This product is no longer available through PPG distribution centers as of October 2004.

EU123CA

D8002

ULTRA HIGH SOLIDS SURFACER

PRODUCT DESCRIPTION

D8002 Ultra High Solids Surfacer is a grey Low VOC, two-pack primer surfacer for use under Global topcoat colours. D8002 must be activated with D8205 UHS Hardener.

PREPARATION OF SUBSTRATE

In all cases, wash with soap and water, then select the appropriate Global cleaner(s) from the guide below, and ensure that the substrate is thoroughly cleaned and dried both before and after preparation work.



Original Paintwork and Electrodeposition Primer must be sanded using European P280 / U.S. 240 grit discs (dry) or European P360 / U.S. 320 grade paper (wet).Exposed bare metal should be spot-primed with a suitable bare metal primer (see below).

Bare Steel, Galvanized Steel and Aluminium must be clean, rust-free and thoroughly abraded and primed with one coat of D831 Chromate-free Wash Primer.

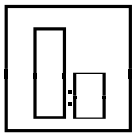
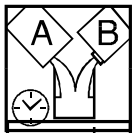
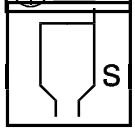
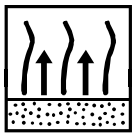
Polyester Body Fillers should be dry sanded using European P240 / U.S. 240 grit paper.



Fibre Glass and SMC should be dry sanded using European P240 / U.S. 240 grit paper.

GUIDE TO SELECTION OF SUBSTRATE CLEANER

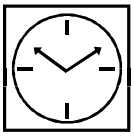
Code	*Product*	*Purpose*
D837	Spirit Wipe	Suitable for removing dirt, grease or other contaminants before or during the painting process.
D842	Low VOC Cleaner	Particularly designed to remove contaminants after sanding, and in areas where VOC emissions should be minimized.
D846	Degreasing Agent for Plastics	A fast, effective degreaser specially formulated to avoid adverse effects on plastic substrates.

	APPLICATION GUIDE	
	*Mixing Ratio*	D8002 2 vol D8205 1 vol An addition of 5 - 10 % by volume of acetone is allowed where aceton is designated an exempt solvent.
	*Potlife*	30 mins. @ 20°C / 68°F The maximum acetone addition will give a 30 min. increase in potlife
	*Spray viscosity*	30 secs ZAHN #2 @ 20°C / 68°F
	Spraygun set-up	1.2 - 1.5 mm or equivalent
	*Spray pressure*	3 - 4 bar / 45 - 55 PSI
	Number of coats	2 - 4
	*Flash off at 20 °C / 68 °F:* *between coats* *before stoving*	 5 - 10 minutes 10 minutes

APPLICATION GUIDE	
Drying times:	
dust-free at 20 °C / 68°F	10 minutes
through dry:	
dry to sand	
20°C / 68°F	2 - 3 hours
60°C / 140°F	30 minutes*
IR medium	20 minutes
Total dry film build:	
minimum	50 µm / 2 mils
maximum	150 µm / 6.0 mils
*theoretical coverage ** *	7.0 m² per litre / 235 sq.ft. per US gal.
Percent solids by volume RTS	70.7%
Flatting:	
grade dry	European P320 - P360 / U.S. 280 - 320 followed by European P1000 - P1200 / U.S. 400 - 600
grade wet	European P320 - P360 / U.S. 280 - 320 followed by European P1000 - P1200 / U.S. 400 - 600 topcoat within 4 hours after sanding
Overcoat / recoat time	- if re-work is necessary - 2 hours
Overcoat with	any Global topcoat or sealer

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

** *Theoretical coverage in m ^{2}/litre and sq.ft./US gal. ready-to-spray (RTS), giving 100 mm (4 mils) dry film thickness*











PERFORMANCE AND LIMITATIONS

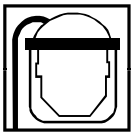
The use of HVLP spray equipment can provide an increase in transfer efficiency of a minimum of about 10% depending on the make and model of equipment used.

If D8002 is used for spot priming, the panel to be primed must be thoroughly sanded beyond the edge of the spot repair.

PROPERTIES

VOC

(D8002:D8205, 2:1)	288 gms per litre / 2.4 lbs per US gal. (When used in a non-exempt area.)
(D8002:D8205, 2:1)	252 gms per litre / 2.1 lbs per US gal. (When used in a exempt area.)







HEALTH AND SAFETY

See Material 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 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 (304) 843-1300; 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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