2K Chromatic Sealer (National Rule)

EU-140

D8081 White D8087 Black
D8085 Gray D8088 Red

GLOBAL REFINISH SYSTEM™

Product Description:
GLOBAL REFINISH SYSTEM™ 2K Chromatic Sealer (National Rule) D808x, are premium quality primer sealers suitable for the advanced technology finishes used in today's refinish collision centers.

The fast drying 2K Chromatic Sealers have superior flow properties and excellent gloss holdout. A variety of Chromatic grays can be achieved by intermixing the sealer colour choices. The sealers can be used over sanded original finishes and/or properly prepared and treated bare steel, aluminum, fiberglass and plastic.

Preparation of Substrate:

- In all cases, wash with soap and water, then use the appropriate *Global Refinish System* cleaner. See EU-134 *Global Refinish System* Cleaners bulletin for selection and usage instructions. Ensure that the substrate is thoroughly cleaned and dried both before and after preparation.
- **Original Paintwork** should be sanded using European P400 / US 360 grit discs (dry) or European P600 / US 400 grade paper (wet). Exposed bare metal should be spot-primed with a suitable bare metal primer (see below).
- **Electrodeposition Primer** must be thoroughly cleaned and may then be directly overcoated with the 2K Chromatic Sealer NR as a Wet-on-Wet Sealer without abrading.
- **Aluminum, Bare Steel and Galvanized Steel** must be clean, rust-free and abraded thoroughly using European P180-P280 / US 180-240 grit paper. These substrates **must be primed with a *Global Refinish System* Etch Primer.**
- **Polyester Body Fillers** should be dry sanded using European P280 / US 240 grit paper.
- **Fibre Glass and SMC** should be dry sanded using European P280 / US 240 grit paper.
- **Plastic** should be dry sanded with European P600 / US 400 grit paper (use a finer grit for softer plastics) and prime first with a PPG Plastic Adhesion Promoter.

Required Products

Hardener
D8291 2K Chromatic Hardener

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 Thinner over 95°F (35°C)

2K Chromatic Surfacer (NR) EU-140

D8081/D8085/D8087/D8088

Mix Ratios:

D808x 2K Sealer:	3 vols.
D8291 2K Hardener:	1 vol.
D Series Thinner:	1 vol.

Pot Life:

2 hours at 68°F (20°C)

Additives:

D814 Plasticiser:	up to 10% to RTS volume
SL814 Universal Flexibilizer:	up to 10% to RTS volume

Spraygun Setup:

Fluid Tip:	1.4-1.6 mm or equivalent
Spray Viscosity:	20-25 seconds #2 Zahn at 68°F (20°C)

Spray Pressure:

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

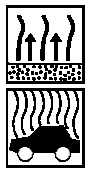
Note: For best overall results, refer to spraygun manufacturer's recommendations for inlet air pressures.

Number of Coats:

Apply: 1-2 wet coats

Total wet film build per coat:	2.5 mils / 63.5 µ
Total dry film build per coat:	1.0 mils / 25.4 µ

Drying Times:



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

Dust Free:
68°F (20°C) 10 minutes

Dry to Handle:
68°F (20°C) 60 minutes

Tape Time:
68°F (20°C) 1½ hours

Force Dry*: 5-10 minutes purge at 68°F (20°C) before stoving

IR:

Medium wave:	10 minutes
Short wave:	5 minutes

Overcoat/Recoat:

Dry to Topcoat:
68°F (20°C) 15 minutes
After 72 hours, sealer must be sanded. If sanded film is below 1 mil, sealer must be reapplied.

Grade Wet:	European P1000 / US 500
Grade Dry:	European P1000 / US 500

Overcoat with: *Global Refinish System* BC, CONCEPT® DCC or ENVIROBASE® High Performance topcoat systems

D8081/D8085/D8087/D8088

Technical Data:

Total dry film build:

Minimum after sanding:	1.0 mils / 25.4 µ
Maximum after sanding:	1.5 mils / 38.1 µ
Film build per wet coat:	2.5 mils / 63.5 µ
Dried film build per coat:	1.0 mils / 25.4 µ

Performance Guidelines:

- The use of HVLP spray equipment can give an increase in transfer efficiency of about 25% depending on the make and model of equipment used.
- For all substrates except un-sanded electrodeposition primer, ensure that they surface is thoroughly sanded to the panel edge or to a distance several centimeters beyond the damaged area, whichever is the smaller.
- Do not attempt spot repair on original or refinish thermoplastic applications, lacquer or 1K finishes.
- Partially used cans of hardener must be carefully closed.

RTS Combinations	**D808x : D8291 : D87x**	**D808x : D8291 : D87x + D814/SL814**
Volume Ratio	3 : 1 : 1	3 : 1 : 1 +10%
VOC Regulatory (Less water, less exempts) g/L	476-518	491-527
VOC Regulatory (Less water, Less exempts) lbs./US gal	3.97-4.32	4.10-4.40
Solids vol. %	33.5	33.1
Solids wt. %	48.5	47.5
Theoretical Coverage - Sq. Ft. / US gal. RTS 1.0 mil dry film thickness	537	531

D8081/D8085/D8087/D8088

Chromatic Gray Mixing Chart 2K Chromatic Sealer NR

This chart can be used to mix the 2K Chromatic Sealer.
The G1-G7 ratios will help to achieve better hiding when used as a guide for mixing the 2K Chromatic Sealer.

Mix Ratio By Volume			Mix Ratio By Cumulative Weight							
			Grams				Parts			
	Mix Ratio		¼ Pint	½ Pint	Pint	Quart	¼ Pint	½ Pint	Pint	Quart
G1	D8081	3	109.6	219.3	38.5	877.0	123.5	247.0	494.0	988.0
	D8291	1	132.7	265.4	530.8	1061.6	149.5	299.0	598.0	1196.0
	D87x	1	152.7	305.3	610.6	1221.2	172.0	343.9	687.9	1375.7
G3	D8081	2	73.1	146.2	292.3	584.7	82.3	164.7	329.3	658.6
	D8085	1	109.1	218.2	436.3	872.7	122.9	245.8	491.5	983.1
	D8291	1	132.2	264.3	528.7	1057.3	148.9	297.8	595.5	1191.1
	D87x	1	152.1	304.2	608.4	1216.9	171.4	342.7	685.4	1370.8
G5	D8085	3	108.0	216.0	432.0	864.0	121.7	243.3	486.6	973.3
	D8291	1	131.1	262.2	524.3	1048.6	147.7	295.3	590.6	1181.3
	D87x	1	151.0	302.1	604.1	1208.2	170.1	340.3	680.5	1361.1
G6	D8085	2	72.0	144.0	288.0	576.0	81.1	162.2	324.4	648.9
	D8087	1	109.4	218.9	437.8	875.5	123.3	246.6	493.2	986.3
	D8291	1	132.5	265.0	530.1	1060.2	149.3	298.6	597.2	1194.3
	D87x	1	152.5	304.9	609.9	1219.8	171.8	343.5	687.0	1374.1
G7	D8087	3	62.4	124.8	249.6	499.3	70.3	140.6	281.2	562.4
	D8291	1	100.9	201.8	403.5	807.0	113.6	227.3	454.5	909.1
	D87x	1	134.1	268.2	536.5	1073.0	151.1	302.2	604.4	1208.7

D8081/D8085/D8087/D8088

Health and Safety:
See 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 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.

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EMERGENCY MEDICAL OR SPILL CONTROL INFORMATION (412) 434-4515; IN CANADA (514) 645-1320

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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Bringing innovation to the surface.™

2K Chromatic Sealer NR

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D-Thinner:	1 vol.

Hardener
D8291 2K Chromatic Hardener

Thinner
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Pot Life:

2 hours at 68°F (20°C)

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Fluid Tip:	1.4-1.6 mm or equivalent
HVLP:	10 psi at the air cap
Compliant:	29 - 40 psi at the gun
Spray Viscosity:	20-25 seconds #2 Zahn at 68°F (20°C)

Application:

Apply:	1-2 wet coats
Total wet film build per coat:	2.5 mils / 63.5 µ
Total dry film build per coat:	1.0 mils / 25.4 µ

Dry Times:

Flash Off:	5-10 minutes at 68°F (20°C)
Dust Free:	10 minutes at 68°F (20°C)
Dry to Handle:	60 minutes at 68°F (20°C)
Force Dry:	5-10 minutes purge before stoving
IR: Medium Wave	10 minutes
Short Wave	5 minutes
To Topcoat:	15 minutes at 68°F (20°C) *After 72 hours, sealer must be sanded. If sanded film is below 1 mil, sealer must be reapplied.*
Grade Wet:	European P1000 / US 500
Grade Dry:	European P1000 / US 500
Overcoat with:	*Global Refinish System* BC, *Concept* DCC or *Envirobase* High Performance topcoat systems.

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