

## D8113 Matt Clearcoat used for the repair of matt finished Lamborghinis including the Black Nemesis Gallardo

The following process outlining the repair of Lamborghini's matt finished paint schemes has been approved by Lamborghini. When repairing Lamborghini vehicles, you should contact your PPG representative for full documentation on the approved product systems and processes.

### Preparation:

- D8113 Matt clearcoat must be applied on top of a clean and dust-free basecoat. The use of a tack rag like SX1070 is recommended.

### Mix Ratio:

- D8113 Matt clearcoat used for Lamborghini repairs must be mixed on a scale to maintain the accuracy of the mixed components.

*\*Note: For Lamborghini's matt black Gallardo (0109 Black Nemesis) ONLY, D8113 Matt Clearcoat must be mixed with D740 black prior to being catalyzed and reduced (see table below);*

D8113 / D740 Black Nemesis Clearcoat	D8113 Matt Clearcoat (parts)	D740 Black (parts)
1 Liter	<b>1034.0 g</b> (1168.0)	<b>2.1 g</b> (2.4)
.75 of a liter	<b>775.5 g</b> (876.0)	<b>1.6 g</b> (1.8)
.50 of a liter	<b>517.0 g</b> (584.0)	<b>1.0 g</b> (1.1)
.25 of a liter	<b>258.5 g</b> (292.0)	<b>.5 g</b> (.6)

- D8113 Matt clearcoat or D8113/D740 black Nemesis clearcoat must be catalyzed and reduced on a scale as follows (see table below).

### Cumulative Amounts (parts)

RTS target volume in Liters:	D8113 or D8113/D740 mix:	D8239 hardener	D871 or D872 thinner
0.10 liter	<b>56 g</b> (63.2)	<b>75 g</b> (84.7)	<b>100 g</b> (113.0)
0.20 liter	<b>113 g</b> (125.6)	<b>150 g</b> (169.4)	<b>201 g</b> (227.0)
0.25 liter	<b>141 g</b> (159.3)	<b>188 g</b> (212.4)	<b>251 g</b> (283.5)
0.50 liter	<b>282 g</b> (318.5)	<b>375 g</b> (423.6)	<b>503 g</b> (568.2)
0.75 liter	<b>423 g</b> (477.8)	<b>563 g</b> (636.0)	<b>754 g</b> (851.7)
1.00 liter	<b>564 g</b> (634.8)	<b>751 g</b> (848.3)	<b>1005 g</b> (1135.2)
2.00 liter	<b>1128 g</b> (1274.2)	<b>1502 g</b> (1696.7)	<b>2010 g</b> (2270.5)

### Mix Product Details:

Pot Life:	@ 70°F (21°C)	4 hours
RTS Spray Viscosity	@ 70°F (21°C)	15 seconds using a DIN4
Recommended Spraygun set-up:	TECHNA 1.2 SATA RP3000 SATA 3000	7E7 1.2 1.3

### Two / Three Coat Process:

The preparation of color test panels to check the color and number of coats of clearcoat needed to achieve the correct matt effect is strongly recommended. The original matt finish can sometimes become less matt over time due to weathering and cleaning processes used by car owners. D8113 can be used to replicate this gloss level by applying an additional coat.

#### *Notes:*

- ***Blending or fading out matt color or clear is not possible***
- ***The clearcoat can be de-nibbed to remove minor imperfections after the flash off time between coats by using P600 grit along with SXA330 as a lubricant. Any de-nibbing must be completed before the final coat of matt clear is applied.***
- ***Dirt removal from the final coat is not possible***

### Application (1<sup>st</sup> coat):

- Apply 1 single coat with 80% overlap to the whole panel being repaired.
- Flash off at least 40 – 50 minutes ensuring the clearcoat has flashed completely matt before applying the next coat.

*Note: Refer to the color test panel to verify the number of coats needed to achieve the correct level of gloss. If 3 coats are required then ...*

### Application (2nd coat if necessary):

- Apply 1 single coat with 80% overlap to the whole panel being repaired.
- Flash off at least 40 – 50 minutes ensuring the clearcoat has flashed completely matt before applying the next coat.

### Application (Final coat):

- Apply the final coat of clear as a cross coat, i.e., 1 pass in one direction with 80% overlap, followed immediately by a second pass at right angles to the first pass.
- The second coat is applied from approximately a 40% greater distance between the spraygun and the panel.

*Note: This final coat application process must be followed no matter if you spray 2 coats or 3 coats. (The more coats that are applied will increase your final level of gloss.)*

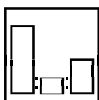
### Bake:

- Allow the final coat to flash at least 40 minutes ensuring the clearcoat is completely matt before baking.

Through Dry:	140°F (60°C)	60 minutes
--------------	--------------	------------

- The listed bake time is for quoted metal temperature. Additional time should be allowed in the bake schedule to allow the metal to reach the recommended bake temperature.

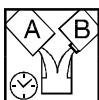
## D8113 Lamborghini Application Summary:



Mix by weight on a scale

### **Cumulative Amounts (parts)**

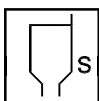
RTS target volume in Liters:	D8113 or D8113/D740 mix:	D8239 hardener	D871 or D872 thinner
0.10 liter	<b>56 g</b> (63.2)	<b>75 g</b> (84.7)	<b>100 g</b> (113.0)
0.20 liter	<b>113 g</b> (125.6)	<b>150 g</b> (169.4)	<b>201 g</b> (227.0)
0.25 liter	<b>141 g</b> (159.3)	<b>188 g</b> (212.4)	<b>251 g</b> (283.5)
0.50 liter	<b>282 g</b> (318.5)	<b>375 g</b> (423.6)	<b>503 g</b> (568.2)
0.75 liter	<b>423 g</b> (477.8)	<b>563 g</b> (636.0)	<b>754 g</b> (851.7)
1.00 liter	<b>564 g</b> (634.8)	<b>751 g</b> (848.3)	<b>1005 g</b> (1135.2)
2.00 liter	<b>1128 g</b> (1274.2)	<b>1502 g</b> (1696.7)	<b>2010 g</b> (2270.5)



Pot Life

@ 70°F (21°C)

4 hours



Application Viscosity

15 seconds using a DIN 4



Spraygun size

TECHNA 1.2

7E7

SATA RP3000

1.2

SATA NR3000

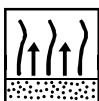
1.3



**1 – 2 single coats – 80% overlap**

40 – 50 minutes flash between coats

Final coat – 1 coat applied same as previous coats followed by one pass at right angles to the 1<sup>st</sup> and with a 40% greater gun distance. (*Approximately an 80% overlap on passes*)



Flash at least 40 minutes before baking - ensure clearcoat is completely matt before bake



Through dry

@ 140°F (60°C)

60 minutes

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