



GLOBAL REFINISH
SYSTEM



June 2014

Product Information



D8082

*D8082 UV - Cured Primer Surfacer
D8783 Activator for UV-Cured Primer Surfacer*

PRODUCT DESCRIPTION

D8082 UV-Cured Primer Surfacer offers a route to achieving very fast application and curing of high quality repairs. The cured material has good film build and easy sanding.

The rapid cure obtained through unique technology using UV light provides faster processing of repairs than conventionally cured products.

Note: The size of repair is limited by the area illuminated by the UV lamp used for curing.

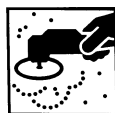
PREPARATION OF SUBSTRATE

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.



As with any spot repair, all of the previous paint finish should be removed from the repair area. The entire area to be painted with UV cured primer must be prepared by machine sanding and finished with paper P320/P360 or coarser to provide a suitable key for UV Primer.



For best results use PPG 2 -pack Etch Primer on areas of bare metal.

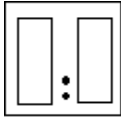
Painting Plastics

UV Primer may be used on small areas of bare plastic after abrading, cleaning and application of a Plastics adhesion promoter, such as D820 or D8420.

Page 1 of 6

RLD293V

MIXING RATIOS



D8082
D8783

By Weight

100 Parts
14 Parts



24 – 26 sec DIN 4



Spraygun: 1.4 mm Gravity

Inlet Pressure: Refer to spraygun manufacturers instructions
(normally 2 bar/30 psi at gun inlet)

WEIGHT MIX TABLE FOR D8082 USING D8783 ACTIVATOR

GUIDELINES FOR WEIGHT MIXING

Where a specific volume of primer mix is required, this may be best achieved by weight mixing, using the guidelines below.

Target Volume of RFU Primer required (Litres)		Weight Primer D8082	Weight Activator D8783	Weight Cumulative weight Primer and Activator
0.10 L		127.0 g	17.6 g	144.6 g
0.15L		190.4 g	26.4 g	216.8 g
0.20 L		253.9 g	35.2 g	289.1 g
0.25 L		317.4 g	44 g	361.4 g
0.30 L		380.9 g	52.9 g	433.8 g
0.40 L		507.8 g	70.5 g	578.3 g
0.50 L		634.8 g	88.1 g	722.9 g

Visc 32s/DIN4/18s

APPLICATION AND DRYING



Number of coats : For best results apply 3 passes in a 1 visit process working from out to in. The first pass covering the largest area. Subsequent passes remain inside the previous pass.

(No Flash off between passes)

Total dry film build: 100 - 150 µm



Drying times:

**Refer to lamp manufacturers guidelines prior to use.
Follow all lamp manufactures safety recommendations.**

Always allow lamp to warm up fully before use.

UV 250-400 WATT UV “A” Type Lamp.

Lamp to panel distance must be no more than 20cm

UV 800 WATT UV “A” Type Lamp.

Lamp to panel distance must be between 20-40cm depending on job size

The use of the higher power lamp will allow a larger repair.

All primer must be fully illuminated by the UV lamp for 4 – 5 minutes to ensure sufficient UV energy for a full & even cure.



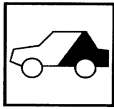
*Surface Cleaning
Process (Optional):*

For best sanding properties – D8403 can be used to remove uncured surface residue and overspray. Alternatively thinner D8718 may be used.

The entire area should be well cleaned and wiped dry before sanding.

Note: Separate cloths should be used for application and removal of D8403 or thinners.

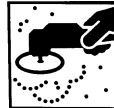
REPAIR AND RECOATING



Dry to topcoat: Immediately after sanding.
After 72 hours, D8082 must be re-sanded before topcoating.



Sanding:
- Hand dry P320



Finishing with
- Machine dry P500



Overcoat with: UV-Cured Primer Surfacer can be overcoated with all solvent based and water based topcoat systems.

PROCESS RECOMMENDATIONS

Surface Preparation

The surface to be painted should be in sound condition and free from dirt or grease.

PE Stopper must be finished with P180 block sanded. Surrounding area should be sanded with P320 to provide a suitable key for the UV Primer.

For best results use PPG 2-pack Etch Primer on areas of bare metal.
Always use 2-pack Etch primer on bare Aluminium.

Painting Plastics

UV Primer may be used on small areas of bare plastic after abrading, cleaning and application of a Plastics adhesion promoter, such as D820 or D8420.

Application

For best results apply 3 passes in a 1 visit process working from out to in. The first pass covering the largest area. Subsequent passes remain inside the previous pass.

The "out-to-in" technique requires that the entire area to be painted is covered by the initial application of paint. The area of subsequent application is reduced until the final application, which is applied to the centre of the repair.

UV Curing

Always refer to the manufacturer's instructions and health and safety advice prior to handling UV equipment.

- The UV lamp requires a warm-up time **before** it can be used to cure UV Primer. Please refer to manufacturer's instructions.
- Constant on/off switching will damage the UV lamp, resulting in reduced lifetime.
- When switched off, the lamp requires a cooling down period of approximately 10 minutes before re-ignition.
- The cure/drying of UV primer is dependant on several factors.
 - Film build of UV Primer
 - Power of lamp
 - Lamp to panel distance.
 - Age of UV bulb. (Follow lamp manufacturers recommendation for bulb life).
- Ensure area of primer to be dried is fully illuminated by the UV lamp at the recommended lamp to panel distance.

When repairing areas of styling lines, care must be taken that all of the applied UV Primer is illuminated. It may be necessary to alter the angle and/or position of the lamp to fully illuminate the paint film within the styling line.

Precautions

Carry out risk assessment before adopting process.

Refer to the Material Safety Data Sheet for UV Primer before use.

Always use UV Primer in an enclosed well ventilated area such as a spraybooth.

Always refer to UV lamp manufacturers guidelines for safe use.

Do not expose eyes or skin to direct UV light.

Always use UV safety glasses.

Do not use the UV lamp if the filter glass is cracked, damaged or unsecured in any way.

Greymatics – Please refer to colour information for the recommended Greymatic shade.

VOC INFORMATION

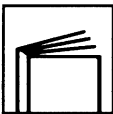
D8082 – UV Cured Primer Surfacer

The EU limit value for these products (product category: IIB.c) in ready to use form is max.

540g/litre of VOC. The VOC content of this product in ready to use form is max. 540g/litre.

Depending on the chosen mode of use, the actual ready to use VOC of these products 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: www.ppgrefinish.com

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