

GlobalStar

7D.1.K1

High Gloss Fast Air Dry Alkyd

US/082320167D.1.K1

Technical Data Sheet

Description

High Gloss Fast Air Dry Alkyd Topcoat

Suggested Uses

As a fast dry high gloss topcoat over the following primers.

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

- Excellent gloss and fast dry is required.
- High production arenas are utilized.
- 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

Base

Fast, Medium, Slow Reducer

*Optional Hardener

Field Applications

- Coachworks (Buses)
- Work Panel Trucks
- Trailers and Frames
- Wood

Mixing Ratio

Mix:

Base is ready for use by adding 10%-30% Reducer from above.

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

Application

Apply:

Two medium wet coats, allow 10-20 minutes flash between coats. Or apply one medium light coat followed by a medium cross coat.

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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

Film Build:

30-40 microns – (1.1 – 1.5 mils.).

Dry Times

Dust Free:

20-30 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

30 minutes @ 60° C (140° F)

Chemical Resistance

Maximum resistance after 14 days

Surface Preparation

Ferrous metals:

Best Case

SA2 sandblast Blow all dust and contaminates off and apply Suitable GlobalStar primer within 12 hours followed by topcoat as directed.

Second Best Case

Hot Phosphate wash system, blow dry, apply primer suitable GlobalStar primer within 8 hours followed by 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 followed by topcoat as directed.

Aluminum:

Clean surface with clean drying wax and grease remover. Apply GlobalStar Epoxy Primer, follow 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)

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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

545 g/l (4.5 lbs./gl.)

Actual VOC

600 g/l (5.0 lbs./gl.)

Solids

By Volume

53% (+ or - 2%)

By Weight

60% (+ or - 2%)

Specific Gravity

1.15 kg/l (9.4 lbs./gl.)

Coverage

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

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

Repainting

After 24 hours @ 20° C (68° F)

Storage Stability

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

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