

# Glair G34 Series

## High Solid Special Effects Polyurethane



**Product** Glair G34 Series High Solid Special Effects Polyurethane

**Item Class** High Solid Polyurethane Topcoat

Glair G34 Series is a high solid polyurethane decorative coating formulated to provide superior resistance and an astonishing appearance. With unlimited mica and pearlescent color options available, various special effects may be achieved with this system. 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
305	PS40 Accelerator
	HF12 High Humidity Additive
*AVAILABLE IN VARIOUS KIT SIZES	

### 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
G34-XXXX	305	1:1
G31-1004 Clear Coat	305	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. (Kit yield either 2 gallons or 2 quarts).

### 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

17-19 Seconds with #2 Zahn cup

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**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°	38°
Temperature Fahrenheit	52°	100°
Humidity	33%	74%

\*\*For Humidity above 74%, use HF12 Additive. Max recommended relative humidity at application is 90%. HF12 high humidity additive should be added to admix material (paint and activator) at a rate of 3% max by volume.

### 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 at cap	10 to 20 psi
Electrostatic	1.2 - 1.5mm	45 to 60 psi	10 to 40 psi
Air Assist Airless Electrostatic	.23 - .34 mm	40 to 60 psi	700 to 1200 psi

### Dry Time

Temperature	PS40	Wet-Edge	Time Between Coats	Dry to Tape	Dry to Handle	Full Cure
52-65°F (11-18°C)	0.25%	50 Min	1-1.5 Hours	8-10 Hours	12 Hours	6 Days
66-75°F (19-23°C)	0.20%	40 Min	45-60 Min	7-8 Hours	9-10 Hours	6 Days
76-85°F (24-29°C)	0.10%	40 Min	45-60 Min	7-8 Hours	9-10 Hours	6 Days
86-100°F (30-38°C)	N/A	30 Min	45-60 Min	6-7 Hours	7-8 Hours	6 Days

\* Do not use PS40 accelerator in temperatures over 85°F (29°C)

### Dual-Coat Colors (Aluminums, Blacks, Blues, Greens, Oranges, Reds, Silvers, and Yellows):

Only mix enough material to be used on initial application. 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. Apply second coat immediately after completing first coat using 50% less material. Final appearance is the direct result of air and material volume used by the applicator.

Once G34 Series Special Effects Coat is tack dry (refer to dry time schedule on this document), apply one even wet coat of G31-1004 High Solid Polyurethane Clear Coat. A second cross coat may be applied to achieve additional depth in final appearance.

### Tri-coat Colors (Whites and Grays, these colors require a 3-step application process):

Prior to applying G34 Series Special Effects Coating, a single wet coat of G32 Series semi-gloss base coat (of corresponding color) must be applied to substrate to achieve required coverage. Minimum coat thickness should be .8 mil DFT. Once product is tack dry with zero paint transfer, the following steps may be taken.

Only mix enough G34 Series 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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Once G34 Series Special Effects Coat is tack dry (refer to dry time schedule on this document), apply one even wet coat of G31-1004 High Solid Polyurethane Clear Coat. A second cross coat may be applied to achieve additional depth in final appearance.

**Application Instructions** PS40 Accelerator (Fast dry additive mix options for touch up applications)

PS40 Accelerator	Dry Between Coats	Dry to Handle	Dry Hard	Pot Life	Full Cure
0.25% By Volume	12 Minutes	2 Hours	4 Hours	4 Hours	6 Days
0.30% By Volume	10 Minutes	1.5 Hours	3 Hours	3 Hours	6 Days
0.40% By Volume	5 Minutes	45 Minutes	1 Hour	45 Minutes	6 Days

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

**Force Cure:** If deemed necessary oven curing is possible to reduce dry to tape and handle times. After application, allow coating to air dry for 1 hour at room temperature (75° F), then force cure for 2 hours at 120° F.

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

**Dry Film Weight** Per 25 microns: 27-35 g/m<sup>2</sup>  
Per dry mil: .0057-.0082 lbs./ft<sup>2</sup>

**Color** Available in various special effect color ranges

**Gloss** 80-90 @ 60 degrees (Prior to G31 Series clear coat application)

**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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