



GLOBAL REFINISH
SYSTEM



November 2007

Product Information



KOBA 2K 5+1 D838

2 Component Primer

PRODUCT INFORMATION

Koba 2K 5+1 D838 yellow is a versatile, high build 2K primer, suitable for use under Deltron UHS DG and Deltron Progress UHS DG only. It offers exceptional film build and isolating properties when used as a high-build spray or primer filler.

Koba 2K 5+1 can be applied over suitably prepared knifing putties, or over sound, fully cured original paintwork or adhesion primers. Options are available for air-drying and for conventional or IR stove-drying.

PREPARATION OF SUBSTRATE



Substrate

Bare steel
Galvanised steel
Zintec
Aluminium and alloys
Electropaint
Aged painted surfaces
Polyester filler

Preparation

Must be pre-primed (e.g. D831 or Epoxy)
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P360 (dry) / P800 (wet)
P400 – P500 (dry) / P280 - 320 (wet)
P320 (dry)
P240 (high-build version)



Before and after any sanding operation, the substrate must be thoroughly degreased. Use an appropriate substrate cleaner/degreaser. PPG make a range of cleaning & degreasing products. See Technical Datasheet **Deltron Cleaners RLD63V**.

MIXING RATIOS

1. Mixing Ratios with MS Hardener – Used as a Spray Filler:

| | <u>By Volume</u> |
|-------------|------------------|
| D838 | 5 vol |
| MS Hardener | 1 vol |

2. Mixing Ratios with MS Hardener – Used as a Primer Filler:

| | <u>By Volume</u> |
|-------------|------------------|
| D838 | 5 vol |
| MS Hardener | 1 vol |
| Thinner | 0.5 vol |

3. Mixing Ratios with MS Hardener – Used as a Surfacer:

| | <u>By Volume</u> |
|-------------|------------------|
| D838 | 5 vol |
| MS Hardener | 1 vol |
| Thinner | 1 vol |

HARDENER AND THINNER SELECTION

Temperature

Up to 18°C
18 - 25°C
25 - 35°C
Over 35°C

MS Hardener

D803 MS Fast
D841 MS Medium
D861 MS Slow
D861 MS Slow

Thinner

D808 Fast Thinner
D866 2K Primer Thinner
D812 Slow Thinner
D869 Very Slow Thinner

MIXED PRODUCT DETAILS

Potlife at 20°C:

Spray Filler
30 minutes

Primer Filler
35 minutes

Surfacer
45 minutes

Spray viscosity:
DIN4 at 20°C

55 - 60
Seconds

35 - 40
Seconds

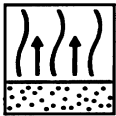
25 - 30
Seconds



APPLICATION AND FLASH OFF



| | <u>Spray Filler</u> | <u>Primer Filler</u> | <u>Surfacer</u> |
|-------------------------|---------------------|----------------------|-----------------|
| <i>Spraygun set-up:</i> | 2.0 - 2.2 mm | 2.0 - 2.2 mm | 1.6 mm |
| <i>Number of coats:</i> | 3 | 3 | 2 - 3 |



| <i>Flash-off at 20°C:</i> | | | |
|----------------------------|------------------|------------------|------------|
| - <i>Between coats</i> | 15 minutes | 10 minutes | 10 minutes |
| - <i>Before stoving</i> | Do not force dry | Do not force dry | 10 minutes |
| - <i>Before topcoating</i> | 15 minutes | 10 minutes | 10 minutes |

DRYING TIMES

| | | | |
|--------------------------------|------------------|------------------|------------|
| - <i>Dust free at 20°C</i> | 15 minutes | 10 minutes | 10 minutes |
| - <i>Through dry at 20°C</i> | Overnight | 5 hours | 3 hours |
| - <i>Through dry at 60°C*</i> | Do not force dry | Do not force dry | 30 minutes |
| - <i>Through dry IR medium</i> | Do not force dry | Do not force dry | 10 minutes |

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

| | <i>Spray Filler</i> | <i>Primer Filler</i> | <i>Surfacer</i> |
|------------------------------|---------------------|----------------------|---------------------|
| <i>Total dry film build:</i> | 200 - 260 µm | 160 - 220 µm | 50 - 100 µm |
| <i>Theoretical coverage:</i> | 2 m ² /l | 2 m ² /l | 6 m ² /l |

REPAIR AND RECOATING



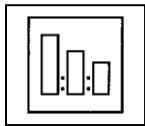
| | |
|--------------------|--|
| <i>Sanding:</i> | Essential before recoating to ensure good adhesion |
| - <i>grade wet</i> | P800 |
| - <i>grade dry</i> | P400 |



| | |
|-----------------------|--|
| <i>Overcoat with:</i> | Deltron UHS Deltron Progress UHS DG N.B. Not recommended under Envirobases. |
|-----------------------|--|



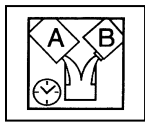
KOBA 2K 5+1 D838



Mixing by volume

With MS Hardener -

As Spray Filler 5 : 1
 As Primer Filler 5 : 1 : 0.5
 As Surfacer 5 : 1 : 1



Pot Life at 20°C 30 minutes as Spray filler,
 35 minutes as Primer Filler
 45 minutes as Surfacer,

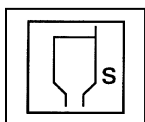
Hardener / Thinner Selection

Up to 18°C D803 MS Fast Hardener
 D808 Fast thinner

18 - 25°C D841 MS Medium Hardener
 D807 Thinner - or D866 Primer Thinner

Over 25°C D861 MS Slow 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 viscosities

55-60 seconds DIN4 - Spray Filler,
 35 - 40 secs - Primer Filler
 25 - 30 secs – Surfacer.



Spraygun Sizes

2.0 - 2.2 mm fluid tip - Spray Filler or Primer Filler
 1.6 mm fluid tip – Surfacer.



Number of Coats

Spray Filler, Primer Filler - 3 maximum, Surfacer 2 – 3.



Drying Times

Dust Free - 10 - 15 minutes
 Through dry at 20°C - Overnight as Spray Filler,
 5 hours as Primer Filler,
 3 hours as a Surfacer.
 Through dry at 60°C - 30 minutes as Surfacer.
 DO NOT Force dry - Spray Filler or Primer Filler



PERFORMANCE AND LIMITATIONS



Do **not** use accelerated MS hardener D864 in Koba 5+1.

Do not attempt to use D838 at humidity levels exceeding 80%.

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.

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

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