



GLOBAL REFINISH  
SYSTEM

June 2018

# Product Information



## D8595 Epoxy Primer

<i>Epoxy Primer</i>	<i>D8595</i>
<i>Hardener for Epoxy Primer</i>	<i>D8298</i>
<i>Thinner For Epoxy Primer</i>	<i>D8752</i>

## PRODUCT DESCRIPTION

D8595 is a multi-mode 2K Epoxy Surfacer. It is light grey in colour, chromate-free and has good corrosion resistance over bare metal.

D8595 has good adhesion to a wide variety of suitably prepared substrates. These include bare and galvanised steel, aluminium, painted surfaces and fillers.

D8595 and its two dedicated hardeners - together forming a versatile package.

- Hardener D8298 offers three modes of use - As a sanding filler, an isolator/sealer under 2K primers & surfacers or as a wet-on-wet for small spot repairs & run-throughs.

<b>Primer + Hardener</b>	<b>Possible Modes Of Use</b>		
D8595 + Epoxy Hardener D8298	Sanding Filler	Isolator	Wet-on-Wet - Spot Repair

## PREPARATION OF SUBSTRATE



### SUBSTRATE

Bare Steel  
Galvanised steel  
Zintec  
Aluminium and alloys  
Electropaint  
Aged painted surfaces  
GRP , Fibre - glass  
Polyester filler

### SAND

P80-P120  
P400 (dry)  
Fine sanding pad  
P240-P320(dry)  
P320(dry)/P800(wet)  
P240/P320/P400/P500  
P320(dry)  
P80-P120-P180(dry)



Degrease all surfaces to be painted with appropriate PPG substrate cleaner before and after sanding operation.

Clean off residues and dry thoroughly before re-cleaning with appropriate PPG substrate cleaner. See Technical Data Sheet **DELTRON® Cleaners RLD63**.





## MIXING RATIOS

FULL WEIGHT MIX TABLES ARE AVAILABLE ON PAGE 5 OF THIS DATASHEET.

- Mixing Ratios as Sanding Filler:

	<u>Using Hardener D8298</u>	
	Volume	Weight
<b>D8595</b>	3 Parts	100g
<b>D8298</b>	1 Part	20.7g

- Mixing Ratios as isolator:

	<u>Using Hardener D8298</u>	
	Volume	Weight
<b>D8595</b>	3 Parts	100g
<b>D8298</b>	1 Part	20.7g
<b>D8752</b>	1.7 Parts	33.7g

- Mixing Ratios for use as a Wet-on-Wet for Spot Repair:

	<u>Using Hardener D8298</u>	
	Volume	Weight
<b>D8595</b>	3 Parts	100g
<b>D8298</b>	1 Part	20.7g
<b>D8752</b>	1 Part	19.8g

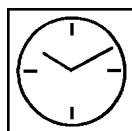
## MIXED PRODUCT DETAILS

	<i>FILLER</i>	<i>ISOLATOR</i>	<i>SPOT REPAIR/WOW</i>
<b>Pot-life 20°C</b> Using D8298	4 Hours	3 Hours	4 Hours
<b>Spray Viscosity</b> Using D8298 (Sec DIN4 / 20°C)	23 - 25	16 - 20	21 - 23

## APPLICATION AND FLASH-OFF

	FILLER	ISOLATOR	SPOT REPAIR WOW
	<b>Spraygun set-up</b>		
	1.4 - 1.6 mm	1.3 - 1.4 mm	1.3 - 1.4 mm
	<i>Adjust pressure according to gun manufactures recommendations</i>		
	<b>Number of coats</b>		
	1 light coat 2 full coats	1 light coat 1 full coat	1 light coat 1 full coat
	<b>Flash-off at 20°C</b>		
	- Flash off Between coats		
Using D8298	5-10 min	5 - 10 min	5 - 10 min
	- Flash off before topcoat		
Using D8298	After Sanding	10-20 min (Until matt) before primer	30-60 min Depending on temp & humidity
		<i>See Note - DP4000 *</i>	<i>See Note - DP4000 *</i>
<i>Note: If DP4000 is to be used on top of D8595 in Isolator or spot prime/wet-on-wet mode, a minimum of 30 mins flash off is required.</i>			

## DRYING TIMES



	FILLER	ISOLATOR	SPOT REPAIR/WOW
-Through dry at 60°C	30mins*	N/A	N/A
- Airdry 20°C	Overnight		



-Through dry IR medium wave	10 min*	N/A	N/A
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\*Stoving times are for quoted metal temperature. Additional time should be allowed in the stoving schedule to allow metal to reach recommended temperature

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## DRY FILM BUILD

### FILLER

*Dry Film Build*                      100-120 microns

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## REPAIR & RECOATING

When used as an isolator - D8595 must be overcoated with a primer within 8 hours.

D8595 can be overcoated with: Any *Deltron 2K* primer.



**\*NOTE\* When used in isolator or spot repair/wet-on-wet mode, D8595 should be left to flash off a minimum of 30 minutes if overcoating with DP4000**

In Filler mode D8595 should be sanded after drying prior to the application of topcoat.

- Sand P360 or finer if topcoating with Direct Gloss.
- Sand P400 or finer if topcoating with Basecoat + Clearcoat

Topcoats - D8595 can be topcoated with :

- *Deltron* Progress UHS Direct Gloss.
- ENVIROBASE® High Performance Basecoat

*Note: See appropriate topcoat Technical Datasheet*

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## PERFORMANCE & LIMITATIONS



-D8595 should not be used at lower temperature than 10°C and humidity higher than 80%.

## MIXING BY WEIGHT

The weights in the tables below are cumulative in grams - please do **NOT** tare or zero the scale between additions.

### 1. Weight mixing for Sanding Filler mode.

Using Epoxy Hardener D8298			
Vol Ratio	3 Parts	1 Part	0.8 Parts
Total Vol Sprayable	Epoxy Primer D8595	Hardener D8298	Thinner D8752
0.25 L	231.3	279.2	315.8
0.33 L	305.3	368.5	416.9
0.5 L	462.5	558.3	631.7
0.66 L	610.5	737.0	833.8
0.75 L	693.8	837.5	947.5
1.0 L	925.0	1116.7	1263.3
1.5 L	1387.5	1675.0	1895.0

### 2. Weight mixing Wet-on-Wet for Spot Repair.

Using Epoxy Hardener D8298			
Vol Ratio	3 Parts	1 Part	1 Parts
Total Vol Sprayable	Epoxy Primer D8595	Hardener D8298 Only	Thinner D8752
0.25 L	222.0	268.0	312.0
0.33 L	293.0	353.8	411.8
0.5 L	444.0	536.0	624.0
0.66 L	586.1	707.5	823.7
0.75 L	666.0	804.0	936.0
1.0 L	888.0	1072.0	1248.0
1.5 L	1332.0	1608.0	1872.0

## 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.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.



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## HEALTH & 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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