



GLOBAL REFINISH
SYSTEM



July 2007

Product Information



D759 Matting Base

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PRODUCT DESCRIPTION

Deltron Matting Base can be added to Deltron DG direct gloss colours to create a satin or matt appearance to match original finishes or to provide a custom finish.

PREPARATION OF SUBSTRATE



Apply over original stoved finishes or recommended PPG primers after first wet flattening with P600 - P800 grade paper or dry sanding with P400 - P500.

SUBSTRATE CLEANING/DEGREASING



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

MIXING RATIOS

1. Mixing Ratios with Standard System:

	<u>Matt Finish</u>		<u>Satin Finish</u>
DG	2 vols	DG	2 vols
D802	1 vol	D802	1 vol
Thinner*	2 vols	Thinner*	1 vol
D759	2 vols	D759	1 vol

2. Mixing Ratios with MS System:

	<u>Matt Finish</u>		<u>Satin Finish</u>
DG	3 vols	DG	3 vols
MS Hardener*	1.5 vol	MS Hardener*	1.5 vol
Thinner*	2 vol	Thinner*	1 vol
D759	3 vols	D759	1 vol

* Choose MS Hardener and Thinner according to application temperature:

HARDENER AND THINNER SELECTION

<u>Temperature</u>	<u>MS Hardener</u>	<u>Thinner</u>
Up to 18°C	D803 Fast	D808
18°C - 25°C	D841 Medium	D807
Over 25°C	D861 Slow	D812

For exceptional conditions of temperature and humidity (> 35°C / >70%) the use of Very Slow Thinner D869 is recommended

MIXED PRODUCT DETAILS

	<u>Standard System</u>	<u>MS System</u>
<i>Potlife</i>	8 - 10 hours / 20°C	8 - 10 hours / 20°C
<i>Spray viscosity</i>	15 secs DIN4 / 20°C	15 secs DIN4 / 20°C

SPRAYGUN SET UP




<i>Spraygun Tip</i>	1.4 - 1.8 mm	1.4 - 1.8 mm
<i>Spray pressure</i>	See manufactures recommendations	
<i>Number of coats</i>	3 coats standard system	2 coats MS system

FLASH OFF AT 20°C

<i>Between coats</i>	5 minutes	10 minutes
<i>Before stoving</i>	10 minutes	10 minutes



DRYING TIMES/PROPERTIES

	<u>Standard System</u>	<u>MS System</u>
 <i>Dust free time</i>	20 minutes	30 minutes
<i>Dry to handle 20 °C</i>	4 hours minimum	4 hours minimum
 <i>Through dry</i>		
- 20 °C	12 hours	16 hours
- 60 °C	30 minute bake *	30 min bake *
* Stoving times are for quoted metal temperature. Additional time should be allowed in the stoving schedule to allow metal to reach recommended temperature.		
 <i>IR drying Med Wave</i>	15 minutes	15 minutes
<i>Recommended dry film build</i>	45µm - 55µm	50µm - 60µm
<i>Theoretical coverage**</i>	5 - 6 m ² / L	6 - 7 m ² / L
** Theoretical coverage in m ² per litre ready-to-spray, giving 50 µm dry film thickness.		

OVERCOATING/RECOATING

As soon as the surface has cooled after stoving or after 16 hours drying at 20 °C

<i>Overcoat with</i>	Any PPG 2K Primer or Deltron topcoat	
<i>Sanding</i>	Essential before recoating to ensure good adhesion	
- <i>Grade Wet</i>	P800	P800
- <i>Grade Dry</i>	P400	P400



VOC INFORMATION

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.
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.

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](http://www.ppg.com/PPG_MSDS)

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