

GlobalStar

6C.1.K2

Industrial Polyurethane

EU/ROW082320166C.1.K2

## Technical Data Sheet

### Description

6C.1.K2 is a two pack medium solids industrial gloss urethane topcoat created for painting of all types of substrates on manufactured items, and industrial machinery. Can be applied DTM on ferrous substrates with careful preparation.

### Suggested Uses

As a gloss 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:

- Good gloss and color retention are desired.
- Outstanding adhesion and flexibility is required.
- Excellent durability and chemical resistance.
- Excellent performance when using air-assist airless, pressure pot, cup gun and Roller or brush application.

### Field Applications

- Light to medium industrial equipment
- Machine tools
- Industrial vehicles
- Construction equipment
- Truck and Trailer Refinishing
- Metallic structures
- Earthmoving vehicles
- Agricultural machinery

### Components

6C.1. K2

OG.013

OG.030

OA.014

Base

Medium Polyurethane Reducer

Slow Polyurethane Reducer

Hardener

### Mixing Ratio

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**Mix:**

Mix three (3) parts base color to one (1) part 0A.014 hardener.  
Reduce with Selected Reducer 0-5%

**Pot Life**

4 hours @ 20° C (68° F)

**Application**

**Apply:**

Two wet coats, allow 10-30 minutes flash between coats, or one cross coat.

**Spray Gun:**

HVLP Gravity Feed – 1.2 – 1.4mm tip and needle  
Pressure Pot HVLP – 1.0 – 1.1mm tip and needle  
Air Assist Airless - 1.0 – 1.1mm tip and needle  
Conventional – 1.2 – 1.4mm tip and needle

**Film Build:**

40-50 microns – when applied as directed.

**Dry Times**

**Dust Free:**

20 - 30 minutes @ 20° C (68° F)

**Dry to Touch**

4 - 6 hours @ 20° C (68° F)

**Total Hardness**

24 hours @ 20° C (68° F)

**Force Dry**

30 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 suitable GlobalStar primer, topcoat as directed.

**Second Best Case**

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

**Third Best Case**

Careful mechanical abrasion. Clean all dust, oil residue, finger prints and contaminants before and after mechanical abrasion with a clean drying wax and grease removal solvent making sure all residue is removed. Can be applied DTM or apply suitable GlobalStar primer within 8 hours, topcoat as directed.

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**Aluminum:**

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

**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 followed by topcoat as directed.

**VOC**

Actual VOC National Rule 600 g/l

**Solids**

By Volume 40% A+B

By Weight 43% A+B

**Specific Gravity**

1.10 kg/l

**Coverage**

10m<sup>2</sup> / Kg (theoretical)

**Repainting**

After 24 hours @20° C (68° F) or full curing light sand recommended for best adhesion.

**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)

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