

# Glair G30 Series

## Semi-Gloss & Flat Colors

### High Solid Polyurethane Topcoat



**Product** Glair G30 Series High Solid Polyurethane Topcoat - Semi-Gloss & Flat Colors

**Item Class** High Solid Polyurethane Topcoat

Glair G30 Series is a high solid polyurethane decorative topcoat formulated to provide superior resistance and astonishing appearance. With an average 54% solid per gallon; it also offers better coverage than most other polyurethane coatings on the market. This product is also formulated to surpass conventional polyurethanes with superior chemical resistance and flexibility.

**Specifications** Product is manufactured to meet the performance requirements of the following specifications:

\*AMS 3095 - AIMS 04.04.025 - AIMS 04.04.031 - AIMS 04.04.032 - BAMS 565-009  
Type I, Class A, Grade B - DHMS C4.04 - MIL-PRF-85285F Ty I-IV, Cl H, Form M, Gr N  
- MEP 10-069

\*(On QPL Listing) – Please check 3chem.com for complete specification list

**Catalyst & Additives** Catalyst/Activator Additive

306 (Semi-Gloss/Flat)	PS40 Accelerator
	CRL25 Rolling/Brushing
	CRL28 Rolling/Brushing High Temperatures

**Use of Primers** 3Chem recommends use of P1019 (High Solid Epoxy Primer) with this system. Please contact your local 3Chem representative for a complete list of epoxy primers which may be utilized with this system.

**Surface Preparation** Prepare substrate per OEM requirements. Refer to Glair application guide for detailed instructions or contact your local 3Chem representative for assistance.

**Mixing Instructions**

Base	Catalyst/Activator	Mix Ratio
G32-XXXX (Semi-Gloss)	306	1:1
G33-XXXX (Flat)	306	1:1

Shake (Base) for 15 minutes to assure no solid settlement remains in can. Add component B catalyst to component A paint first. Mix ratio for material is 1-part component A paint, 1-part component B catalyst. No thinner should be added to semi-gloss or flat colors. (Kit yield either 2 gallons or 2 quarts). Must insure mix ratio is exact to obtain desired semi-gloss or flat finish.

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**Induction Time** Although no induction time is needed. Once mixed together, ensure that admixed material is continuously stirred for at least 5 minutes before proceeding.

**Spraying Viscosity** Semi-Gloss/Flat Colors: 19-22 Seconds with #2 Zahn cup

**Pot Life** 7 Hours @ 21° Celsius, 70° Fahrenheit

**Film Thickness** 2-3 MILS DFT (2 Coats @ 1-1.5 DFT) Wet film thickness should be 4-6 MILS total between 2 coats

### Application Instructions

Temperature and Humidity	Minimum	Maximum
Temperature Celsius	11°	35°
Temperature Fahrenheit	52°	95°
Humidity	33%	74%

### Spray Equipment

Spray Gun Type	Tip/Nozzle Size	Cap Pressure	Pot Pressure
Conventional Air	1.3 - 1.6 mm	40 to 60 psi	10 to 20 psi
HVLP	1.4 - 1.6mm	10 psi Maximum	10 to 20 psi
Electrostatic	1.2 - 1.5mm	45 to 60 psi	10 to 40 psi

### Dry Times

Temperature	Wet-Edge	Time Between Coats	Dry to Tape	Dry to Handle	Full Cure
52-65°F (11-18°C)	60 Min	45-90 Min	8-9 Hours	10 Hours	6 Days
66-85°F (19-29°C)	45 Min	30-60 Min	7-8 Hours	9 Hours	6 Days
86-95°F (30-35°C)	30 Min	30-40 Min	6-7 Hours	7-8 Hours	6 Days

Only mix enough material to be applied on initial coat. Always add component B activator to component A paint. Complete kit of material will yield 2 US Gallons (7.5 liters). 1-gallon component A paint, 1-gallon component B activator.

Apply one even wet coat of material using a uniform spray pattern. Cross coat may be used to achieve 100% coverage in one single coat depending on color. Note: Apply only one coat of material to achieve proper gloss requirement of product.

**Application Instructions** PS40 Accelerator (Fast dry additive mix options)

PS40 Accelerator	Dry Between Coats	Dry to Handle	Dry Hard	Pot Life	Full Cure
1% By Volume	12 Minutes	2 Hours	4 Hours	4 Hours	6 Days
1.5% By Volume	10 Minutes	1.5 Hours	3 Hours	3 Hours	6 Days
2% By Volume	5 Minutes	45 Minutes	1 Hour	45 Minutes	6 Days

\*Note: Overuse of PS40 additive may affect product gloss and finish

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<b>Theoretical Coverage</b>	800-900 sq. ft / gallon @ 1 mil    20-22m <sup>2</sup> / liter @1 mil *Coverage based on 100% transfer efficiency rate
<b>Color</b>	Available in all color ranges
<b>Gloss</b>	Semi-Gloss colors: 17-30 @ 60 degrees Flat/Matt Colors: Less than 5 @ 60 degrees *Also available is custom gloss ranges
<b>Volatile Organic Compound</b>	340 – 390 g/l
<b>Shelf Life</b>	24 Months (When stored in climate-controlled environment between 60-80° F) *Product may be re-certified upon inspection by 3Chem.
<b>Safety Instructions</b>	Always read material safety data sheet (SDS) and product label before utilizing this product. Product SDS is available upon request.

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