

GlobalStar

P7.3.K1

2K Acrylic Primer Filler

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US/08232016P7.3.K1

Technical Data Sheet

Description

P7.3.K1 is a 2K, high build, high production, acrylic urethane primer with excellent hold out and easy to sand properties. Light Gray color makes it easy to achieve opacity with a minimum number of color coats.

Suggested Uses

As a wet on wet sealer or a full bodied sand-able primer, where body repair, scratches or imperfections need to be filled.

- Excellent hold out with minimal shrinkage is needed.
- Excellent sand-ability is needed.
- High productivity is required.
- Excellent performance when applied with air-assist airless pressure pot, Conventional, HVLP, siphon or gravity feed cup gun.

Components

P7.3.K1

GSR-F, GSR-M, GSR-S

AE.002

Base

Fast, Medium, Slow Reducer

Hardener

Field Applications

- Semi-trucks
- Coachworks (Buses)
- Work panel trucks
- Cement trucks and snow plows
- Many OEM applications
- Aircraft and marine

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Mixing Ratio

Mix:

One (4) parts P7.3.K1 Base to one (1) part AE.002 Hardener. Reduce 25%-50% with selected reducer.

Application

Apply:

One to three medium wet coats, allow 10-20 minutes flash between coats.

Spray Gun:

HVLP Gravity Feed – 1.4 – 1.7mm tip and needle
Pressure Pot HVLP – 1.0 – 1.2mm tip and needle
Air Assist Airless - 1.0 – 1.2mm tip and needle
Conventional – 1.5 – 1.8mm tip and needle

Film Build:

50-100 microns – (2.0 – 5.0 mils.)

Dry Times

Dust Free:

10 minutes @ 20° C (68° F)

Dry to Touch

20 minutes @ 20° C (68° F)

Dry to Sand

1 hour per coat @ 20° C (68° F)

Force Dry

20 minutes @ 60° C (140° F) sand before painting

Surface Preparation

Ferrous metals:

Best Case

SA2 sandblast Blow all dust and contaminates off and apply P9.3.K1 epoxy primer within 8 hours. Allow epoxy primer to fully cure then sand before applying P7.3.K1 filler primer.

Second Best Case

Hot Phosphate wash system, blow dry and apply P9.3.K1 epoxy primer within 8 hours. Allow epoxy primer to fully cure, then sand before applying P7.3.K1 filler primer.

Third Best Case

Careful mechanical abrasion. Clean all dust, oil

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residue, finger prints and contaminates before and after mechanical abrasion with a clean drying wax and grease remover making sure all residue is removed. Then apply P9.3.K1 epoxy

primer within 4 hours. Allow epoxy primer to fully cure then sand before applying P7.3.K1 filler primer.

Aluminum:

Sand surface, then clean surface with clean drying wax and grease Remover, apply Globalstar P9.3.K1 Epoxy Primer and let flash fully as per TDS, then apply P7.3.K1 primer.

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 P9.3.K1 Epoxy Primer, let flash fully as per TDS then apply P7.3.K1 epoxy primer.

VOC

Regulatory VOC
Actual VOC

563.3 g/l (4.7 lbs./gl.)
563.3 g/l (4.7 lbs./gl.)

Solids

By Volume
By Weight

35%
53%

Specific Gravity

1.5 kg/l (10.06 lbs./gl.)

Coverage

280.0 square feet per gallon @ 100% transfer efficiency
@ 50 microns (2 mils.)
26.1 square meters per gallon @ 100% transfer efficiency
@ 50 microns (2 mils)

Repainting

After 48 hours @ 20° C (68° F) light sanding needed.

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Storage Stability

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

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