



GLOBAL REFINISH
SYSTEM



November 2007

Product Information



D8080

D8080 – UV Cured Primer Surfacer
D8403 – Surface Degreaser for UV Primer

PRODUCT DESCRIPTION

D8080 UV Cured Primer Surfacer is a unique UV cured undercoat suitable for small area repair of minor dents and scratches. Repair process times using D8080 are extremely rapid, with easy application from ready-to-spray aerosol packaging and just a 2 minute through cure time using an approved UV lamp.

D8403 – Surface Degreaser for UV Primer is a degreaser for surface cleaning immediately after the UV cure process.

PREPARATION OF SUBSTRATE

Degreasing



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.

Use an appropriate substrate cleaner/degreaser. PPG make a range of cleaning & degreasing products. See Technical Datasheet **Deltron Cleaners RLD63V** for cleaners & degreasers.

PREPARATION OF SUBSTRATE continued

Priming and Sanding



Ensure the surface to be repaired is thoroughly sanded either to the panel edge or to a distance several centimetres beyond the area to be primed. **Do not** pre-prime with 1K primers or wash etch primers such as D831 Universel.



Original Paintwork or OE Electropaint should be sanded using minimum P400 grit discs (dry) or P600 grade paper (wet). Preparation using just a Scotchbrite pad will not ensure adequate surface adhesion.

Bare Steel and Aluminium must be clean, rust-free and abraded thoroughly using P180 to P280 grade paper before application.

Galvanized Steel must be thoroughly abraded.

Polyester Body Fillers should be dry sanded using P280 grade paper.

Fibreglass and GRP / SMC should be dry sanded using P400 grade paper.

Proper preparation of **plastic substrates** is essential. Degrease with D846, use a fine brush to clean grained surfaces. Dry sand rigid plastics with P400 grade paper, flexible plastics with a finer grade such as P600. Do not use D8080 directly over PE or polystyrene.

Wash off residues and dry thoroughly before re-cleaning with the appropriate PPG substrate cleaner.

MIXING RATIOS

The product is packaged in an aerosol, no mixing is needed. Simply shake the can to dislodge the internal metal ball, then shake vigorously for a further 2 minutes.

APPLICATION AND DRYING



Number of coats: *Minor dents and scratches*

Apply up to 6 continuous coats to achieve the maximum recommended film thickness of 120 microns

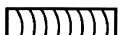
Spraying distance: 15 - 20cm
D8080 contains fluorescent dyes and will glow when exposed to the UV lamp for curing.

Use a suitable application technique to achieve a graduated film thickness across the repair area and a feather edge.

*Total dry film
build/coat:*

Minimum after sanding 50 µm
Maximum after sanding 120 µm

APPLICATION AND DRYING continued

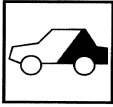


Drying times at 20°:



- *UV cure* Direct light from the UV curing lamp at the repair area for 2 minutes at a distance of 15 - 20cm.
- *Dry to sand* Immediately after curing, clean with D8403 UV Surface Degreaser to remove any uncured surface residue and overspray before sanding.

REPAIR AND RECOATING



- Dry to topcoat:* Immediately after sanding.
After 72 hours, D8080 must be re-sanded before topcoating.



- Sanding:*
- *Grade dry* P400 - P500
 - *Grade wet* P600 - P800



- Overcoat with:* Deltron UHS Direct Gloss topcoat
Envirobase Basecoat Colour
Compatible 2K surfacer or sealer

PERFORMANCE AND LIMITATIONS



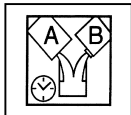
- The entire surface area of the primer must be fully illuminated by the UV lamp for 2 minutes. Material **will not** cure unless it is **directly** exposed at a 90° angle to an approved UV light source at a distance of 15 - 20cm.*
- Refer to UV lamp manufacturer's instructions, as not all UV lamps operate in the same way.
- Solvent wipe with D8403 Surface Degreaser for UV Primer
- A 2-minute curing time at a distance of maximum 20cm will cure an area the size of an A4 sheet of paper. Reducing the distance between the lamp and the panel will decrease the area exposed to UV light and thus reduce the size of the area cured.
- At greater distances, curing time will be significantly longer.
- Do not expose eyes or skin to direct UV light. Use UV safety glasses, available from the lamp manufacturer.
- **UV lamps get very hot and should be kept away from solvent fumes. Be careful to avoid burns to skin.**
- **Do not use the UV lamp** if the filter glass is damaged in any way or not securely in place.
- * When the repair area is not a flat, even surface it will not be possible to do the repair in one go. The following steps should be taken:
 1. Partially cure the whole repair area by moving the lamp around the repair, ensuring that all of the applied D8080 film has been exposed to UV light for at least 30 seconds.
 2. Fully cure all areas of the repair area section by section for 2 minutes at a time. It is **not** a problem to over-expose an area to the UV light.
 3. Clean and sand as recommended above.



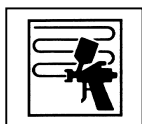
UV CURED PRIMER SURFACER D8080



Product is in an aerosol, no mixing is needed. Simply shake can vigorously For 2 minutes after dislodging the ball bearing.

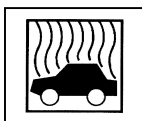


Pot Life at 20°C - Unlimited.



Apply Up to 6 continuous coats

D8080 contains optical brighteners and will glow when exposed To the UV lamp for curing.



UV Cure Apply light from UV curing lamp for 2 minutes, at a distance of 18 - 25 cms from the panel. After 2 minute UV cure, the entire surface should be well cleaned with D8403 Surafce Degreaser for UV Primer to remove uncured surface residue and overspray , before sanding.

Dust Free / Dry to sand
After a 2 minute cure and cleaning with D8403 Cleaner.

UV Lamp Information & Cautions

All primer must be fully illuminated by the UV lamp for 2 minutes

Refer to lamp manufacturers instructions, as not all lamps operate the same.

A 2 minute cure time at an 18 - 25 cm distance will cure an area the size of an A4 sheet of paper. Reducing the lamp to panel distance will decrease the area exposed to UV light and thus restrict the size of area being cured.

At greater distances, cure time will be significantly extended.

Do not expose eyes or skin to direct UV light. Use UV safety glasses available from lamp manufacturer.

UV lamp gets very hot and should be kept away from solvent fumes. Be careful to avoid burns to skin.

If filter glass is damaged in any way, or not securely in place;
DO NOT USE LAMP.

PERFORMANCE AND LIMITATIONS continued



Do not apply this product to obtain coverage. This product is pigmented solely to show the painter where the paint has been applied, so that the entire area is cured by the UV lamp. If this product is applied to hide, the product will not cure properly, adhesion failure will occur.

Do not attempt to repair any thermoplastic finishes, or 1K primers or topcoats.

CAN DISPOSAL

When aerosol is empty, turn it upside down and press the nozzle until all propellant is exhausted. Place empty can or cans that will no longer be used into properly labeled metal containers. The waste containers should be managed as a hazardous waste according to legislation.

VOC INFORMATION

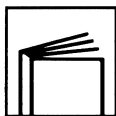
D8080 – UV Cured Primer Surfacer

The EU limit value for this product (product category: IIB.e) in ready to use form is max.840g/litre of VOC. The VOC content of this product in ready to use form is max. 840g/litre.

D8403 – Surface Degreaser for UV Primer

The EU limit value for this product (product category: IIB.a) in ready to use form is max. 850g/litre of VOC. The VOC content of this product in ready to use form is max. 850g/litre.

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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