



GLOBAL REFINISH
SYSTEM



March 2015

Product Information



DELTRON® Premium UHS Rapid Clearcoat D8135

D8135 Premium UHS Rapid Clearcoat

PRODUCTS

<i>Deltron</i> Premium UHS Rapid Clearcoat	D8135
<i>Deltron</i> UHS Hardener	D8302
<i>Deltron</i> Low VOC Thinners	D8717, D8718, D8719
<i>Deltron</i> Accelerated Thinner	D8714

For textured finishes or painting of flexible substrates:

<i>Deltron</i> Texture Additive	D843 to create a fine textured 'suede' effect
<i>Deltron</i> Leather Grain Additive	D844 to create a coarser, more pronounced textured finish

PRODUCT DESCRIPTION

Deltron Premium UHS Rapid Clearcoat is a 2K acrylic urethane clearcoat for the repair and repainting of panels originally finished with clearcoat over a single or multistage colour basecoat system.

D8135 is designed for use over ENVIROBASE® High Performance basecoat colour.

PREPARATION OF SUBSTRATE

Deltron D8135 Clear must be applied on top of clean and dust-free *Envirobase* High Performance basecoat. The use of a tack rag is recommended.

MIXING RATIO

Mixing ratios with UHS Hardener:

	<u>By Volume</u>	<u>By Weight</u>
D8135	3 vol	See table, Page 4
UHS Hardener	1 vol	
Thinner*	0.6 vol	

As with all ultra high solids products, cold ready for use paint temperatures can lead to more difficult application and overspray absorption. It is strongly recommended that ready for use product is applied at a temperature greater than 15°C

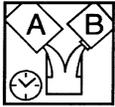
HARDENER AND THINNER SELECTION

Choose UHS hardener and thinner according to application temperature:

Temperature	UHS Hardener	Thinner
Up to 25°C	D8302	D8714/D8717
20°C - 30°C	D8302	D8718
25°C - 35°C	D8302	D8719

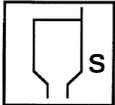
The choice of thinner should be made according to application temperature, air movement and size of job.

MIXED PRODUCT DETAILS



Pot Life at 20°C

1 hour with D8302 hardener and D87xx Thinner
30 - 40 min. with D8302 hardener / D8714 Accelerated Thinner



Application Viscosity 18 - 20 seconds / DIN4 / 20°C

APPLICATION AND FLASHOFF



Spraygun set-up: 1.2 - 1.4 mm

Express Single Visit Process

Application Apply 1 medium & 1 full coat to give 50-60 microns dry film build.

The first coat should be applied to all repair panels before the second coat is applied.

Flash off between spray coats For less than 3 panels, 2-3 minutes flash off.

For more than 3 panels, no flash off is required.

Flash off before bake or IR dry 5 - 10 minutes

Conventional Two Coat Process

Application Apply 2 single coats to give ~60 microns dry film build.

Flash off between spray coats 10 minutes

Flash off before bake or IR dry 5 - 10 minutes



DRYING TIMES

- | | |
|--------------------------------------|--|
| - Dust free time at 20°C | 25 - 35 minutes with D8302 / D8714
40 - 50 minutes with D8302 / D8717/18/19 |
| - Dry to handle at 20°C | 4 hours with D8302 / D8714
6 hours with D8302 / D8717/18/19 |
| - Through dry at 20°C | 12 hours with D8302 / D8714
16 hours with D8302 / D8717/18/19 |
| - Through dry at 60°C* | 15 minutes with D8302 / D8714
30 minutes with D8302 / D8717/18/19 |
| - Through dry at IR
(medium wave) | 8 - 15 minutes (depending upon colour) |



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

Total dry film build:
Theoretical coverage:

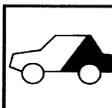
50 – 60 µm
Assuming 100% transfer efficiency and dry film
thickness as indicated: 8 m²/l

REPAIR AND RECOATING



- Sanding:* Essential before recoating to ensure good adhesion
- | | |
|--------------------|-------------|
| - <i>grade wet</i> | P800 |
| - <i>grade dry</i> | P400 - P500 |

Overcoat / Re-coat time:



- | | |
|--|---------------------------------------|
| - <i>Force dry at 60°C,
70°C or IR</i> | After cooling |
| - <i>Air drying at 20°C</i> | 12 - 16 hours - depending on thinner. |

Overcoat with: *Deltron primers, Envirobase High Performance,
Deltron topcoats*

PAINTING OF PLASTIC SUBSTRATES - TEXTURED FINISHES

To obtain a textured finish with *Deltron* D8135 Premium UHS Rapid Clearcoat, it is necessary to include texture additives in the mix. The additives required and the appropriate volume and/or weight mix ratios are indicated in RFU IT if relevant or in the tables below.

Note: The majority of plastics used on cars are considered **Rigid**. These plastics may have some flexibility when painted off the car, but are rigid once mounted.



Cumulative Mixing by Weight using Low VOC Deltron Thinners

Do not tare the balance between additions

Substrate	Appearance	D8135	D843	D844	UHS Hardener	Deltron Thinner D8714/17/18/19
RIGID	Gloss	642g	-	-	872g	979g
	Matt Textured	287g	641g	-	745g	946g
	Leather Grain	392g	-	708g	850g	960g

Note: Use of the above additives for plastics, will significantly reduce the scratch resistance of this clearcoat.

POLISHING



If polishing is required, i.e. to remove dirt nibs, it is recommended that it is carried out between 1 hour and 24 hours after the quoted drying time.
Use PPG Specialty Polishing system SPP1001.

FADE - OUT REPAIR PROCEDURE

- Apply D8135 Premium UHS Clearcoat according to the information above
- Take care to minimise the clearcoat edge in the fade-out area
- Melt overspray edge using D8731 Aerosol Spot Blender or D8430 Spot Blender.
- Refer to datasheet No: RLD 299V for successful repair.

WEIGHT MIX TABLE FOR D8135

Target Volume of RFU Paint required (Litres)	Weight Clearcoat D8135	Weight UHS Hardener D8302	Weight Low VOC Thinner D8714, D8717/18/19
0.10 L	64 g	87 g	98 g
0.25 L	161 g	218 g	245 g
0.33 L	212 g	288 g	323 g
0.60 L	385 g	523 g	588 g
0.75 L	482 g	654 g	735 g
1.00 L	642 g	872 g	979 g



EQUIPMENT CLEANING

After use, clean all equipment thoroughly with cleaning solvent or thinner.

VOC INFORMATION

The EU limit value for this product (product category: IIB.d) in ready to use form is max. 420g/litre of VOC. The VOC content of this product in ready to use form is max. 420g/litre. Depending on the chosen mode of use, the actual ready to use VOC of this product may be lower than that specified by the EU Directive code.

Note:

Combinations of this product D814, D819, D843 or D844 will produce a paint film with special properties as defined by the EU Directive code.

In these specific combinations: 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.

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: www.ppgrefinish.com

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