

# Glair G41 Series

## High Solid Polyurethane Topcoat



**Product** Glair G41 Series High Solid Polyurethane Topcoat

**Item Class** High Solid Polyurethane Topcoat

Glair G41 Series is a high solid polyurethane topcoat formulated to provide superior resistance and long-lasting durability. This product is also formulated to provide excellent chemical resistance and flexibility.

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

AIMS 04.04.012 - MEP 10-061 - PCS-2500 - S 26.3529 - TH 33.0150

**Catalyst & Additives** Catalyst/Activator Thinner Additive

308 (Gloss)	CS34 (High Temperatures)	PS40 Accelerator
312 (Low Gloss)	CM100 (Normal Conditions)	
	CF3 (Low Temperatures)	
*AVAILABLE IN VARIOUS KIT SIZES		

**Use of Primers** 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	Thinner	Mix Ratio
G41-XXXX (Gloss)	308	See Chart Below	1:1:.25 (Max-Optional)
G41-XXXX (Low Gloss)	312	Do not Use	1:1

Shake (Base) for 15 minutes to assure no solid settlement remains in can. Add component B catalyst to component A paint first. Then add recommended thinner reducer from chart below. Refer to thinner option chart below for detailed mixing information. Mix ratio for material is 1-part component A paint, 1-part component B catalyst and between .18 to .25 parts thinner (or 8-12.5% by volume) depending on environmental conditions and applicator preference. Kit including thinner should yield either a maximum of 2.25 gallons or 2.25 quarts. Product viscosity is contingent on environmental conditions. Therefore, check material viscosity to determine exact percentage of thinner to be added while staying within the recommended ranges. For small component application minimal thinning is recommended.

No thinner should be added to low colors. (Kit yields either 2 gallons or 2 quarts). Must ensure mix ratio is exact to obtain desired low gloss finish.

**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.

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**Spraying Viscosity** 17-19 Seconds with #2 Zahn cup (Once thinner is added)

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

**Film Thickness** 2-3 Mills DFT (2 Coats @ 1-1.5 DFT) Wet film thickness should be 4-6 Mills 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
Air Electrostatic	1.2 - 1.5mm	45 to 60 psi	10 to 40 psi

### Dry Times:

Temperature	Thinner	Wet-Edge	Time Between Coats	Dry to Tape	Dry to Handle	Full Cure
52-65°F (11-18°C)	CF3	40 Min	30-50 Min	5-6 Hours	7-8 Hours	6 Days
66-85°F (19-29°C)	CM100	35 Min	30-45 Min	5-6 Hours	7-8 Hours	6 Days
86-95°F (30-35°C)	CS34	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 catalyst to component A paint then add recommended thinner reducer based on environmental condition. Refer to thinner option chart above. Complete kit of material will yield a maximum of 2.25 US Gallons (8.5 liters). 1-gallon component A paint, 1-gallon component B catalyst, 1 quart thinner (32 US oz. / 946 ml).

Always check product viscosity using #2 Zahn cup to confirm exact amount of thinner required to achieve recommended application viscosity. Recommended thinning range is between 8% and 12.5%.

Apply one tack coat of material using a uniform spray pattern. Wait recommend time between coats based on chart above. Initial coat should be tacky before applying second coat. Applying second coat too early will lead to possible running of material. Waiting too long will lead to a dull finish. Mix enough material to be applied on second coat. Use same mixing instruction from initial coat above.

Apply a second medium wet coat using a uniform spray pattern. Second coat must appear wet and uniform once complete. Take care not to leave any dry areas or spots. Wet these areas if necessary, to assure a uniform finish. Wait appropriate dry to tape or dry to handle time based on chart above.

When painting small components using minimal or no reducer, single cross-coat application may be used depending on required DFT desired.

For Low gloss colors: 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.

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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
.5% By Volume	12 Minutes	2 Hours	4 Hours	4 Hours	6 Days
1% By Volume	10 Minutes	1.5 Hours	3 Hours	3 Hours	6 Days
1.5% By Volume	5 Minutes	45 Minutes	1 Hour	45 Minutes	6 Days

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

**Theoretical Coverage** 800-900 sq. ft / gallon @ 1 mil 20-22m<sup>2</sup> / liter @1 mil  
\*Coverage based on 100% transfer efficiency rate

**Color** Available in various colors

**Gloss** Gloss colors: 90 minimum @ 60 degrees  
Low Gloss colors: 10-15 @ 60 degrees

**Volatile Organic Compound** 340 – 390 g/l

**Shelf Life** 24 Months (When stored in climate-controlled environment between 60-80° F)  
\*Product may be re-certified upon inspection by 3Chem.

**Safety Instructions** Always read material safety data sheet (SDS) and product label before utilizing this product. Product SDS is available upon request.

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