



GLOBAL REFINISH
SYSTEM



May 2006

Product Information

2K GREYMATIC UHS PRIMA

D8018 White
D8019 Black
D8024 Grey

PRODUCT DESCRIPTION

2K GreyMatic UHS Prima is a range of 2K primer surfacers suitable for a wide range of repair work. Versatile, quick-drying and easy to apply and sand, they offer excellent corrosion resistance, film build, surface leveling and gloss holdout over a wide range of substrates such as sound original paintwork, bare steel, polyester body fillers and suitable adhesion primers.

By simple adjustment of the thinning ratio, 2K GreyMatic UHS Prima may be applied as a primer surfacer, as a high build spray filler, or as a wet-on-wet surfacer. 2K GreyMatic UHS Prima may be air dried, low baked or IR cured.

It can be directly overcoated with Deltron GRS BC, Deltron GRS DG, Deltron GRS UHS, Deltron Progress UHS DG or Envirobase basecoat.

By combining D8018, D8019 and D8024 (see **GreyMatic** section), a range of 4 grey shades can be obtained. By using the relevant grey shade (GreyMatic 1,3 ,5 or 7) as a tinted undercoat, the topcoat consumption and the total repair process time may be reduced.

PREPARATION OF SUBSTRATE – DEGREASING



Before any preparation work, wash all surfaces to be painted with soap and water. Rinse and allow to dry before degreasing with a suitable PPG substrate cleaner: Ensure all substrates are thoroughly cleaned and dried before and after each stage of the preparation work. Always wipe substrate cleaner off the panel surface immediately, using a clean, dry cloth.

Please see **Deltron Cleaners (RLD63)** Technical Data Sheet for appropriate substrate cleaning and degreasing products.

These products are for professional use only.

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PREPARATION OF SUBSTRATE - PRIMING & SANDING



Bare Steel should be lightly abraded and completely rust free before application. GreyMatic may be applied directly, but Universel or DP40 bare metal primers are recommended where optimum adhesion and corrosion resistance is required.



Other bare metals should be pre-primed with either Universel or DP40.

Electropaint should be sanded with P360 grade paper (dry) or P800 grade (wet).



Original Paintwork or Primers should be sanded using P280-P320 grade paper (dry) or P400-P500 grade paper (wet). Spot prime any exposed bare metal with bare metal primer Universel or DP40.



GRP or Fibreglass should be sanded using P320 grade paper (dry).

Polyester Fillers should be dry sanded using a sequence of grade of paper grades suitable for the chosen application of D8023 :

P80-P120 when using as a spray filler.

P80-P120-P240 when using as a primer surfacer or non-sand surfacer.

HARDENER & THINNER SELECTION

Using:

HS Hardeners

MS Hardeners

| <u>Temperature</u> | <u>HS Hardener</u> | <u>Thinner</u> | <u>MS Hardener</u> | <u>Thinner</u> |
|--------------------|--------------------|----------------|--------------------|----------------|
| Up to 18°C | D8208 | D808 | D803/D864 | D808 |
| 18-25°C | D897 | D866/D807 | D841 | D866/D807 |
| 25-35°C | D897 | D812 | D861 | D812 |
| Above 35°C | D897 | D869 | D861 | D869 |

When using GreyMatics as a non-sand surfacer, it is recommended that the same hardener be used in subsequently applied direct gloss colour or clearcoat. Consult the appropriate technical datasheets(s) to identify a suitable common hardener.

MIXING RATIOS

1. Mixing Ratios using HS Hardeners:

| | <u>Spray Filler</u> | <u>Primer Surfacer</u> |
|-----------|---------------------|------------------------|
| UHS Prima | 6 vol | 6 vol |
| Hardener | 1 vol | 1 vol |
| Thinner | 0 – 0.5 vol | 1 vol |

2. Mixing Ratios using MS Hardeners:

| | <u>Spray Filler</u> | <u>Primer Surfacer</u> |
|-----------|---------------------|------------------------|
| UHS Prima | 4 vol | 4 vol |
| Hardener | 1 vol | 1 vol |
| Thinner | 0 – 0.5 vol | 1 vol |

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MIXED PRODUCT DETAILS

| <i>Using:</i> | HS Hardeners | | MS Hardeners | |
|-------------------------------|---------------------|------------------------|---------------------|------------------------|
| <i>Applied as a:</i> | Spray Filler | Primer Surfacer | Spray Filler | Primer Surfacer |
| Potlife at 20°C: | 30-40min | 60min | 30-60 min | 75 min |
| Spray viscosity DIN4/20°C: | 40-85 sec | 25-35 sec | 25-60 sec | 20-30 sec |



SPRAYGUN SETUP

| <i>Using:</i> | HS Hardeners | | MS Hardeners | |
|------------------------|--|------------------------|---------------------|------------------------|
| <i>Applied as a:</i> | Spray Filler | Primer Surfacer | Spray Filler | Primer Surfacer |
| Fluid Tip, Gravity: | 2.0-2.2mm | 1.6-1.8mm | 2.0-2.2mm | 1.6-1.8mm |
| Suction: | not recommended | 1.8-2.0mm | not recommended | 1.8-2.0mm |
| Pressure: | Follow spraygun manufacturer's recommendations | | | |

APPLICATION GUIDE

| <i>Using:</i> | HS Hardeners | | MS Hardeners | |
|------------------------------------|---------------------|------------------------|---------------------|------------------------|
| <i>Applied as a:</i> | Spray Filler | Primer Surfacer | Spray Filler | Primer Surfacer |
| Number of coats: | max. 3 | 2-3 | max. 3 | 2-3 |
| Flash off/20°C: - between coats | 10 minutes | 10 minutes | 10 minutes | 10 minutes |
| - before stoving | Do not force dry | 10 minutes | Do not force dry | 10 minutes |

DRYING TIMES

| <i>Using:</i> | | HS Hardeners | | MS Hardeners | |
|---|---------------------------|---------------------|------------------------|---------------------|------------------------|
| <i>Applied as a:</i> | | Spray Filler | Primer Surfacer | Spray Filler | Primer Surfacer |
|  | Dust free/20°C | 10 minutes | 10 minutes | 10 minutes | 10 minutes |
| | Touch dry/20°C | 3-4 hours | 2-3 hours | 3 hours | 2 hours |
| | Sandable/20°C | | | | |
| | (below 100 microns) | 5 hours | 5 hours | 5 hours | 5 hours |
| | (above 100 microns) | 6 hours | 6 hours | 6 hours | 6 hours |
|  | Through dry/60°C | Do not force dry | 30 minutes* | Do not force dry | 30 minutes* |
| | Through dry/ IR medium | Do not force dry | 20 minutes | Do not force dry | 20 minutes |

* Drying time once substrate reaches 60°C metal temperature.

FILM PROPERTIES

| <i>Using:</i> | | HS Hardeners | | MS Hardeners | |
|----------------------|--|---------------------|------------------------|---------------------|------------------------|
| <i>Applied as a:</i> | | Spray Filler | Primer Surfacer | Spray Filler | Primer Surfacer |
| Dry film builds: | | | | | |
| - minimum | | 100µ | 80µ | 100µ | 80µ |
| - maximum | | 200µ | 140µ | 200µ | 140µ |

SANDING



By machine dry: P400



By hand wet: P800

TOPCOATING

UHS Prima may be overcoated directly with the following topcoat products:

Global Refinish System/Deltron BC Basecoat Colour
Global Refinish System/Deltron DG Direct Gloss Colour
Global Refinish System/Deltron UHS Ultra High Solids Direct Gloss Colour
Global Refinish System/Deltron Progress UHS DG Colour
Envirobase Waterborne Basecoat Colour

LIMITATIONS

Accelerators should NOT be used. Part used cans of hardener must be carefully closed immediately after use. All equipment must be perfectly dry. Use of UHS Prima is not recommended when humidity levels exceed 80%.

FLEXIBLE SUBSTRATES

Using:

HS Hardeners

| | | |
|---------------|-----------|-------|
| Mixing Ratio: | UHS Prima | 6 vol |
| | Hardener | 1 vol |
| | D814 | 1 vol |
| | Thinner | 1 vol |

MS Hardeners

| | |
|-----------|-------|
| UHS Prima | 4 vol |
| Hardener | 1 vol |
| D814 | 1 vol |

GUIDE TO USING UHS PRIMA AS A WET ON WET SURFACER

WITH HS HARDENERS

| | |
|--------------------------------------|------------------|
| Mixing Ratios using HS Hardeners: | <u>By Volume</u> |
| UHS Prima | 6 vol |
| Hardener | 1 vol |
| Thinner | 1.5 - 2.5 vol |
| Number of coats | 1-2 |
| Spray viscosity DIN4/20°C | 18-25 sec. |
| Flash off between coats @ 20°C | 10 minutes |
| Drying before Topcoat: | |
| Before BC, DG UHS or Progress UHS DG | 20-30 minutes |
| Before Envirobase Waterborne topcoat | 30 minutes. |

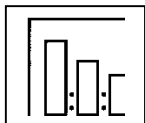
WITH MS HARDENERS

| | |
|--------------------------------------|------------------|
| Mixing Ratios using MS Hardeners: | <u>By Volume</u> |
| UHS Prima | 4 vol |
| Hardener | 1 vol |
| Thinner | 2 vol |
| Number of coats | 1-2 |
| Spray viscosity DIN4/20°C | 14-16 sec. |
| Flash off between coats @ 20°C | 10 minutes |
| Drying before Topcoat: | |
| Before BC, DG UHS or Progress UHS DG | 20-30 minutes |
| Before Envirobase Waterborne topcoat | 30 minutes. |

Do not exceed the 30 minute/20°C flash off before topcoat application.

When using GreyMatics as a wet on wet surfacer, it is recommended that the same hardener be used in subsequently applied direct gloss colour or clearcoat. Consult the appropriate technical datasheets(s) to identify a suitable common hardener.

GREYMATIC UHS PRIMA



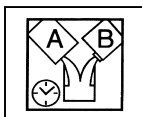
Mixing by volume

With HS Hardener -

| | |
|--------------------|-------------------|
| As Spray Filler | 6 : 1 : 0 - 0.5 |
| As Primer Surfacer | 6 : 1 : 1 |
| As a Wet on Wet | 6 : 1 : 1.5 – 2.5 |

With MS Hardener -

| | |
|--------------------|-----------------|
| As Spray Filler | 4 : 1 : 0 - 0.5 |
| As Primer Surfacer | 4 : 1 : 0.8 |
| As a Wet on Wet | 4 : 1 : 2 |

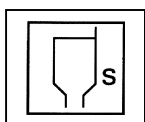


| | |
|-----------------------------------|---|
| Pot Life at 20°C with HS hardener | 30 - 40 minutes as Spray filler, 60 minutes as Primer Surfacer |
| Pot Life at 20°C with MS hardener | 30 - 60 minutes as Spray filler, 75 minutes as Primer Surfacer |

Hardener / Thinner Selection

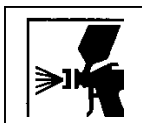
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|------------|--|
| Up to 18°C | D8208 HS Fast hardener or D803 MS Fast Hardener D808 Fast thinner |
| 18 - 25°C | D897 HS Hardener or D841 MS Medium Hardener D807 Thinner - or D866 Primer Thinner . |
| Over 25°C | D897 HS Hardener or D861 MS Slow Hardener D812 Slow thinner |

For exceptional conditions of Temperature and humidity
(above 35°C or 70% RH) the use of D869 is recommended.

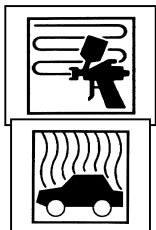


Application viscosities

| | |
|-------------|--|
| HS Hardener | 40 - 85 seconds DIN4 - Spray Filler, 25 - 35 seconds DIN4 - Primer Surfacer, 18 - 25 seconds DIN4 – Wet on Wet |
| MS Hardener | 25 - 60 seconds DIN4 - Spray Filler, 20 - 30 seconds DIN4 - Primer Surfacer, 14 - 16 seconds DIN4 – Wet on Wet |



| | |
|----------------|--|
| Spraygun Sizes | 2.0 - 2.2 mm fluid tip - Spray Filler 1.6 - 1.8 mm fluid tip - Primer Surfacer 1.4 – 1.6 mm fluid tip – Wet on Wet |
|----------------|--|



| | |
|-----------------|---|
| Number of Coats | Spray Filler 3 maximum Primer Surfacer 2 – 3, Wet on Wet 1 – 2 |
|-----------------|---|

Drying Times

| | |
|---------------------|--|
| Dust Free - | 10 minutes |
| Through dry at 20°C | 3 - 4 hours as Spray Filler, 2 - 3 hours as Surfacer, |
| To topcoat | 30 minutes Wet on Wet. |

Dry Film Builds

approx. 100-200 microns as Filler,
approx. 80 - 140 microns as Surfacer

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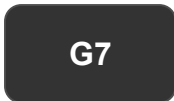
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GREYMATIC SELECTION

GreyMatic shades are selected according to topcoat colour. The recommended GreyMatic shade for any colour can be referenced in the PPG colour information systems.

As a guide, see below.

| | | | |
|---|---|--|---|
| G1 D8018 | G3 D8018 70% D8024 30% (Mix by Wt.) | G5 D8024 | G7 D8019 |
|  |  |  |  |
| <div><u>Use</u> <u>under:</u> Whites Light Greys Light Yellows Light Greens Light blues</div> | <div><u>Use</u> <u>under:</u> Medium greys Yellows</div> | <div><u>Use</u> <u>under:</u> Dark greys Dark Yellows Greens Blues Light and medium reds</div> | <div><u>Use</u> <u>under:</u> Blacks Dark greens Dark blues Dark reds</div> |

After selecting the correct GreyMatic shade for the topcoat colour, the primer shades are made by reference to the chart above. GreyMatic 1, 5 and 7 are available straight from the can. GreyMatic 3 is a blend of D8018/D8024 as indicated above. Mix with hardener & thinner as indicated in this TDS before application.

HEALTH AND SAFETY

These products are for professional use only, and are not to be used for purposes other than those specified. The information on this TDS is based on present scientific and technical knowledge, and it is the responsibility of the user to take all necessary steps in order to ensure the suitability of the product for the intended purpose. For Health and Safety information please refer to the material Safety Data Sheet, also available at: http://www.ppg.com/PPG_MSDS

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