GLOBAL REFINISH SYSTEM

March 2016

Product Information

DP5000

(For use with D8302 UHS Hardener)

D8521 Light Grey
D8525 Grey
D8527 Dark Grey
D8302 UHS Hardener
D8717/18/19 Thinners

PRODUCT DESCRIPTION

DP5000 is a range of 2K primer surfacers suitable for a wide range of repair work in the refinish bodyshop. Versatile and easy to apply and sand, they offer excellent film build, surface levelling and gloss holdout over a wide range of substrates such as sound original paintwork, bare steel, polyester body fillers and suitable adhesion primers.

These primers may be directly over coated with DELTRON® UHS Progress or ENVIROBASE® High Performance basecoat.

By combining D8521, D8525and D8527 (see **GreyMatic** section), the GreyMatic range of primers can be obtained. In this way the topcoat consumption and the total repair process time may be optimised.

PREPARATION OF SUBSTRATE - DEGREASING

Before any preparation work, wash all surfaces to be painted with soap and water. Rinse and allow to dry before degreasing with a suitable PPG substrate cleaner: 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.

Please see ***Deltron*** **Cleaners (RLD63V)** Technical Data Sheet for appropriate substrate cleaning and degreasing products.

PREPARATION OF SUBSTRATES

DP5000 surfacers should only be applied over the following substrates:

For bare steel use PPG 2-pack Etch Primer or 2-pack Epoxy Primer for maximum durability. Aluminium **must** be Etch primed.

Well sanded GRP, polyester fillers works primer and old finishes in sound condition.

Good preparation is vital in order to obtain the best results from these products.

The following grades of sanding paper are recommended for substrate preparation: -

Dry machine sanding P180 - P240

NOTE: Not recommended for spot repairs over thermoplastic acrylic, old lacquer finishes or sensitive substrates. Over these substrates, apply to complete panels only.

THINNER SELECTION

D8717	below 20°C
D8717/D8718	15-25°C
D8718	20-30°C
D8718/D8719	25-35°C
D8719	30-40°C

Note: For accurate activation and thinning, weight mixing is recommended (See Page 4).

MIXING

Mixing Ratio:	DP5000	7 vol
	UHS Hardener	1 vol
	Thinner	1 – 2 vol

MIXED PRODUCT DETAILS

Pot life at 20°C:	90 minutes
Spray viscosity DIN4/20°C:	26 - 29 seconds (@ 7 : 1 : 1)

SPRAYGUN SETUP

Fluid Tip,
Gravity: 1.6 - 1.8 mm
Pressure: Follow spraygun manufacturer's recommendations (normally 2 bar / 30 psi)

APPLICATION GUIDE

Number of coats:	1 medium coat + 2 full coats
Flash off/20°C:	
- Between coats	Until Matt
- Before stoving	Until Matt

DRYING

Sandable @ 20°C	3 – 4 hours
Sandable below 20°C	Overnight
Through dry at 60^0C	20 - 30 minutes* depending on film thickness
Through dry/ Infra-Red	12 minutes

* Drying time once substrate reaches 60°C metal temperature.

FILM PROPERTIES

Dry film builds:

- Minimum	75µ
- Maximum	150µ

SANDING

Finish with P500 grade

TOPCOATING

DP5000may be overcoated directly with the following topcoat products:
Deltron UHS Progress Direct Gloss Colour
Envirobase High Performance Basecoat colour

GREYMATICS

The mixtures below should be activated and thinned in the normal way before spraying.

For each of the GreyMatic primer variants specified the following weight mix ratios apply:

	G1	***G3***	***G5***	***G6***	***G7***
D8521	***100***	***75***	***--***	***--***	***--***
D8525	***--***	***25***	***100***	***48***	***--***
D8527	***--***	***--***	***--***	***52***	***100***

WEIGHT MIXING

Weight Activations for use with UHS hardener (D8302) Ratio 7 : 1 : 1 - 2				
1 Litre RFU Sprayable Volume (@ 7 : 1 : 2 ratio)	Please note the weights are cumulative. Do not tare or zero scale between additions			
G1	Wt Primer D8521 Grams (7 Parts)	Wt Hardener D8302 Grams (1 Part)	Wt. Thinner D8717/8/9 Grams (1 Part)	Wt. Thinner D8717/8/9 Grams (2 Parts)
1.0 L	1078	1184	1266	1348
G5	Wt Primer Grams (7 Parts)	Wt Hardener Grams	Wt. Thinner Grams	Wt. Thinner Grams
1.0 L	1077	1183	1266	1346
G7	Wt Primer Grams (7 Parts)	Wt Hardener Grams	Wt. Thinner Grams	Wt. Thinner Grams
1.0L	959	1065	1147	1229

LIMITATIONS

Part used cans of hardener must be carefully closed immediately after use. All equipment must be perfectly dry. Use of DP5000 is not recommended when humidity levels exceed 80%.

Clean sprayguns immediately after use.

GUIDE TO USING DP5000 AS A ROLL PRIMER WITH UHS HARDENER

MIXING RATIO

Mixing Ratios – If scales are not available, then primer may be activated by volume.

	By Volume
DP5000	7 vol
D8302	1 vol
Thinner	0.25 vol

Pot life at 20ºC: 40 minutes.
Note: It is recommended to use the material immediately after mixing.
Clean roller tray immediately after use.

WEIGHT MIXING FOR ROLLING

Weight Activations for use with UHS hardener (D8302) Ratio 7 : 1 : 0.25			
1 Litre RFU Rolling Volume (@ 7 : 1 : 0.25 ratio)	Please note the weights are cumulative. Do not tare or zero scale between additions		
G1	D8521 Grams (7 Parts)	Wt Hardener D8302 Grams (1 Part)	Wt. Thinner D8717/8/9 Grams (0.25 Part)
1.0 L	1307	1435	1460
G5	D8525 Grams	Wt Hardener Grams	Wt. Thinner Grams
1.0 L	1305	1433	1458
G7	D8527 Grams	Wt Hardener Grams	Wt. Thinner Grams
1.0 L	1162	1291	1316

APPLICATION AND FLASH OFF

1. Use of good quality high density foam rollers is essential. Use of a suitable roller tray allows easy control of paint loading on the roller.
2. Load the roller from a suitable roller tray. Removed excess paint from the roller.
3. The first coat covers the largest area. Subsequent coats cover smaller areas.
4. Apply paint from the centre of the repair patch, rolling outwards using light pressure.
5. Use the roller with less paint loading to fade hard edges of each coat.
6. Allow the paint to flow out on the panel; avoid over- working, which can leave an uneven surface.
7. When one coat becomes matt, it is ready for the next coat.

Number of coats: Apply 4 coats to give a film thickness of 75 - 125 microns (3 - 5 thou.)

Flash-off at 20°C: Between coats Approx. 5 minutes

DRYING TIMES

Air-dry at 20°C: 3 - 4 hours (Depending on film thickness)

Stoving at a metal temperature of 60°C: 20 - 30 minutes

Infra-red drying times given require the short wave infra-red lamp to be positioned 70-100 cm away from the panel. Use IR unit on half power for 5 minutes before applying full power for approximately 15 minutes. Drying times will depend on the type of infra-red lamp used. Drying time will depend on film thickness.

FLEXIBLE SUBSTRATES:

Mixing Ratio:	DP5000	5.6 vol
	D814	1.4 vol
	D8302	1 vol
	Thinner	1 vol

VOC INFORMATION

The EU limit value for this product (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 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: **www.ppgrefinish.com**

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