

2K High Performance Primer Surfacer

EU-151



D8035

Product Description:

GLOBAL REFINISH SYSTEM™ D8035 2K High Performance Primer Surfacer is a speed primer designed for spot and panel repairs which offers outstanding film build, fast dry to sand times and excellent resistance to film shrinkage.

D8035 delivers maximum throughput for operations striving for premium performance and unsurpassed refinish repairs.

D8035 is easy to spray and can be applied to a wide range of substrates. D8035 is also rollable.

Preparation of Substrate:



- Wash the area to be painted with soap and water, then clean with appropriate PPG Cleaner.
- Original paintwork should be sanded using US 240 / European P280 grit discs (dry) or US 320 / European P360 grade paper (wet). Exposed bare metal should be spot-primed with a suitable bare metal primer.
- Electrodeposition Primer must be thoroughly cleaned as outlined above. Abrade the electrodeposition primer as recommended in the "original paintwork" section.
- Aluminum, Bare Steel and Galvanized Steel must be clean, rust-free and abraded thoroughly using US 180 / European P180 to US 240 / European P280 grit paper and then apply a suitable bare metal treatment/primer.
- Polyester Body Fillers should be dry sanded with US 180 / European P180 followed by US 240 / European P280 grit paper.
- Gel Coated Fiber glass and SMC should be dry sanded using US 240 / European P280 grit paper.
- Plastic should be dry sanded with US 400 / European P600 (use a finer grit for softer plastics), cleaned, and primed with an appropriate PPG adhesion promoter.

Required Products

Hardener

D8291 2K Chromatic Hardener
D8295 2K Undercoat Hardener - High Temp 90°F (32°C) and above

Thinner

D870	Fast Thinner	65°F (18°C)
D871	Medium Thinner	65-77°F (18-25°C)
D872	Slow Thinner	77-95°F (25-35°C)
D873	Very Slow Thinner	95°F (35°C) and above

D8035

Application Guide

Mix Ratios:

Standard

D8035 4 Vols.
D8291/D8295 Hardener 1 Vol.
D87x Thinner 1 Vol.

Rollable

D8035 4 Vols.
D8291/D8295 Hardener 1 Vol.

Note: Thinner is not required for rollable application.

**Pot Life:**

Standard with D8291: 25-30 minutes at 70°F (21°C)
High Temp with D8295: 15-20 minutes at 90°F (32°C)
Rollable: 20 minutes at 70°F (21°C)

Note: Pot Life may be considerably shorter when temperatures exceed 70°F (21°C). Clean equipment immediately after each use. **Best practice is to Mix, Shoot, Clean**

Additives:



D814 Plasticiser: 5% to RTS by volume
SL814 Universal Flexibilizer: 5% to RTS by volume

Note: Allow increased flash time between coats. The use of D814/SL814 will slow flash and overall dry times.

Spraygun Setup:



Fluid Tip: 1.4 - 1.8 mm or equivalent

Note: For best overall results, refer to spraygun manufacturer's recommendations for inlet air pressures.

Spray Pressure:

HVLP: 10 psi at the air cap
Compliant: 29 - 40 psi at the gun

Number of Coats:



Apply: 2-3 medium wet coats

Dry film build per coat: 2.0-2.5 mils

Total dry film build:

Minimum after sanding: 2.0 mils
Maximum after sanding: 6.0 mils

Flash Off:



Between Coats: 3-5 minutes at 70°F (21°C)
As temperatures increase over 70°F (21°C), flash times will be shortened.
Back-to-Back coats may be necessary with increased temperatures.

Drying Times:



Air dry to sand: 30-45 minutes
70°F (21°C)



Force dry to sand: 10-15 minutes
140°F (60°C)
Increased film builds will extend dry to sand times.



IR:
Medium Wave: 10 minutes
Short Wave: 5 minutes



*Bake times quoted are for metal temperature. Additional time should be allowed in the force drying schedule to allow metal to reach recommended temperature.

D8035

Application Guide

Overcoat/Recoat:

**Dry to Topcoat:**

70°F (21°C)

30-45 minutes and after sanding

140°F (60°C)

10-15 minutes and after sanding

**Grade Wet:**

400-600 grit

Grade Dry Machine:

320-500 grit

**Overcoat with:**

Global Refinish System BC Basecoat

Global Refinish System Sealers

CONCEPT® (DCC) Acrylic Urethane

ENVIROBASE® High Performance Basecoat

Envirobase High Performance Sealers

ONECHOICE® Sealers

Equipment Cleaning:

Spray guns, gun cups, storage pots, etc. should be cleaned thoroughly after each use with any PPG general purpose solvent, lacquer thinner or DT Reducer.

Technical Data:

	<u>Primer Surfacer</u>	<u>Primer Surfacer Flexed</u>
	D8035 : D8291/D8295 : D87x	D8035 : D8291/D8295 : D87x +D814/SL814
Volume Ratio	4:1:1	4:1:1+5%
% solids by volume RTS	41.1	40.5
% solids by weight RTS	59.4-60.0	58.6-59.1
VOC Regulatory (Less water less exempt)	3.63-3.95 lbs./ US gal. (435-473 g/L)	3.71-4.03 lbs./ US gal. (445-483 g/L)
Theoretical Coverage (1 mil @100% transfer efficiency)	659	650

Health and Safety:

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



- The contents of this package may have to 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 SDS's of all the components, since the mixture will have the hazards of all of 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 SDS 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 SDS.
- Always observe all applicable precautions and follow good safety and hygiene practices.

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Mix: Standard



D8035 : D8291/D8295 Hardener : D87x Thinner
4 : 1 : 1

Thinner Selection:

D870	Fast Thinner	65°F (18°C)
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D872	Slow Thinner	77-95°F (25-35°C)
D873	Very Slow Thinner	95°F (35°C) and above

Rollable



D8035 : D8291/D8295 Hardener
4 : 1

Pot Life:



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Rollable:	20 minutes at 70°F (21°C)

Note: Pot Life may be considerably shorter when temperatures exceed 70°F (21°C). Clean equipment immediately after each use. **Best practice is to Mix, Shoot, Clean**

Air Pressure:



HVLP:	10 psi at the air cap
Compliant:	29 - 40 psi at the gun
Fluid Tip:	1.4 - 1.8 mm or equivalent

Application:



Apply:	2-3 medium wet coats
Between Coats:	3-5 minutes at 70°F (21°C)

As temperatures increase over 70°F (21°C), flash times will be shortened.

Dry Times:



Air dry to sand:	30-45 minutes at 70°F (21°C)
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Force dry to sand*:	10-15 minutes at 140°F (60°C)
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Increased film builds will extend dry to sand times.



IR:	
Medium Wave:	10 minutes
Short Wave:	5 minutes



Dry to Topcoat:	
70°F (21°C)	30-45 minutes and after sanding
140°F (60°C)	10-15 minutes and after sanding



Grade Wet:	US 400 / P600 grit
Grade Dry Machine:	US 320 / P500 grit

*Bake times quoted are for metal temperature. Additional time should be allowed in the force drying schedule to allow metal to reach recommended temperature.

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Important: 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 of all components since the mixture will have the hazards of all its parts. Improper spray technique may result in a hazardous condition. Follow spray equipment manufacturer's instructions to prevent personal injury or fire. Follow directions for respirator use. Wear eye and skin protection. Observe all applicable precautions.

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 public. Products mentioned may be hazardous and should only be used according to direction, 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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