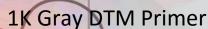
GlobalStar

P8.3.K1







US/07222020P8.3.K1

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:

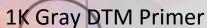
P8.3.K1 1K Grey DTM Primer comes ready to spray, but can be reduced 15%-20% with selected reducer to be used a sealer

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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:

Dry to Topcoat:

Force Dry

20-30 minutes @ 20° C (68° F)

30-45 minutes @ 20° C (68° F)

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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1K Gray DTM Primer

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Galvanized Steel:

Only suitable if GlobalStar Epoxy Primer is applied first.

VOC

Reg<mark>ulatory VOC Actual VOC
</mark>

395.96 g/l (3.30 lbs./gl.) 268.05 g/l (2.23 lbs./gl.)

Solids

By Volume By Weight 37.99% 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.

All technical advice, recommendations and services are rendered by the seller gratis. They are based on technical data which they believe to be reliable, and are intended for use by persons having skill and know-how at their own discretion and risk. Seller assumes no responsibility for the results obtained or damages incurred from their use by Buyer in whole or part. Such recommendations, technical advice or services are not to be taken as a license to operate under or intended to suggest infringement of any existing patent.

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