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TECHNICAL DATA SHEET

GTB420 BASECOAT BINDER

0301021



GTB420 is a VOC compliant binder that may be added to compliant basecoat systems where all components are less than 420 grams per liter. Addition of GTB420 will not increase the VOC above 420 grams per liter when used with these systems. GTB420 is specifically formulated to eliminate flop issues and allow for proper blending. Addition of GTB420 at 50% of color mixture may require an additional coat in some colors.



COMPONENTS

- GTB420 Basecoat Binder
- Basecoat Mixed color



MIXING RATIO

Mix one (1) part Basecoat mixed color to one (1) part GTB420 Basecoat Binder. Then add in reducer according to the basecoat recommendations. Use compliant reducers to maintain VOC of less than 420 grams per liter.



POT LIFE

N/A



CLEAN UP

Use NORTHSTAR Lacquer Thinner or zero VOC solvents. (Check local regulation)



PHYSICAL DATA

Solids wt. 14.1% (as mixed 25%-45% (varies according to basecoat used))
VOC as mixed (restricted areas)



DRY / FLASH TIMES

Air Dry at 77° F/25°C
Flash between coats 5-10 minutes
Dust free 15-20 minutes
Tack free 5-15 minutes

Force Dry

Not Recommended



COLOR SANDING

De-nib with 800-1000 grit sand paper if needed.



GUN SETUPS

Compliant

Gravity Feed 1.3 mm – 1.5 mm
Siphon Feed 1.3 mm – 1.5 mm

AIR PRESSURES

Conventional at Gun

Gravity Feed 18-28 psi
Siphon Feed 18-28 psi
HVLP at cap 8 – 10 psi



SURFACE PREPARATION

Use NORTHSTAR Clean Wipe (S10) to clean substrate free of grease, dirt, and foreign contaminants.



APPLICATION AT 77° F/25°C

- Apply 2 – 3 medium wet coats over substrate allowing proper flash times between coats. Apply final mist coat when needed at reduced pressure for metallic and pearl orientation.
- If more than 3 coats of Basecoat are required, add 5% by volume compliant Hardener (H01522)
- Allow 5-10 minutes between coats
- Wait until fully matte before applying clear coat
- Scuff and rebase after 8 hours before clear coating
- Clean gun after spraying is completed



SAFETY

Refer to Material Safety Data Sheet (MSDS) for complete safety instructions. The technical data sheet listed has been compiled in good faith for your convenience and guidance. No warranty, expressed or implied, is intended or given by the information on this sheet.

