



GLOBAL REFINISH
SYSTEM

June 2016

Product Information

GRS Deltron® D880

*High-solids
Clear*

PRODUCTS

Deltron Clear	D880
Deltron Medium Solids Hardeners	D803, D841, D861, D864
Deltron Thinners	D808, D807, D812, D869
Deltron DG Fade-out Thinner	D868
Deltron Accelerator	D818

PRODUCT DESCRIPTION

Deltron D880 High Solids Clear is a premium quality high solids polyurethane clearcoat specifically formulated to give optimum gloss and durability when low-baked.

It is designed to be used over Deltron BC and Envirobase Colour.

PREPARATION OF SUBSTRATE

Deltron D880 Clear must be applied on top of a clean and dust-free Deltron basecoat or Envirobase. The use of a tack rag is recommended.

MIXING RATIOS

Mixing Ratio with MS Hardener:

	<u>By Volume</u>
D880	2 vol
MS Hardener*	1 vol
Thinner	0.5 vol

- Choose MS Hardener and Thinner according to application temperature

HARDENER AND THINER 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

Potlife at 20°C:	3 hours
Spray viscosity at 20°C:	17 seconds DIN4

APPLICATION AND FLASH OFF



Spraygun set-up: 1.4 - 1.8 mm

Number of coats: 1 medium , 1 full



Flash-off at 20°C:

- *Between coats* 10 - 15 minutes
- *Before stoving* 15 minutes

DRYING TIMES



Drying times:*

- Dust free at 20 °C 40 minutes
- Dry to handle at 20°C 6 hours



- Through dry at 20 °C 20 hours
- Through dry at 60°C 40 minutes
- Through dry at 70°C 30 minutes



- Through dry at IR Medium
Dependent on colour of basecoat (darker colours require less time): 15 minutes

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

Drying times may be reduced still further by using the Deltron Accelerated System.

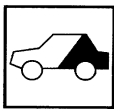
Total dry film build: 50 - 60 µm

Theoretical coverage: Assuming 100% transfer efficiency and dry film thickness as indicated:
7 - 7.5 m²/l

REPAIR AND RECOATING



- Sanding:* Essential before recoating to ensure good adhesion
- Grade wet P800
 - Grade dry P400



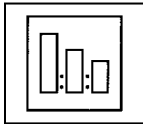
- Overcoat / recoat time:*
- Force dry 60°C, 70°C or IR after cooling
 - Airdrying at 20°C Minimum 12 hours

Overcoat with: Deltron primers, Envirobase, Deltron topcoats

Global at a Glance

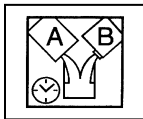
GRS Deltron High Solids Clear

D880



Mixing by volume

With MS Hardener - 2:1:0.5

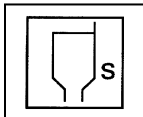


Pot Life at 20°C 3 hours

Hardener / Thinner Selection

Up to 18°C	D803 MS Accelerated Hardener D808 - Fast thinner
18 - 25°C	D841 MS Hardener D807 Thinner
Over 25°C	D861 MS Hardener D812 Slow thinner

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



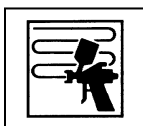
Application viscosity

17 seconds DIN4



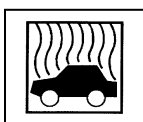
Spraygun Size

1.4 - 1.8 mm fluid tip



Number of Coats

1 medium coat followed by 1 full coat



Drying Times

Dust Free -	40 minutes
Through dry at 20°C -	20 hours
Through dry at 60°C -	30 minutes

SPOT REPAIR PROCEDURE

- Apply Deltron D880 HS Clear according to the 'Application, Flash-Off and Drying' section above.
- Leave to flash-off for 10 minutes / 20°C after the 2nd coat.
- A suitable quantity of activated and thinned D880 HS Clear should then be reduced with Deltron DG Fade-Out Thinner D868 at a ratio of 1:3 (1 part activated and thinned clear to 3 parts D868).
- Apply this 1:3 mix over the repair area, using a reduced gun pressure to minimise overspray. Spray from the outside of the repair inwards, covering an area that extends beyond the edge of the initial application.
- After force-dry or IR, buff the repair edges.

POLISHING

<i>Low-bake or IR force-drying:</i>	Minimum 1 hour after cooling
<i>Airdrying at 20°C:</i>	Minimum 24 hours after application

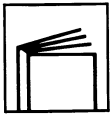
WEIGHT MIX TABLE FOR D880

Target Volume of RFU Paint required (Litres)	Weight Clearcoat D880	Weight UHS Hardener D803/D841/D861/D864	Weight Thinner D808/D807/D812/D869
0.10 L	57	87	100
0.25 L	143	217	249
0.33 L	188	287	329
0.60 L	343	521	598
0.75 L	429	651	748
1.00 L	571	869	997

EQUIPMENT CLEANING

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

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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