° C (68° F) before recoating
(without hardened) and 3-5 days @ 20° C (68° F) with hardener).

Storage Stability

One year, stored in closed package, in cool dry place, away
From any sources of heat.

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