

## Technical Data Sheet

### Description

L6.1. K1 is a 2K High Solids High Gloss Low VOC Anti-Sag Urethane Topcoat. L6.1.K1 is compliant in all restricted VOC areas.

### 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 chemical resistance is required.
- Low VOC coatings are mandated.
- Excellent anti-sag qualities for easy application around hard to get to areas.
- Excellent performance when using air-assist airless, pressure pot, cup gun
- Can be used for roller or brush application.

### Field Applications

- Heavy industrial equipment
- Oil Field equipment
- Construction equipment
- Aircraft and Marine (above the water line)
- Airport ground support equipment
- Truck and Trailer Refinishing
- Equipment, Truck, Trailer OEM finishing.

### Components

L6.1. K1

GS0R-F, GS0R-M, GS0R-S

AV.002

Base

Fast, Medium, Slow Urethane Reducer (VOC compliance)

Hardener (VOC compliance)

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L6.1.K1

High Gloss UHS Low VOC Polyurethane

US/08232016L6.1.K1

### Mixing Ratio

Mix:

Mix three (3) parts base color to one (1) part hardener.  
Reduce up to 15% - 33% with selected suitable reducer.

### Pot Life

2 hours @ 20° C (68° F)

### Application

Apply:

Two medium wet coats, allow 10-20 minutes flash between coats.  
Or apply one medium coat follow 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 – Not recommended.

Film Build:

75-125 microns – (3.0 – 5.0 mils.) when applied as directed.

### Dry Times

Dust Free:

60 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

45 minutes @ 60° C (140° F)

Chemical Resistance

Maximum resistance after 7 days

### Surface Preparation

**Ferrous metals:**

Best Case

SA2 sandblast Blow all dust and contaminates off and apply  
Suitable GlobalStar primer, followed by topcoat as directed.

Second Best Case

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

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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 follow by topcoat as directed.

**VOC**

Regulatory VOC National Rule

408.0 g/l (3.4 lbs./gl.) when using National Rule hardener & reducer.

Actual VOC National Rule

408.0 g/l (3.4 lbs./gl.) when using National Rule hardener & reducer.

Regulatory VOC Compliant

319.2 g/l (2.66 lbs./gl.) when using VOC compliant hardener & reducer.

Actual VOC Compliant

319.2 g/l (2.66 lbs./gl.) when using VOC compliant hardener & reducer.

**Solids**

By Volume

47.57%

By Weight

48.29%

**Specific Gravity**

1.11 kg/l (9.268 lbs./gl.)

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**Coverage**

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

**Repainting**

After 24-36 hours @20° C (68° F). Light sand recommended for best adhesion. After force dry recommendations are completed, allow cool down for 2 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 ASTM D 3359 A/B (5/5)
Salt Spray Resistance	Excellent	ASTM B 117(pass 1500 hrs.)
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 hrs.)
Film Hardness	3H	ASTM D 3363
Chemical Resistance (Rating Scale 1-10 with 10 best)	Excellent	ASTM D 1308
	10	1% Sodium Hydroxide
	10	5% Sodium Hydroxide
	10	10% Sodium Hydroxide
	10	10% Ammonia
	10	Diesel Fuel
	10	1% Hydrochloric Acid
	10	1% Sulfuric Acid
	10	10% Sulfuric Acid

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	10	100% Ethanol
	10	1% Phosphoric Acid
	10	10% Phosphoric Acid
	10	MEK (Methyl Ethyl Ketone)
	10	Gasoline
	10	Skydrol
	10	DOT 3 Brake Fluid
<u>QUV A</u>	<u>Excellent</u>	<u>ASTM D 4587 (1500 hrs. -97%)</u>
<u>Initial Gloss @ 60°</u>	<u>93 min</u>	<u>ASTM D523</u>
<u>Solvent Resistance</u>	<u>Surpassed</u>	<u>ASTM D 4752 (1000 MHR)</u>
<u>Flexibility</u>	<u>Excellent</u>	<u>ASTM D 522 Mandrel</u>

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