



G90 Low VOC Topcoat

Technical Data Sheet (TDS)

Product Description

G90 Low VOC Topcoat is a two component highly cross-linked, high performance polyester polyurethane coating providing a high gloss surface finish.

Product features:

- Excellent UV Stability, providing long term gloss and color retention
- Outstanding chemical resistance
- Outstanding abrasion resistance
- Outstanding impact resistance
- Solid Colors Only
- **VOC Compliant**

Recommended Uses

G90 Low VOC Topcoat is intended for industrial applications; either new build or maintenance. EX-2C Topcoat is suitable for application on all Endura primers.

Industries:

- Oilfield & Energy Services
 - Well Service Vehicles
 - Drilling
 - Tanks
- Cranes and Construction Equipment
- Waste and Recycling Industry
 - Garbage Trucks
- Trailers and Rolling Stock

Mix Ratio

2 part by volume of component A [**CLRGXXXXX**]
(Part Number varies with color)
1 part by volume of component B [**FUB0502**]

The recommended temperature when mixed is 68-77°F (20-25°C).

NOTE: Other G90 B components are available for different ambient conditions and application requirements.

See: Component B Selector and Mixing Ratios
Please contact your sales representative if you have any questions.

Product Characteristics

Gloss: High Gloss 90+ GU at 60 deg.

Note: Slight gloss variations will occur depending on color.

Volume Solids Mixed:

70% ± 4% (Depending on color)

Pot Life: 8-10 Hours at 77°F (25°C) and 50% RH

Note: Pot life is reduced when Supercat II is used

VOC Mixed (Unreduced): (EPA Method 24):

White 120: 251 g/l (2.102 lb /gal)

Note: All colors are below 420 g/l (3.5 lb/gal)
VOC content will vary with each color.

Shelf Life:

Component A: 3 years at 77°F (25°C)

Component B: 2 years at 77°F (25°C)

Note: For unopened product

Surface Prep

G90 Low VOC Topcoat Topcoat can be applied over all Endura primer sealers and primer surfacers without sanding during their topcoat window. The topcoat window varies with each primer; see the relevant primer technical data sheet for the specific topcoat window data.

If the primer topcoat window has been surpassed; the primer should be sanded with 240 – 280 grit sandpaper to achieve inter-coat adhesion. All sanding dust must be blown off prior to application of the topcoat.



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Application Method

G90 Low VOC Topcoat can be applied using most spray painting systems.

Note: Assure that any solvent absorbent primer surfacers are properly sealed with a primer sealer prior to application of the topcoat.

Solid Colors:

Apply two single wet coats allowing up to 30 minutes flash time between coats.

It is recommended that a thinner first coat be applied 1.0 - 1.5 mils wet followed by a wet coat of 2.0 – 3.5 mils wet. Allow up to 30 minutes between coats.

Note: When a high-hide version of any solid or metallic color is used it must be clear coated to realize full gloss and UV stability.

Spray Gun Setup

Feed Type	Fluid Tip	Application Pressures (heel of gun)	Fluid Delivery
Siphon Feed	1.6-1.8 mm	40-50 psi	
Gravity Feed	1.3-1.4 mm	30-40 psi	
Pressure Feed	1.0-1.8 mm	50-60 psi	10-14 oz/min
Air Assist Airless	9-17 Thou	1,000-1,800 psi	
Airless	11-13 Thou	1,700-3,000 psi	

Spray Viscosity

Using a Ford 4 Cup (White)

23 Seconds*	23 Seconds*
←—————→	
Conventional	Airless

Note: Spraying viscosity and thinning will depend on ambient conditions, spray equipment used, and the desired surface finish.

To maintain VOC compliance, if required, thin G90 Low VOC Topcoat with Endura Low VOC topcoat Thinners/Reducers. VOC content of the following Reducers: (0g/l, 0lbs/gal)

Up to 20% with FTH0021 – Low VOC Topcoat Thinner/ Reducer
 Up to 20% with FTH0023 – Slow Low VOC Topcoat Thinner / Reducer

Film Build

G90 Low VOC Topcoat has a recommended film build thickness:

Wet: (unreduced): 2.0 – 3.5 mils (50 – 90 microns)

Dry: 1.5 – 2.5 DFT (37.5 – 62.5 microns)

Note: With poor hiding colors film build may be higher.

Theoretical coverage at 1.0 mil (25 microns)
Average DFT: 1125 ft² per gallon at 100% transfer efficiency.

Dry Times

	68°F (20°C)	86°F (30°C)	104°F (40°C)
Dust Free	2 Hours	1 Hour	30 Minutes
Full Cure	7 Days	5-6 Days	3-4 Days

Note: Dry Times are subject to ambient conditions (temperature and humidity) and good airflow and film build of the topcoat.

Note: The use of Super Catalyst II with Endura topcoats will accelerate drying times.



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Clear coat application time:

Solid colors: Minimum 4 hours

Note: The recoat or clear coat times are based on based on 68°F (20°C) and 50% RH and recommended film build.

For best results surface temperature must be 86°F (30°C) or less before topcoating.

Maximum re-coat window without sanding is 16 hrs at 68°F (20°C). After 18 hours G90 Low VOC Topcoat must be sanded to achieve inter-coat adhesion.

Recommended 320 – 400 grit mechanical sanding before topcoating.

Important Note: Ensure that no more than three coats of paint are applied in a 12-hour shift. This includes primer, mid-coat, topcoats and clear coat.

If more than 3 coats have been applied wait 10-12 hours to allow for proper solvent evaporation.

For questions about scheduling please contact your Endura representative.

Component B Selector

G90 H.A.T. B – For use in high ambient temperatures above 86°F (30°C)

2 part by volume of component A **[CLRGXXXXX]**
(Part Number varies with color)
 1 part by volume of component B **[FUB0571]**

Clean Up

Clean all equipment immediately after use with Endura high strength gun wash, Endura epoxy reducer or Endura EX-2C thinner.

Follow manufacturer's safety recommendations when using any solvent.

Ordering Information (sizing)

Available in Gallons and 5 Gal Pails

Other custom sizes may be available.

3 Gallons		
Comp A – 2X Part numbers vary by color	CLRGXXXXX-030	1 Gal
Comp B	FUB0502-030	1 Gal

15 Gallons		
Comp A -2X Part numbers vary by color	CLRGXXXXX-050	5 Gal.
Comp B	FUB0502-030	5 Gal.

Environmental Conditions

For optimum coating performance product, substrate and ambient temperature should be between 68°F-77°F (20°C-25°C). To prevent condensation during application the surface temperature must be 5°F (3°C) or more above the dew point at all times.

Note: For use outside this range please contact your Endura Representative.

Safety Precautions

Please refer to all Safety Data Sheets (SDS) before using this product. SDS sheets can be found on our website at www.polyglasscoatings.com