



GLOBAL REFINISH
SYSTEM



November 2007

Product Information



D854 TRANSPARENT SEALER

PRODUCT DESCRIPTION

D854 Transparent Sealer is ideal for the rapid repainting of sound original substrates.

D854 promotes excellent gloss holdout of 2K topcoats over a range of sanded substrates. These include OE finishes, any sound aged paint surface, and non-synthetic primer-surfacers.

D854 is especially recommended when a wet-on wet paint system is required to save labour costs during the sanding process, and since it is transparent it is especially suited to respray work, avoiding the need for long and delicate masking around door-shuts, panel edges etc.

PREPARATION OF SUBSTRATE



In all cases, select the appropriate PPG cleaner(s).
See Technical Data Sheet: **Deltron Cleaners RLD63V**.
Ensure that the substrate is thoroughly cleaned and dried both before and after preparation work.



When using sealer as a wet-on wet sealer
OE or existing paintwork should be sanded back to sound substrate layers using P320-360 grit discs (dry) or P600-800 grade paper (wet).
Any exposed bare metal should be spot primed with D831 Universel Chromate-free Wash Primer.

Primed surfaces should be sanded with P320 grit discs (dry) or P600 grade paper (wet).

When using sealer as an adhesion promoter
Sound OE or existing paintwork should simply be cleaned thoroughly. Areas particularly susceptible to stone chip damage - leading edges, wheel arches or sills, for example, will benefit from additional adhesion if abraded with a scotchbrite pad.

MIXING RATIO

1. Mixing Ratios with HS Hardener -:

D854	5 vol
HS Hardener	1 vol
Thinner	2 vol

MIXED PRODUCT DETAILS

With HS Hardener

Potlife at 20°C: 2-3 hours

Spray Viscosity 20 - 24 seconds DIN4 @ 20°C:

HARDENER AND THINNER SELECTION

When overcoating D854 sealer wet-on-wet with GRS Deltron UHS Progress, GRS Deltron DG or GRS Deltron BC+Clearcoat. it is important to use the same speed hardener or slower in the topcoat as used for the application of D854 Sealer.

<u>Temperature</u>	<u>HS Hardener</u>	<u>Thinner</u>
Up to 18°C	D8208	D808 Fast Thinner
18°C - 25°C	D897	D866 or D807 Thinner
Over 25°C	D897	D812 Slow Thinner

APPLICATION AND FLASH OFF

With HS Hardener



Spraygun set-up:

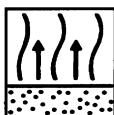
1.4 -1.6mm

Spray pressure:

See spraygun manufacturers information

Number of coats:

2 normal



*Flash-off at 20°C:
Between coats*



5-10 minutes

Before topcoat

20-30 minutes



DRYING TIMES

	<i>Drying times:</i>	When used as a sealer which has to be sanded to obtain optimum finish.
	<i>Dust free at 20°C</i>	10 minutes
	<i>Through dry at 20°C</i>	Overnight
	<i>Through dry at 60°C</i>	30 - 45 minutes
	<i>Through dry IR medium</i>	5 minutes
	<i>Total dry film build:</i>	
	<i>Minimum</i>	25µm
	<i>Maximum</i>	50 µm

REPAIR AND RECOATING

Overcoat/recoat time: Overcoat without sanding within 12 hours of application. In order to ensure good adhesion if over 12 hours, or in order to remove dirt or defects, Sealer may be sanded after it has through dried.



Sanding: In normal use it is not necessary to sand this product. Use P400 grade (dry) or P600-800 (wet) if required.

Overcoat with: Deltron Progress UHS Direct Gloss. Deltron DG or Deltron BC+ Clearcoat

Note: Envirobase basecoat not recommended.

PERFORMANCE AND LIMITATIONS

If required, D854 may be coloured with up to 5-10% of Deltron UHS Progress tinter. Do not exceed this mix ratio. Deltron Accelerator D818, or D864 Accelerated Hardener, should not be used in D854.

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

PPG Industries (UK) Limited.
Auto Refinish
Customer Service and Sales Group,
Needham Road,
Stowmarket,
Suffolk.
IP14 2AD,
England.
Tel: 01449 771775
Fax: 01449 773480

