SHERWIN-WILLIAMS
General Industrial Coatings

Gloss Modified Duraspar® IP

Gloss Modified Duraspar® IP is a 2K polyurethane topcoat system that combines standard Duraspar IP (90°+ gloss) with a flattening base to achieve mid-gloss (60° ± 10), low-gloss (30° ± 10) and flat gloss (<10) black.

1. COMPONENTS

• Duraspar IP	Top Coat
• F63VC30	Duraspar IP FSGM Gloss Modifier
• CTC1163	Duraspar IP Activator (Option 1)
• 53-X145A	Duraspar IP Urethane Curing Agent (Option 2)
• US1	Ultrasolv Reducer Cold (up to 75° F/24° C)
• US2	Ultrasolv Reducer Cool (85° F/29° C)
• US3	Ultrasolv Reducer Moderate (86-95° F/29-35° C)
• US4	Ultrasolv Reducer Warm (95° F/35° C)
• GA1098	Genesis® Super Accelerator
• 71-X245A	Potlife Extender
• YXC1326	Urethane Thixotrope

2. MIXING RATIO

Note: *High Performance Reducer selection should be based on the size of the area to be painted, spray booth air movement and application temperature.*

Option 1
Mix 4 parts Duraspar IP FSGM Gloss Modifier to 1 part CTC1163 Activator and 1 part US series reducer. (Mixing Ratio 4:1:1)

Option 2
Mix 3 parts Duraspar IP FSGM Gloss Modifier to 1 part 53-X145A Urethane Curing Agent and up to 15% US series Reducer

3. ADDITIVES

Add as needed to mixed paint:

- GA1098 Genesis Super Accelerator (at 0.25-1.0 oz/gal)
  - Use of accelerator does not significantly impact time to tape or time to sand
- 71-X245A Potlife Extender (at 0.5-1.0 oz/gal)
- YXC1326 Urethane Thixotrope (at 1-3 oz/gal)

4. POT LIFE @ 77 ˚F (25 ˚C)

@ 77° F (25° C) = 2 hours (as is) or 60 minutes with GA1098 Genesis Super Accelerator

@ 90° F (32° C) = 60 minutes (as is).

5. CLEAN UP

Ketones or aromatics (check local regulations)

6. SURFACE PREPARATION

Finish sand with 180 grit dry sandpaper or equivalent

- Mask all adjacent areas to prevent overspray problems
- Apply the Gloss Modified Duraspar IP over a Sherwin-Williams approved primer
- Do NOT apply the Gloss Modified Duraspar IP directly to metal

Note: Coatings should not be applied at air or surface temperature below 60° F (18° C). The substrate must be at least 5° F (3° C) above the dew point.

7. SUBSTRATES

Prime with Sherwin-Williams -approved primers. Contact your local S-W sales representative for list of approved primers.

8. APPLICATION

Cut in all recessed areas first and paint top to bottom. Apply two coats using cross-coat technique. Apply one medium coat horizontally and then apply one medium coat vertically. Flash times will be dependent on temperature, air flow, reducer selection and if accelerator is used.

Target Wet Film Thickness: 3.0-5.0 mils
Recommended Dry Film Thickness: 1.5-2.5 mils

FOR INDUSTRIAL SHOP APPLICATION ONLY

9. FLASH / DRY TIMES

AIR DRY @ 77° F (25° C) Standard System	
Flash between primer & color coat	45 minutes minimum
Time To Tape	• 2 hours
Time To Sand	• 2 hours
Time to Outdoor Exposure	48 hours at temps. > 60° F, before exposure to outdoors
Recoat Windows:	**Scuff sanding of first coat is required when applying second coats outside these windows**

- Color coat over color coat: 12 hours max at temps up to 90° F
- Color coat over color coat (with accelerator): 8 hours max at temps up to 90° F

FORCE DRY	
Flash after topcoat application	30 minutes minimum
Cure time & temp.	60 minutes at 150° F (oven set point)
Time to Outdoor Exposure	24 hours minimum

10. GUN SET UP

LOW PRESSURE CONVENTIONAL AIR SPRAY GUN	
Tip Size	0.8-1.2 mm
Flow Rates	10-12 oz/min
Atomizing Air	45-60 PSI

12. PHYSICAL DATA

Gloss Level	Flat Black	Satin	Mid-Gloss
VOC (Reduced With US1, US2, US3 or US4)	3.5 lbs/gal (maximum)		
Volume Solids (as supplied)	39-43 %	43-47%	44-48%
Theoretical Coverage	661 ft^2/gal @ 1 mil DFT	721 ft^2/gal @ 1 mil DFT	736 ft^2/gal @ 1 mil DFT
Target WFT	3.0-5.0 mils		
Recommended DFT	1.5-2.5 mils		
Viscosity (Ready To Spray)	18-22 secs # 2 Zahn Cup, Signature Series		
60° Gloss Range	< 10	20-40	50-70

13. SAFETY

Before using any Sherwin Williams product, be sure to read all SDS and application instructions and warnings.