

Low VOC Performance Clear

EU-112

D893



GLOBAL REFINISH
SYSTEM™

Product Description:

GLOBAL REFINISH SYSTEM™ D893 Low VOC Performance Clear is a premium quality high solids clearcoat specifically formulated for today's high production shop. The force dry time of D893 is up to 50% lower than traditional clears. D893 can be polished within minutes after cooling down.

D893 is designed for use over *Global Refinish System BC* (see data sheet EU02) and *ENVIROBASE®* High Performance basecoat colour (see data sheet EB143).

Preparation of Substrate:



- In all cases, wash surfaces to be painted with soap and water, then apply the appropriate PPG substrate cleaner. Ensure that the substrate is thoroughly cleaned and dried both before and after application work.
- Wet sand with European P800-P1200 / US 500-600 grade paper or dry sand with European P600-P800 / US 400-500 grade paper.
- Wash off residue and dry thoroughly before recleaning with appropriate PPG substrate cleaner. The use of a tack rag is recommended.

Required Products

Hardener

- D884 High Solids Hardener (Air Dry/ General Purpose)
D887 High Solids Hardener (Stoving/ Mar Resistance)

Thinner

- D870 Fast Thinner 60-65°F (15-18°C)
D871 Medium Thinner 65-77°F (18-25°C)
D872 Slow Thinner 77-95°F (25-35°C)
D873 Very Slow Thinner Over 95°F (35°C)
DT8110 May replace up to 25% of recommended thinner levels in very warm conditions.

Note: Smaller areas may require faster thinner.

D893

Mix Ratios:



D893:	3 vols.
D88x Hardener:	1 vol.
D87x Thinner:	1 vol.

Pot Life:



1-1½ hours at 68°F (20°C)

Additives:



SU4985 Matting Agent:	See ONECHOICE® OC-2
D899 Anti-Silicone:	0.5 fl. oz. per RTS quart
D814 Plasticiser:	
SL814 Universal Flexibilizer:	

D893	:	D88x	:	D87x	:	D814/SL814
2	:	1	:	1	:	1

Spraygun Setup:



Fluid Tip: 1.3-1.5 mm or equivalent

Spray Pressure:

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

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

Number of Coats:



Apply:	2 coats
Dry film build per coat:	1.0-1.25 mils
Maximum dry film build:	3.0 mils

Drying Times:



Between Coats: 5-10 minutes
68°F (20°C)



Dust Free: 20-25 minutes
68°F (20°C)

Dry to Handle: 4 hours
68°F (20°C)

Tape Time: 5-6 hours
68°F (20°C)

Air Dry: 8 hours
68°F (20°C)



Force Dry*: 0-15 minutes purge
140°F (60°C) 15-20 minutes



IR:
Medium Wave: 15 minutes
Short Wave: 8 minutes



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

D893

Overcoat/Recoat:



Overcoat/Recoat Time: 10 hours at 68°F (20°C) or 2 hours after force dry and cool down
D893 must be sanded before recoating with primer, colour or clear.



Grade Wet: European P800-P1200 / US 500-600
Grade Dry: European P600-P800 / US 400-500



Overcoat with: Envirobase High Performance basecoat, Global Refinish System BC basecoat.

Recoat times will be extended at lower temperatures

Polishing:



Use a 3 step process.

1. After bake cycle and 1 hour cool down, use a premium wool pad with a minor cutting compound.
2. Follow with a medium foam pad with machine glaze.
3. Use a soft foam pad with a fine glaze to remove any minor imperfections.

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 D87x Thinner.

Technical Data

RTS Combinations	D893 : D88x : D872	D893 : D88x : D872 : D814/SL814
Volume Ratio	3:1:1	2:1:1:1
VOC Regulatory (less water less exempts) g/L	498	521
VOC Regulatory (less water less exempts) lbs./ US gal	4.16	4.35
Solids vol. %	40.0	37.9
Sq. Ft. Coverage / US gal. 1 mil at 100% transfer efficiency	642	608

Health and Safety:



- 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.

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

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.

PPG Automotive Refinish
19699 Progress Drive
Strongsville, OH 44149
800.647.6050

PPG Canada Inc.
2301 Royal Windsor Drive, Unit #6
Mississauga, Ontario L5J 1K5
888.310.4762

Follow us online:
www.ppgrefinish.com



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








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Product Information Effective 11/15



Low VOC Performance Clear

Mix:		D893 3	:	Hardener 1	:	"D" Series Thinner 1				
		Hardener				Thinner				
		D884		High Solids Hardener (Air Dry/ General Purpose)		D870 Fast Thinner 60-65°F (15-18°C)				
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Additives:		SU4985 Matting Agent:				See OC-2				
		D899 Anti-Silicone:				0.5 fl. oz. per RTS quart.				
		D814 Plasticiser:								
		SL814 Universal Flexibilizer:		D893	:	D88x	:	D87x	:	D814/SL814
				2	:	1	:	1	:	1
Pot Life:		1-1½ hours at 68°F (21°C)								
Air Pressure:		HVLP:		10 psi at the air cap						
		Compliant:		29-40 psi at the gun						
		Fluid Tip:		1.3-1.5 mm or equivalent						
Application:		Apply:		2 coats						
		Between Coats:		5-10 minutes at 68°F (20°C)						
Dry Times:		Dust Free:		20-25 minutes at 68°F (20°C)						
		Dry to Handle:		4 hours at 68°F (20°C)						
		Tape Time:		5-6 hours at 68°F (20°C)						
				After bake cycle at 140°F (60°C) and cool down						
		Force Dry:**		0-15 minutes purge						
				15-20 minutes at 140°F (60°C)						
		IR:								
		Medium Wave:		15 minutes						
		Short Wave:		8 minutes						
		Overcoat/Recoat:		After force dry/cool down or 10 hours at 68°F (20°C)						
		<i>Must be sanded before recoating with primer, colour or clear</i>								
		Grade Wet:		European P800-P1200 / US 500-600						
		Grade Dry:		European P600-P800 / US 400-500						

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