

## Technical Data Sheet

### Description

P8.3.K1 is a 1K, Phenolic Alkyd Primer with built in corrosion resistance and excellent adhesion onto properly prepared hot or cold roll steel and over properly prepared 2K painted surfaces.

### Suggested Uses

As a wet on wet sealer or primer surfacer.

Over hot roll or cold roll steel, fiberglass and sanded 2K coatings where:

- High level of corrosion resistance is needed.
- Excellent adhesion is needed.
- High productivity is required.
- Excellent performance when applied with airless, air-assist airless, airless, pressure pot, cup gun, brush or rolled

### Components

P8.3.K1

GSR-F, GSR-M, GSR-S

Base

Fast, Medium, Slow Reducer

### Field Applications

- Structural steel
- Work panel trucks
- Trailers and frames
- Construction equipment
- Many OEM applications
- Oil Field Equipment

### Mixing Ratio

Mix:

P8.3.K1 1K Grey DTM Primer comes ready to spray, but can be reduced 15%-20% with selected reducer to be used a sealer

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**P8.3.K1**

**1K Gray DTM Primer**

**GlobalStar**  
INDUSTRIAL



US/08232016P8.3.K1

**Application**

Apply:

One to two medium wet coats, allow 5-10 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  
Airless - 310 – 610 – 313 – 613 nozzle

Film Build:

50-75 microns – (2.0 – 3.0 mils.)

**Dry Times**

Dust Free:

20-30 minutes @ 20° C (68° F)

Dry to Topcoat:

30-45 minutes @ 20° C (68° F)

Force Dry

30 minutes @ 60° C (140° F) light sanding needed.

**Surface Preparation**

**Ferrous metals:**

Best Case

SA2 sandblast Blow all dust and contaminates off and apply P8.3.K1 primer within 8 hours.

Second Best Case

Hot Phosphate wash system, blow dry and apply P8.3.K1 primer Within 8 hours.

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 then apply P8.3.K1 primer within 4 hours.

**Aluminum:**

Only suitable if GlobalStar Epoxy Primer is applied first

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**Galvanized Steel:**

Only suitable if GlobalStar Epoxy Primer is applied first.

**VOC**

Regulatory VOC

395.96 g/l (3.30 lbs./gl.)

Actual VOC

268.05 g/l (2.23 lbs./gl.)

**Solids**

By Volume

37.99%

By Weight

49.37%

**Specific Gravity**

1.38 kg/l (11.54 lbs./gl.)

**Coverage**

304.86 square feet per gallon @ 100% transfer efficiency

@ 50 microns (2 mils.)

28.3 square meters per gallon @ 100% transfer efficiency

@ 50 microns (2 mils)

**Repainting**

After 24 hours @ 20° C (68° F) light sanding needed.

**Storage Stability**

One year, stored in closed package, in cool dry place, away

From any sources of heat.

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