



GLOBAL REFINISH
SYSTEM



May 2006

Product Information



DELTRON D821

High Solids Chip Resistant Primer



PRODUCT DESCRIPTION

D821 is a transparent-grey primer surfacer with excellent anti-chip and anti-corrosion properties. It is ideal for the repair and repainting of any panel surfaces, particularly those areas most susceptible to chip damage.

Tintable with GRS Deltron UHS or Deltron Progress UHS DG colour, D821 may be applied directly to bare steel, suitably prepared aluminium and pretreated steel. It may be overcoated, with or without sanding, with GRS Deltron UHS topcoat, Deltron Progress UHS DG or Envirobase. D821 may be air dried, IR cured or low baked.

D821 offers significant economies in process time. A single stage application of D821 can replace a conventional two stage primer system. D821 gives the adhesion and anticorrosion performance of an epoxy or wash etch primer together with the film build and surface levelling of a 2K surfacer.

PREPARATION OF SUBSTRATE

	Substrate	Preparation
	Bare steel Galvanised steel Zintec Aluminium and alloys Electropaint Aged painted surfaces GRP, fibre-glass Polyester filler	P80 - 120 (dry) P400 (dry) Fine sanding pad P280 - 320 (dry) P360 (dry) / P800 (wet) P400 - 500 (dry) / P280 - 320 (wet) P320 (dry) P240 (dry)
		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 for cleaners & degreasers

MIXING RATIOS

1. Mixing Ratio – Untinted

	<u>By Volume</u>
D821	5 vol
D884/D897	1 vol
Thinner	1 vol

2. Mixing Ratio – Tinted

	<u>By Volume</u>
D821	3 vol
UHS/Progress	1 vol
D884/D897	1 vol
Thinner	1 vol

HARDENER AND THINNER SELECTION

Temperature

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

HS Hardener

D884/D897
D884/D897
D884/D897
D884/D897

Thinner

D808 Fast Thinner
D866 2K Primer Thinner or D807
D812 Slow Thinner
D869 Very Slow Thinner

MIXED PRODUCT DETAILS

Potlife at 20°C: 3 - 4 hours

Spray Viscosity at 20°C: 18 - 25 seconds DIN4



APPLICATION AND FLASHOFF

	<u>Untinted</u>	<u>Tinted</u>
<i>Spraygun set-up:</i>		1.4 - 1.6 mm
<i>Number of coats:</i>		2 - 3
<i>Flash-off at 20°C:</i>		
- <i>Between coats</i>		10 - 15 minutes
- <i>Time before topcoating</i>		Solvent borne topcoat: 30 minutes Waterborne topcoat: 45 minutes

DRYING TIMES

	<u>Untinted</u>	<u>Tinted</u>
Drying Times at 20°C		
- <i>Dustfree</i>	35 minutes	35 minutes
- <i>Touch dry</i>	1.5 - 2 hours	2 - 2.5 hours
- <i>Through dry</i>	Overnight	Overnight
<i>Through dry at 60°C:*</i>	20 -25 minutes	30 minutes
<i>Through dry IR medium</i>	10 -15 minutes	10 - 15 minutes

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

Total dry film build: 70 - 110 µm 60 - 90 µm

Theoretical coverage: (assuming 100% transfer efficiency and dry film thickness as indicated)
5 - 6 m²/l 6 - 7 m²/l

REPAIR AND RECOATING

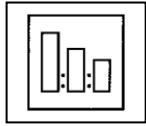


Sanding: Essential before recoating to ensure good adhesion
P800 (wet)
P400 (dry)

Overcoat with: GRS Deltron UHS, Deltron Progress UHS DG topcoat
or Envirobase Basecoat colour



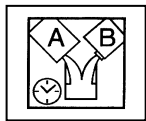
DELTRON HS CHIP RESISTANT PRIMER D821



Mixing by volume

Untinted with HS Hardener - 5 : 1 : 1
(D821:D884/897:thinner)

Tinted with HS Hardener - 3 : 1 : 1 : 1
(D821:UHS/Progress:D884/897:thinner)



Pot Life at 20°C 3 - 4 hours

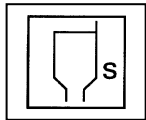
Hardener / Thinner Selection

Up to 18°C D884/897 HS Hardener
D808 Fast thinner

18 - 25°C D884/897 HS Hardener
D807 Thinner - or D866 Primer Thinner

Over 25°C D884/897 HS 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.



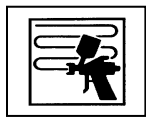
Application viscosities

18 - 25 seconds DIN4



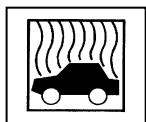
Spraygun Sizes

1.4 - 1.6 mm fluid tip



Number of Coats

2 - 3



Drying Times

Dust Free -

35 minutes

Through dry at 20°C -

Overnight or 30 minutes before topcoat

Through dry at 60°C -

25 - 30 minutes



PERFORMANCE AND LIMITATIONS



Use only the hardeners and thinners recommended on this data sheet.

Do NOT use Hardeners D803, D864 or D8208, Accelerator D818, Enhancer D885.

Where humidity is in the range 70 - 80%, use of Very Slow Thinner is recommended.

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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