



GLOBAL REFINISH
SYSTEM

Product Information

DGLV Direct Gloss LV Colour

Global Refinish System DGLV is a high-performance two-pack acrylic urethane topcoat designed for the direct gloss repair and respray of cars and commercial vehicles, where local regulations require a maximum VOC of 3.5 lb./gal.

The performance of Global Refinish System DGLV in a recommended Global repair system meets or exceeds motor manufacturer warranty requirements and the Global Refinish System carries many OEM approvals.

Preparation of Substrate



Apply over original baked finishes or over recommended Global primers.



In all cases, wash all surfaces to be painted with soap and water and then apply the appropriate Global cleaner. See EU134 Global Cleaners bulletin for selection and usage instructions. Ensure that the substrate is thoroughly cleaned and dried both before and after application work.



Apply DGLV Colour after (WET) sanding with European P600-800 / U.S. 400-500 grade paper or dry sanding with European P400-600 / U.S. 360-400 grade paper.

Wash off residues and dry thoroughly before recleaning with appropriate Global substrate cleaner. The use of a tack rag is recommended.

Mixing Ratio:



+ +

DGLV

D884 Hardener

Add Thinner

Add D885/D886

2 vols

1 vol

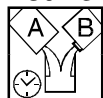
5 – 10% by volume

1 oz. per ready-to-spray quart

Use the below chart to choose the appropriate thinner and additive according to the application temperature:

<i>Temperature</i>	<i>Thinner</i>	<i>Dry Method</i>	<i>Additive</i>
<i>Up to 18°C / 65 °F</i>	D8764	Air Dry	1 oz. D885
<i>18° - 25°C / 65° - 77°F</i>	D8774	Air Dry	1 oz. D885
<i>Over 25°C / 95°F</i>	D8767	Air Dry/Stoving	½ oz. D885 + ½ oz. D886

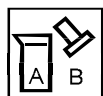
Potlife:



@ 20°C / 68 °F

1 - 2 hours @ 20°C / 68 °F

Additives:



DX84 Accelerator and/or DX87 Extender are required to properly mix DGLV. Use the ratios found in the mixing section.

SLV814 Plasticiser: Mix at **2 : 2 : 1 : 1** (DG : Hardener : D Thinner : SLV814)

Spraygun set-up:



Fluid Tip

1.3 – 1.5 mm or equivalent

Spray Viscosity

20 - 30 secs ZAHN 2 @ 20°C / 68°F

Spray pressure:

HVLP

0.7 bar / 10 PSI (at air cap)

Conventional

3 - 4 bar / 45 – 55 PSI (at spray gun)

Number of coats:



Apply

2 – 3 coats or until hiding

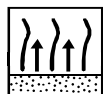
Film build per wet coat

2.0 mils

Dried film build per coat

1.0 mils

Flash off at 20°C / 68°F:



Between coats

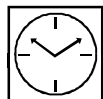
3 – 7 minutes

Before stoving

0 – 10 minutes

APPLICATION GUIDE (Continued)

Drying times:



Dust-free
20°C / 68°F: 50 – 70 minutes



Dry to handle
20°C / 68°F: 6 – 8 hours



Tape Time
20°C / 68°F: 6 – 8 hours
60°C / 140°F: 3 hours



IR (Infrared)
Medium Wave: 24 hours
Short Wave: 30 minutes
10 – 15 minutes, depending on colour.
8 minutes, depending on colour.

Note: Stoving times are for quoted metal temperatures. Additional time should be allowed in the stoving schedule to allow metal to reach recommended temperature.

Recoat:



Recoat After surface has cooled if stoved, or
After 8 hours minimum @ 20°C / 68 °F

Sanding:



Grade wet European P800 / U.S. 500
Grade dry European P400 / U.S. 360

For best adhesion, sanding is essential before recoating

Overcoat:



Overcoat with With any Global primers, topcoats or clearcoats.
Clearcoats can be applied after a minimum of 2 hours dry.

Performance Guidelines:

Recoating times will be extended at lower temperatures. Global Refinish System DGLV may be sanded with 1200 grit paper or finer and polished when hard, to rectify minor imperfections.

Fading Out:

After spot repairing, mix equal parts of RTS CLV and D853, Global Refinish System Fade-Out Thinner. Spray this mixture around the repaired area to lose the edge and blend the repair into the surrounding panel. Spray starting from the outside of the repair, moving to the center.

Product Compatibility

DGLV may be applied over...

Cured Air Dry Finishes
OEM Basecoat/Clearcoat (*must be sanded*)
OEM Enamels (*must be sanded*)
OEM & Refinish Lacquers (*must be sanded & sealed*)
D820 Plastic Adhesion Promoter
D822 Corrosion Resistant Primer (*not in Rule 1151 area*)
D831 Chromate Free Wash Primer (*must be sealed or primed afterwards*)
D891 Sealer (*not in Rule 1151 area*)
D8080 UV Cured Primer Surfacer
SX/SXA 1050 Plastic Adhesion Promoter (*Specialty Performance Products*)
SX1056 Flexible 2K Sealer
SX1057 Flexible 2K Surfacer
SX1080 2K Rollable Surfacer LV

Technical Data:**Total dry film build:**

<i>Minimum</i>	50µ / 2 mils
<i>Maximum</i>	100µ / 4 mils

Theoretical coverage: 10.3 m² per liter / 417 sq.ft. per U.S. gal.

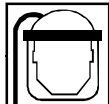
Note: Theoretical coverage in m² /litre and sq.ft./US gal. ready-to-spray (RTS), giving 50 µm (2 mils) dry film thickness.

Percent solids by volume RTS: 52%

RTS Combinations:	DGLV	DGLV : D884 + D87XX + D885/D886	DGLV : D884 : D87XX : SLV814 + D885/D886
Volume Ratio:	Package Color (as is)	2 : 1 + 10% + 1 oz/qt	2 : 2 : 1 : 1 + 1 oz/qt
Applicable Use Category	Single-Stage Ctg	Single-Stage Ctg	Single-Stage Ctg (flexed)
VOC Actual (g/L)	452 - 515	330 - 371	221 - 260
VOC Actual (lbs/gal)	3.77 - 4.30	2.76 - 3.10	1.85 - 2.18
VOC Regulatory (less water less exempt) (g/L)	452 - 515	364 - 419	304 - 354
VOC Regulatory (less water less exempt) (lbs/gal)	3.77 - 4.30	3.04 - 3.50	2.54 - 2.96
Density (g/L)	983 - 1353	1017 - 1255	1065 - 1213
Density (lbs/gal)	8.20 - 11.29	8.49 - 10.47	8.89 - 10.12
Volatiles wt. %	33.4 - 49.3	35.1 - 44.7	46.4 - 52.5
Water wt. %	0.0	0.0	0.0
Exempt wt. %	0.0	8.7 - 10.4	28.1 - 31.1
Water vol. %	0.0	0.0	0.0
Exempt vol. %	0.0	9.0	27.1

Health and Safety

See Material Safety Data Sheet and Labels for additional safety information and handling instructions.



- The contents of this package must be blended with other components before the product can be used. Before opening the packages, be sure you understand the warning messages on the labels and MSDS's of all the components, since the mixture will have the hazards of all its parts.



- Improper handling and use, for example, poor spray technique, inadequate engineering controls and/or lack of proper Personal Protective Equipment (PPE), may result in hazardous conditions or injury.



- Follow spray equipment manufacturer's instructions to prevent personal injury or fire.
- Provide adequate ventilation for health and fire hazard control.
- Follow company policy, product MSDS and respirator manufacturer's recommendations for selection and proper use of respiratory protection. Be sure employees are adequately trained on the safe use of respirators per company and regulatory requirements.
- Wear appropriate PPE such as eye and skin protection. In the event of injury, see first aid procedures on MSDS.

Always observe all applicable precautions and follow good safety and hygiene practices.

Emergency Medical or Spill Control Information (412) 434-4515; In Canada (514) 645-1320

Materials described are designed for application by professional, trained personnel using proper equipment and are not intended for sale to the general public. Products mentioned may be hazardous and should only be used according to directions, while observing precautions and warning statements listed on label. Statements and methods described are based upon the best information and practices known to PPG Industries. Procedures for applications mentioned are suggestions only and are not to be construed as representations or warranties as to performance, results, or fitness for any intended use, nor does PPG Industries warrant freedom from patent infringement in the use of any formula or process set forth herein.

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