AUTOMOTIVE REFINISH

GLOBAL
REFINISH
SYSTEM

Product Information

Sealer

D891

D891 Sealer is a grey two-pack sealer for use under Global topcoat colours. It is designed to give the optimum topcoat appearance. It must be activated with D892 Catalyst.

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 should be sanded using European P400 / U.S. 360 grit discs (dry) or European P600 / U.S. 400 grade paper (wet). Exposed bare metal should be spot-primed with a suitable bare metal primer (see below).

Bare Steel and Galvanized Steel must be clean, rust-free and abraded thoroughly using European P180 / U.S. 180 to European P280 / U.S. 240 grit paper (wet). Then prime with one coat of D831 Chromate-free Wash Primer.

Aluminum must be clean, rust-free and abraded thoroughly using European P180 / U.S. 180 to European P280 / U.S. 240 grit paper (wet) before application. For maximum corrosion resistance, apply one coat of D831 Chromate-free Wash Primer.

Polyester Body Fillers should be dry sanded using European P400 / U.S. 360 grit paper.

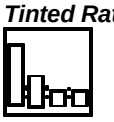
Fibre Glass and SMC should be dry sanded using European P400 / U.S. 360 grit paper.

APPLICATION GUIDE

Mixing Ratio:

D891	**2 vols**
D892	**1 vol**

Tinted Ratio:



D891	**4 vols**
D892	**2 vols**
Thinner	**1 vol**
DG	**1 vol**

Thinner Selection:

Temperature	*Thinner*
Up to 18°C / 65 °F	D870
18° - 25°C / 65° - 77°F	D871
25° - 35°C / 77° - 95°F	D872
Over 35°C / 95°F	D873

Note: D8700 Retarder may be mixed with thinners in temperatures over 35°C / 95°F. Up to 25% of the retarder can be mixed with the appropriate thinner. Do not use alone as a reducer.

Potlife:

1 hour @ 20°C / 68°F

Additives:

None

Spraygun set-up:

Fluid Tip	1.4 - 1.6 mm or equivalent
Spray Viscocity	21 - 22 seconds ZAHN 2 (Signature type) @ 20°C / 68°F

Spray pressure:

HVLP at air cap	0.7 bar / 10 PSI
Conventional at spray gun	3 - 4 bar / 45 - 55 PSI

Number of coats:

1 – 2 coats

Flash off at 20º C / 68º F:

Between coats	5 – 10 minutes
Before Topcoat	20 minute minimum (1 coat) 45 minute minimum (2 coats) **Note:** After 8 hours maximum, product must be sanded and the sealer reapplied.

Drying times:

Dust-free 20ºC / 68ºF:	15 minutes

Drying times: (Continued)

Through dry
20ºC / 68ºF:

Sandable after 1 – 2 hours

Through dry
60ºC / 140ºF

15 – 20 minutes (if rework is necessary)*

Through dry IR medium

10 minutes

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

Overcoat:

Flatting

Grade dry	European P1000 / U.S. 500
Grade wet	European P1000 / U.S. 500

Overcoat with

Any Global Topcoat

Performance Guidelines:

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

Technical Data:

Total dry film build:

minimum	25 µm / 1.0 mil
maximum	50 µm / 2.0 mils

Theoretical coverage:

Percent solids by volume RTS:

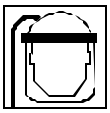
(D891:D892, 2:1)	21.1 m² per l / 859 sq. ft. per US gal.
(D891:D892:D872:DG, 4:2:1:1)	18.1 m² per l / 743 sq. ft. per US gal.

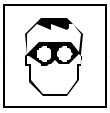
VOC:

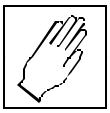
(D891)	419 gms per litre / 3.5 lbs per US gal.
(D891:D892, 2:1)	419 gms per litre / 3.5 lbs per US gal.
(D891:D892:D872:DG, 4:2:1:1)	491 gms per litre / 4.1 lbs per US gal.

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 rained 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 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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Global At A GLANCE

D891

Sealer

Mix Ratio: 	**D891** **D892**	**2 vols** **1 vol**
Tinted Ratio: 	**D891** **D892** **Thinner** **DG**	**4 vols** **2 vols** **1 vol** **1 vol**
Thinner	***Temperature*** Up to 18°C / 65 °F 18° - 25°C / 65° - 77°F 25° - 35°C / 77° - 95°F Over 35°C / 95°F	***Thinner*** D870 D871 D872 D873
	Note: D8700 Retarder may be mixed with thinners in temperatures over 35°C / 95°F. The retarder can be mixed up to 25% with the appropriate thinner. Do not use alone as a reducer.	
Pot life: 	*@ 20°C / 68°F*	1 hour
Air Pressure: 	*HVLP:* *Conventional:* *Fluid tip:*	0.7 bar / 10 PSI 3 - 4 bar / 45 - 55 PSI 1.3 - 1.5 mm or equivalent
Application: 	*Apply:* *Between coats:*	1 – 2 coats 5 – 10 minutes
Dry Times: 	*Dust-free* 20°C / 68°F:	15 minutes
	*Dry to sand* *20°C / 68°F:*	Sandable after 1 – 2 hours
	*Dry to sand* *60°C / 140°F*	15 – 20 minutes (If rework is necessary)*
	Dry to sand IR medium	10 minutes
	*Dry to Topcoat* *20°C / 68°F:*	20 minute minimum (1 coat) 45 minute minimum (2 coats) After 8 hours, product must be sanded and sealer reapplied.
	**Stoving times are for quoted metal temperature. Additional time should be allowed in the force drying schedule to allow metal to reach recommended temperature.*	

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