



GLADIATOR XC

TECHNICAL DATA SHEET



Check local VOC regulations to ensure compliance of all products in your area.

DESCRIPTION

Gladiator XC is a high quality, 2K urethane, textured coating that provides a durable, chemical and fade resistant, protective finish for truck beds, recreational vehicles, industrial equipment, restoration and more.

FEATURES

- Tough, durable 2K protective coating
- Excellent fade resistance and UV stability
- 50 state compliant
- T³ True Tint Technology – non-yellowing formula
- Produce a variety of textures with **Economy Coating Gun**, HVLP gun, roller, or brush
- Outstanding adhesion to most surfaces

SUITABLE SUBSTRATES

PROPERLY PREPPED (SEE PREPARATION SECTION)

- Steel
- Aluminum
- Galvanized
- Existing OEM Paint
- Polyester Fillers
- E-Coat
- Fiberglass
- SMC
- GRP
- Plastics
- Wood
- Concrete

TYPICAL PROPERTIES

Part:	Product Name:	Color:	Container:
56650	Gladiator XC Black Kit	Black	RTS Gallon Kit
56609	Gladiator XC Half Pint Catalyst	Clear	Cone Top ¼ Pint
56644	Gladiator XC Quart Catalyst	Clear	Cone Top Quart
56648	Gladiator XC Pint Catalyst	Clear	Cone Top Pint
56654	Gladiator XC Black Quart (Short-Fill)	Black	Cone Top Quart
56655	Gladiator XC Black 5 Gallon Pail	Black	5 Gallon Pail
56670	Gladiator XC Tintable Kit	Tintable	RTS Gallon Kit
56674	Gladiator XC Tintable Quart (Short-Fill)	Tintable	Cone Top Quart
56675	Gladiator XC Tintable 5 Gallon Pail	Tintable	5 Gallon Pail
56680	Gladiator XC Black Quart Kit	Black	RTS Quart Kit



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56690	Gladiator XC Tintable Quart Kit	Tintable	RTS Quart Kit
5665-DR	Gladiator XC Black 54 Gallon Drum	Black	54 Gallon Drum
5667-DR	Gladiator XC Tintable 54 Gallon Drum	Tintable	54 Gallon Drum

PRODUCT SPECIFICATIONS

Kit Contains:	4 each short-filled quart bottles containing base material
	1 pint Gladiator XC Activator
	1 each 71102 Economy Coating Gun
	1 mixing cup
RTS VOC:	Gladiator XC – less than 1.63 #/gal maximum (196 g/L)
Pot Life @ 70°F (21°C) and 50% R.H.:	30 Minutes
Coverage:	150 sq. ft. per gallon (dependent on application method)
Optimal Film Thickness:	10 – 20 mils
Dust Free Time:	30 minutes
Heat Cure Recommendations:	10 minute flash, 30 minutes at 140°F (60°C)
Delivery Time:	8 hours (air dry), allow 48 hours before light use of truck bed; 5 days for full use

Use VOC calculator to determine VOC of mixtures. If applying to a non-automotive substrate, consult local VOC regulations.

Always wear OSHA required (PPE) Personal Protection Equipment as outlined on the SDS and product label to ensure your safety.



PREPARATION

BARE METAL, ALUMINUM, GALVINIZED, POLYESTER FILLER, AND EXISTING OEM PAINT

1. Pressure wash the surface if needed.
2. Clean with **SEM Solve** or **XXX Universal Surface Cleaner**.
3. Sand the surface with P180 grit sandpaper or use a bed brush. Blow off and tack clean.
4. Prime any bare metal and aluminum areas with **World Class™ DTM Primer** or **Metalock™ DTM Primer**.
5. After 24 hours, scuff the primer with a red scuff pad. Blow off dust and tack clean.

Note: Do not apply over self-etching primers.



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FIBERGLASS, RIGID PLASTIC, FLEXIBLE PLASTIC, AND SMC

1. Clean with **SEM Solve** or **XXX Universal Surface Cleaner**. Surface must be completely dry; avoid saturating panel with cleaner.
2. Sand the surface with P180 grit sandpaper, blow off dust and tack clean.

If applying to flexible plastics:

3. Apply one full wet coat of **XXX Adhesion Promoter** or **Plastic Adhesion Promoter**.
4. Allow to flash 3 – 5 minutes before applying **Gladiator XC**. If topcoat time exceeds 24 hours, scuff, tack, and reapply adhesion promoter.

Note: On fiberglass and SMC any exposed fibers below the gelcoat must be primed with a high quality 2K Urethane Primer.

IMPORTANT! **Gladiator XC** will not stick to polyethylene, even with the use of an adhesion promoter.

E-COAT

1. Clean with **SEM Solve** or **XXX Universal Surface Cleaner**.
2. Scuff the surface with a coarse abrasive pad, taking care to not scuff through the e-coat.
3. Blow off dust and tack clean.

WOOD

1. Pressure wash surface first and allow to fully dry.
2. Sand the surface with P80 grit sandpaper, blow off dust and tack clean.

IMPORTANT! Treated wood may interfere with adhesion.

CONCRETE

The following steps do not guarantee adhesion – as some contaminants, such as silicone, are much harder to clean and it may be necessary to clean and prep the concrete several times to achieve adhesion. Always test a small inconspicuous area before coating an entire floor to ensure proper adhesion.

1. Degrease concrete using a commercial degreaser. For heavy oil contamination, heavier caustic cleaners will be needed. Refer to the manufacturer's instructions for exact process.
2. Acid etch the surface using a 1:1 muriatic acid and water combination. It is recommended to perform this step on all concrete to remove any mineral deposits, but is especially important when dealing with any treated, smooth, or polished concrete surfaces, even those that are new. Neutralize and rinse with water thoroughly. Allow to dry completely before coating with **Gladiator XC**.



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Note: On new concrete, it is necessary to wait a month or longer until the concrete is fully dry. Application over concrete that is not fully dry will result in failure. It is recommended to perform both the degreasing and acid etch steps even on new concrete to ensure proper adhesion.

Note: If fixing imperfections in concrete prior to application, do not use any silicone-based products.

Disclaimer:

If there is moisture present under the concrete, and a vapor barrier is not present, lifting of product may still occur no matter how thorough the prep process.

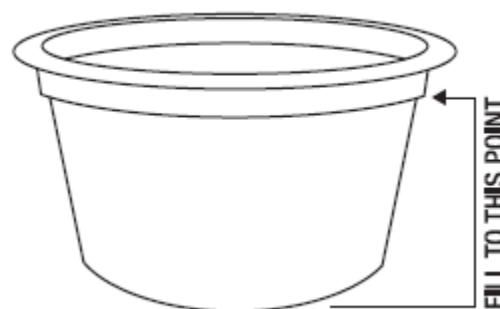
IMPORTANT! Due to the variety of substrates that **Gladiator XC** can be applied to, it is recommended to test a small area for adhesion before applying the product. Full adhesion may take up to 48 hours.



MIXING

Gladiator XC is a shake-and-shoot system.

1. Refer to the below chart for appropriate mix ratios. Note that reduction is not needed when applying with an **Economy Coating Gun** or roller.
2. Shake each bottle individually for two minutes just before applying that bottle. Mix only one bottle at a time. If reducing, use a high-quality urethane reducer.



Note: If using a standard Schutz type applicator, ensure that the pick-up tube reaches the bottom of the **Gladiator XC** bottle.



Gladiator XC

Type here Add 3.7 oz. of **Gladiator XC Activator** per bottle of **Gladiator XC**. Shake each bottle individually for two minutes just before applying that bottle. Do not over-catalyze.

	Coating (A)	Tint	Coating (B)	Reducer (optional)
Gladiator XC Black				
Shake-and-Shoot	1 bottle	n/a	3.7 oz.	Up to 10%
Mix by ratio	7 parts	n/a	1 part	Up to 10%



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Gladiator XC Tintable				
Shake-and-Shoot	1 bottle	3 oz.	3.7 oz.	Up to 10%
Mix by ratio	7 parts	1 part	7:1 after tint	Up to 10%

Note: Tint with premium solvent-based automotive paint. Omit any binders, balancers or reducers called for in the formula; use pigmented toners only. Do not use water-based or lacquer-based colorants. Tint and mix prior to adding activator.



APPLICATION

Note: Applicator guns may need to be cleaned between coats, especially in hot and/or humid conditions.

ECONOMY COATING GUN

Coats:	1 light coat followed by 2 – 3 medium coats
Flash Time between Coats:	5 – 10 minutes @ 70°F (21°C)
Air Pressure:	30 – 65 psi

Note: A final drop coat will lower gloss and change texture. Always spray a test panel to ensure desired texture. Variations in temperature, air pressure, distance from substrate and applicator used will affect texture.



HVLP GUN

Coats:	2 – 3 coats
Flash Time between Coats:	5 - 10 minutes @ 70°F (21°C)
Air Pressure:	10 – 30 psi

IMPORTANT! In hot and/or humid conditions, you must apply lighter coats and allow longer flash times between coats. The first coat should not achieve full coverage and subsequent coats should be applied in the same manner.



ROLL

Coats:	1 medium wet coat
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1. Cut in hard to reach areas with a brush prior to rolling.
2. Using the **Heavy Texture Roller**, slowly apply product in one medium wet coat using medium pressure.
3. Texture can be increased with additional rolling after product starts to set up.



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Note: For uniform appearance, complete all rolling while product is still wet. To avoid trapping solvent do not over apply. Any pooled or over-applied areas should be brushed or rolled out. Do not apply more than one coat.

IMPORTANT! To achieve desired results, SEM only recommends the use of **71140 Heavy Texture Roller**. Should any other roller be used, proper results cannot be assured.



TOPCOATING

Gladiator XC can be painted over with most paint systems

1. If topcoating, let **Gladiator XC** dry for 24 hours.
2. Scuff with fine abrasive pad.
3. Blow off dust and tack clean.
4. Follow paint manufacturer's instructions for paint application.



CLEAN UP

Remove all masking tape while final coat is still wet. Use appropriate cleaning materials compliant with VOC regulations in your area.



STORAGE

Gladiator XC should be stored between 60 – 80°F (16 – 27°C). The shelf life for **Gladiator XC** and **Gladiator XC Activator** is 3 years when stored under ideal conditions.

RELATED PRODUCTS

Part:	Product:	Size:
38371	SEM Solve	Gallon
38373	SEM Solve	20 oz. Aerosol
38374	SEM Solve	Quart
38375	SEM Solve	5 Gallon
39861	Plastic Adhesion Promoter	Gallon
39863	Plastic Adhesion Promoter	20 oz. Aerosol
39864	Plastic Adhesion Promoter	Cone Quart
50121	World Class™ DTM Primer	Gallon
50124	World Class DTM Primer	Quart
50134	World Class DTM Primer Activator	Cone Quart



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50136	World Class DTM Primer Activator	Half Pint
71102	Economy Coating Gun	Each
71140	Heavy Texture Roller	Each
77721	XXX Adhesion Promoter	Gallon
77723	XXX Adhesion Promoter	16 oz. Aerosol
77724	XXX Adhesion Promoter	Cone Quart
77771	XXX Universal Surface Cleaner	Gallon
77774	XXX Universal Surface Cleaner	Quart
77763	XXX Universal Gun Cleaner	20 oz. Aerosol
ML010	Metalock™ DTM High Build Primer Kit	5 Quart Kit
ML014	Metalock DTM High Build Primer	Quart
MLH16	Metalock Hardener	Half Pint

Technical Consultation Service

Our Technical Staff is ready to assist you with any questions. You are invited to take advantage of our extensive experience, laboratory services and trained field service representatives. Call (800) 831-1122 for answers to your questions. Hours of operation are Monday through Thursday 8:00 am until 5:00 pm EST and on Friday 8:00 am until 4:30 pm EST.

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