

## GM350

### 3.5 VOC Glamour Clear

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#### DESCRIPTION

GM350 is a premium high solid's overall clear that has a VOC of 3.5 pounds per gallon. GM350 possesses a "water white" color that eliminates concerns of color change over some basecoat colors, especially white. It has outstanding buffing capabilities and a superior gloss for a glamour appearance.

#### COMPONENTS

- |                           |                                       |
|---------------------------|---------------------------------------|
| • GM350                   | Clearcoat                             |
| • H6                      | Activator                             |
| • S9860/S9870/S9885/S9895 | Fast/Medium/Slow/Very Slow - Reducers |
| • S065/S075/S085          | Fast/Medium/Slow – Zero VOC Reducers  |

#### MIXING RATIO

Mix two (2) parts GM350 clear with one (1) part H6 activator and one (1) part selected reducer. A566 accelerator may be used up to 1 ounce per gallon or ¼ ounce per quart for enhanced drying.

#### POT LIFE AT 77° F

2 hours (without accelerator)

#### CLEAN UP

Use **NORTHSTAR** Lacquer thinner or zero VOC solvents. (Check local regulations)

#### PHYSICAL DATA

Solids wt. (as mixed)	45%
VOC as mixed	3.5
Color	Water white

#### DRY / FLASH TIMES

##### Air Dry at 77° F

Flash between coats	15-30 minutes
Dust Free	45 minutes
Tack Free	30 minutes
Sand & Buff	24 hours

## Force Dry

Flash before force dry  
Force dry time  
Sand & Buff

15 minutes minimum  
40 minutes at 140° F  
after 2 hour cool down

## COLOR SANDING

Wet sand with 1000 to 1500 wet or dry paper, then buff with appropriate compounds and glazes to achieve a high gloss finish.

## GUN SETUPS

### Conventional

Gravity Feed  
Siphon Feed

1.3 mm – 1.5 mm  
1.3 mm – 1.5 mm

## AIR PRESSURES

### Conventional at Gun

Gravity Feed  
Siphon Feed  
HVLP at cap

30 – 40 psi  
35 – 45 psi  
8 – 10 psi

## SURFACE PREPARATION

Use **NORTHSTAR** Clean Wipe (S10) to clean substrate free of grease, dirt, and foreign contaminants.

## APPLICATION

- Apply 2 medium wet coats over substrate to desired film thickness
- Avoid excessive film build on flat or horizontal areas
- Allow 10-15 minutes between coats
- Scuff after 24 hours before applying topcoat or recoating
- Clean gun after spraying is completed
- Note: Flex additive is recommended when flexible part is not on vehicle

## SAFETY

Refer to Material Safety Data Sheet (MSDS) for complete safety instructions. The technical data sheet listed has been compiled in good faith for your convenience and guidance. No warranty, expressed or implied, is intended or given by the information on this sheet.