



GLOBAL REFINISH
SYSTEM



November 2007

Product Information



PRIMA D839

2 Component Primer

PRODUCT DESCRIPTION

Prima is a grey 2K primer surfacer, suitable for a wide range of day-to-day repair work.

Versatile, quick drying and easy to apply and sand, it offers excellent corrosion resistance, film build, surface levelling and gloss holdout over a wide range of substrates.

By simple adjustment of the thinning ratio, Prima may be applied as a conventional primer surfacer, as a high build spray filler. Prima may be air dried, low baked or IR cured.

Prima may be applied directly to sound original paintwork, bare steel, polyester bodyfillers and suitable adhesion primers. It may be directly overcoated with 2K topcoat materials such as Deltron Progress UHS DG ,Envirobase, Deltron DG or Deltron BC

PREPARATION OF SUBSTRATE



Substrate

Bare steel
Galvanised steel
Zintec
Aluminium and alloys
Electropaint
Aged painted surfaces
GRP , Fiber-Glass
Polyester filler

Preparation

Must be pre-primed (e.g. D831, D834)
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P360 (dry)/P800(wet)
P400 - 500 (dry)/P280 - 320 (wet)
P320 (dry)
P240 (high-build version)



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

Wash off residues and dry thoroughly before re-cleaning with appropriate PPG substrate cleaner. See Technical Data Sheet **Deltron Cleaners RLD63V**.

MIXING RATIO

1. Mixing Ratio with MS Hardener as a Spray Filler:

	<u>By Volume</u>
D839	5 vol
MS Hardener	1 vol

2. Mixing Ratio with MS Hardener as a Surfacer:

	<u>By Volume</u>
D839	5 vol
MS Hardener	1 vol
Thinner	1 vol

HARDENER AND THINNER SELECTION



<u>Temperature</u>	<u>MS Hardener</u>	<u>Thinner</u>
Up to 18°C	D803 MS Fast	D808 Fast Thinner
18 - 25°C	D841 MS Medium	D866 or D807 2K Primer Thinner
25 - 35°C	D861 MS Slow	D812 Slow Thinner
Over 35°C	D861 MS Slow	D869 Very Slow Thinner

MIXED PRODUCT DETAILS




	<i>Spray filler</i>	<i>Surfacer</i>
Potlife at 20°C	20 minutes	45 minutes
Spray viscosity at 20°C:	60 seconds DIN4	25 seconds DIN4




APPLICATION AND FLASH OFF

	Spray filler	Surfacer
 <i>Spray gun set-up:</i>	1.8 - 2.0 mm	1.6 - 1.8 mm
<i>Number of coats:</i>	Max. 4	2 - 3
 <i>Flash-off at 20°C:</i>		
- <i>Between coats</i>	5 - 10 minutes	5 - 10 minutes
- <i>Before stoving</i>		10 minutes

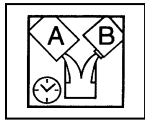
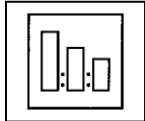
DRYING TIMES

	Spray filler	Surfacer
 <i>Dustfree at 20°C</i>	5 minutes	5 minutes
<i>Through dry at 20°C</i>	4 hours	2 hours
 <i>Through dry at 60°C*</i>	Do not force dry	30 minutes
<i>Through dry IR MW</i>	Do not force dry	20 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>Total film build:</i>	200 - 270 µm	100 - 150 µm
<i>Theoretical coverage:</i>	Assuming 100% transfer efficiency and dry film thickness as indicated:	
	1.75 m ² /l	2.5 m ² /l

REPAIR AND RECOATING

 <i>Sanding:</i>	Essential before recoating to ensure good adhesion P800 (wet) P400 (dry)
<i>Overcoat with:</i>	Deltron Progress UHS DG, Envirobase Basecoat, Deltron DG, Deltron BC





Mixing by volume

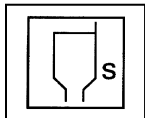
With MS Hardener -

As Spray Filler 5 : 1
As Surfacer 5 : 1 : 1

Pot Life at 20°C with MS hardeners 20 minutes as Spray filler,
45 minutes as Primer Filler

Hardener / Thinner Selection

Up to 18°C	D803 MS Fast Hardener D808 Fast thinner
18 - 25°C	D841 MS Hardener D807 Thinner or D866 Primer Thinner
25 - 35°C	D861 MS Slow Hardener D812 Slow thinner



Application viscosities

60 seconds DIN4 - Spray Filler,
25 seconds DIN4 - Surfacer



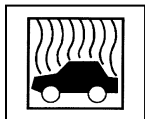
Spraygun Sizes

1.8 - 2.0 mm fluid tip - Spray Filler
1.6 - 1.8 mm fluid tip - Primer Surfacer



Number of Coats

Spray Filler - 4 maximum,
Primer Surfacer 2 - 3



Drying Times

Dust Free -	5 minutes
Through dry at 20°C -	4 hours Spray Filler, 2 hours Surfacer
Through dry at 60°C -	Spray Filler - DO NOT force dry, Surfacer - 30 minutes

Dry Film Builds

Spray Filler	200 - 275 microns,
Surfacer	100 - 150 microns,



PERFORMANCE AND LIMITATIONS



When high build is needed on flexible parts, D839 Prima can be applied on top of a plastic adhesion promoter. Apply a maximum of 2 coats according the following mixing ratio:

D839	4 vol
MS Hardener	1 vol
D814	1 vol

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.

Note:

Combinations of this product with D814 will produce a paint film with special properties as defined by the EU Directive code.

In these specific combinations: The EU limit value for this product (product category: IIB.e) in ready to use form is max. 840g/litre of VOC. The VOC content of this product in ready to use form is max. 840g/litre.

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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