

EU125/CA

# D8107

## 2.1 Stoving Clear

### PRODUCT DESCRIPTION

Global Refinish System D8107 2.1 Stoving Clear is a premium, compliant clear formulated to meet VOC limits in effect in many Air Quality Districts in Southern California. D8107 must be activated with D8207 2.1 Stoving Clear Activator.

D8107 is designed to be used over Global BC Colour (see Data Sheet EU02).

### PREPARATION OF SUBSTRATE

Wash all surfaces to be painted with soap and water. Degrease all surfaces with appropriate Global substrate cleaner (see selection guide below) before wet sanding with European P800-1200 / U.S. 500-600 grade paper or dry sanding with European P600-800 / U.S. 400-500 grade paper.

Wash off residues and dry thoroughly before re-cleaning with appropriate Global substrate cleaner (see selection guide below). The use of a tack rag is recommended.

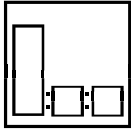
Apply Global BC Colour over original stoved finishes or over recommended Global Primers (eg. D860, D824, D891, etc.). See Data Sheet EU02 for Global BC system application details.

**Note:** Can be used on flexible substrates, no additives needed.

### GUIDE TO SELECTION OF SUBSTRATE CLEANER

<i>Code</i>	<i>Product</i>	<i>Purpose</i>
D837	Spirit Wipe	Suitable for removing 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.

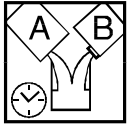




## APPLICATION GUIDE

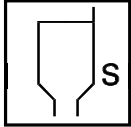
*Mixing Ratio*

D8107	3 vol
D8207	1 vol
D8767	1 vol



*Potlife*

1 1/2 - 2 hours @ 20°C / 68°F



*Spray viscosity*

15 - 23 secs ZAHN #2(Signature type) @ 20°C / 68°F

*Spraygun set-up*

1.3 - 1.5 mm or equivalent

*Spray pressure*

*HVLP at air cap*

*Conventional at spray gun*

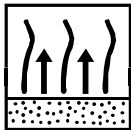
0.7 bar / 8-10 PSI

3 - 4 bar / 45 - 55 PSI



*Number of coats*

1 full wet with decreased fluid volume  
followed by  
1 full wet with normal fluid volume  
(see "Performance and Limitations", page 4)

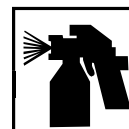
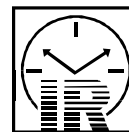
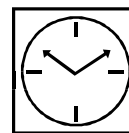


*Flash off at 20°C / 68°F:  
between coats  
before stoving*

5 - 10 minutes

0 - 10 minutes

APPLICATION GUIDE	
<p><i>Drying times:</i>  <i>dust-free</i>  20°C / 68°F dry to handle</p> <p><i>through dry:</i>  20°C / 68°F  60°C / 140°F  IR medium</p> <p><i>Total dry film build:</i>  <i>minimum</i>  <i>maximum</i></p> <p><i>theoretical coverage**</i></p> <p><i>** Theoretical coverage in m<sup>2</sup>/litre and sq.ft./US gal. ready-to-spray, giving 50 <math>\mu</math>m (2 mils) dry film thickness for D8107.</i></p>	<p>N/A  Must be Stoved</p> <p>Must be Stoved  20 minutes  20 minutes</p> <p>50<math>\mu</math>m / 2 mils  70<math>\mu</math>m / 3 mils</p> <p>10.0 - 10.2 m<sup>2</sup> per l /  311 sq.ft. per US gal.</p>
<p><i>Percent solids by volume RTS</i></p> <p><i>Flatting:</i>  <i>grade wet</i>  <i>grade dry</i></p> <p><i>Overcoat / recoat time</i></p> <p><i>Overcoat with</i></p>	<p>38.8%</p> <p>D8107 must be sanded before recoating to insure good adhesion.  European P800 - 1200/ U.S. 500 - 600  European P600 - 800 / U.S. 400 - 500</p> <p>After stoving/cool down</p> <p>Any Global primer or topcoat</p>



## PERFORMANCE AND LIMITATIONS

Allow the Global BC Colour to flash off for 15 minutes (but no longer than 24 hours) before applying D8107 Clear. The timing will depend on B/C film thickness and temperature.

Adjust the fluid volume on the gun lower before applying the first coat of D8107. Spray the coat to look as you want the final appearance to look. Apply the second coat with normal fluid volume to achieve the same appearance.

Recoating times will be extended at lower temperatures. Global D8107 may be sanded with 1200 grit paper or finer and polished when hard, to rectify minor imperfections.

## FADING OUT - D8107 CLEAR

After spot repairing, clean the gun and spray Global Blending Thinner D853 around the repaired area to lose the edge and blend the repair into the surrounding panel. Start from the outside of the repair, moving to the centre.

## PROPERTIES

VOC SCAQMD Rule 1151 ( Less exempt solvent )

(D8107)

240 gms per litre/2.0 lbs per US gal.

(D8107:D8207:D8767, 3:1:1)

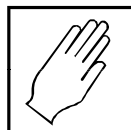
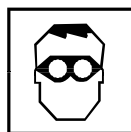
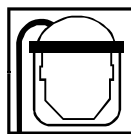
250 gms per litre/1.7 lbs per US gal.

## 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 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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