

Technical Data Sheet

Description

P10.3.K1 is a high solids DTM 2K Urethane Primer made for the Automotive or Light Industrial & Fleet market. P10 is known for excellent adhesion to a variety of substrates, while also providing corrosion resistance. P10 is a 2.1 VOC product and is compliant with known and applicable rules in North America.

Suggested Uses

As a high performance DTM primer over properly prepared substrates, where:

- Compliant 2.1 VOC (250 g/L) is desired.
- Outstanding corrosion protection is required.
- DTM adhesion is desired to steel, aluminum, galvanized, and stainless steel
- High build is necessitated.
- Excellent sanding properties are needed

Field Applications

- OEM trailer and truck body manufacturers
- Signs and advertising manufacturers
- Airport ground support equipment
- Truck and Trailer Refinishing
- Commercial auto and van refinish.

Components

P10.3.K1

AV.005

AE.002

Primer

Hardener (2.1 VOC)

Hardener (2.8 VOC)

Mixing Ratio

Mix:

Mix four (4) parts Primer to one (1) part AV.005 compliant hardener or AE.002 (2.8 VOC) Hardener.
Reduce 10-35% with GS0RF/M/S

Pot Life

2 hours @ 20° C (68° F)

Application

Apply: Two medium wet coats, allow 10-20 minutes flash between coats.

Spray Gun: HVLP Gravity Feed – 1.3 – 1.5mm tip and needle
Conventional – 1.3 – 1.5mm tip and needle

Film Build: 50-62.5 microns – (2.0 – 2.5 mils.) when applied as directed.

Dry Times

Dust Free: 30 minutes @ 20° C (68° F)
Tack Free: 15-20 minutes @ 20° C (68° F)
Sand 2-4 hours @ 20° C (68° F)
Force Dry (15-minute flash) - 20 minutes @ 60° C (140° F)
Top Coat 1 hour

Surface Preparation

Make sure surface is dry, and free of contamination. Use Northstar S10 Cleanwipe for final wipe.

VOC

With AV.005 Regulatory VOC	231 g/l (1.92 lbs./gl.)
With AV.005 Actual VOC	132 g/l (1.1 lbs./gl.)
With AE.002 Regulatory VOC	333 g/l (2.77 lbs./gl.)
With AE.002 Actual VOC	229 g/l (1.91 lbs./ gl.)

Solids

By Volume	42%
By Weight	55.4%

Specific Gravity

1.44 kg/l (11.99 lbs./gl.)

Coverage

337 square feet per gallon @ 100% transfer efficiency,
@ 50 microns (2 mils.).
31.32 square meters per gallon @ 100% transfer efficiency,
@ 50 microns (2 mils.).

Acceptable Topcoats

P10 may be top coated with all GlobalStar Top Coats

Repainting

After 24 hours @20° C (68° F). Sand recommended for best adhesion. After force dry recommendations are completed, allow cool down for 1 hours before sand and recoat.

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)

ASTM Information:

Test	Results	Test Results
Flexibility	Excellent	ASTM D 522 Mandrel
Abrasion Resistance	Excellent	ASTM D 4060
Adhesion	Excellent	ASTM D 3359 A/B 5/5
Salt Spray Resistance	Excellent	ASTM B 117 (Pass 1000 hrs)
Humidity Resistance	Excellent	ASTM D2247 (Pass 1000 hrs)

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