



GLOBAL REFINISH  
SYSTEM



November 2007

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# Product Information



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## 2K HS FILLER D8022

*Fast drying 2K Surfacer  
Hardener D858*

### PRODUCT DESCRIPTION

D8022 2K HS Filler is a grey 2K surfacer with high film-build and fast air-drying properties. Suitable for use under a wide range of PPG refinish topcoat, D8022 may be applied as either a high-build or a surfacer simply by adjusting the quantity of thinner in the mix.

When used as a high build surfacer, D8022 offers up to 250 $\mu$  film build and is sandable after 3 hours air dry at 20°C. As a surfacer, D8022 offers approx. 100 $\mu$  and is sandable after only 2 hours at 20°C.

D8022 can be applied over suitably prepared polyester fillers, over sound, fully cured original paintwork, properly preprimed -bare steel and adhesion primers. D8022 may be air-dried, low baked or IR cured.

D8022 is not suitable as a spot primer under Envirobase basecoat.

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### PREPARATION OF SUBSTRATE - DEGREASING

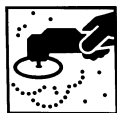


Before any preparation work, wash all surfaces to be painted with soap and water. Rinse and allow to dry before degreasing with a suitable PPG substrate cleaner :

Ensure all substrates are thoroughly cleaned and dried before and after each stage of the preparation work. Always wipe substrate cleaner off the panel surface immediately, using a clean, dry cloth.

Please see the **Deltron Cleaners (RLD63V)** Technical Data Sheet for appropriate substrate cleaning & degreasing products

## PREPARATION OF SUBSTRATE – SANDING



**Bare Steel** should be lightly abraded and completely rust free before application. D8022 may be applied directly, but bare metal primer Universel or Epoxy is recommended where optimum adhesion and corrosion resistance is required.

**Other bare metals, including Zinc coated steel** - should be primed with Universel or Epoxy before the application of D8022.



**Original Paintwork or Primers** should be sanded using P320 grade paper (dry) or P360 grade paper (wet). Spot prime any exposed bare metal with bare metal primer Universel or Epoxy.

**Polyester Fillers** should be dry sanded using a sequence of grade of paper grades suitable for the chosen application of D8022 :

P80-P120 when using D8022 as a high build (2-4 coats).

P80-P120-P240 when using D8022 as an surfacer (1-2 coats).

## MIXING BY VOLUME

	<u>High Build</u>	<u>Surfacer</u>
D8022	3 vol	3 vol
D858	1 vol	1 vol
Thinner*	0.5 vol	0.9 vol

## MIXING BY WEIGHT

### HIGH BUILD MODE

Please note the weights are cumulative. Do not tare or zero scale between additions			
Sprayable Volume	Wt D8022 Grams	Wt D858 Grams	* Wt Thinner Grams
0.25L	260	318.3	342.5
0.5L	520	636.5	685
0.75L	780	955	1027.5
1.0L	1040.0	1273.0	1370.0
1.5L	1560	1910	2055
2.0L	2080	2546	2740
2.5L	2600	3183	3425



## SURFACER MODE

Please note the weights are cumulative. Do not tare or zero scale between additions			
Sprayable Volume	Wt D8022 Grams	Wt D858 Grams	* Wt Thinner Grams
0.25L	238.8	292.3	332.4
0.5L	477.6	584.7	664.8
0.75L	716.3	877.0	997.3
1.0L	955.1	1169.4	1329.7
1.5L	1432.7	1754.0	1994.5
2.0L	1910.2	2192.0	2493.0
2.5L	2387.8	2923.5	3324.0

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## THINNER SELECTION

### Temperature

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

### Thinner

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

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## MIXED PRODUCT DETAILS

	High Build	Surfacer
Potlife at 20°C:	30-45 minutes	45-60 minutes
Spray viscosity DIN4/20°C:	45-50 seconds	25 seconds

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## SPRAYGUN SETUP



*Fluid Tip, Gravity:*

**High Build**

1.8mm

**Surfacer**

1.6mm



*Fluid Tip, Suction*

Not recommended

1.8mm

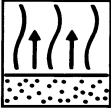
*Pressure:*

Follow spraygun manufacturer's recommendations




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## APPLICATION AND FLASH OFF

	High Build	Surfacer
		
Number of coats:	2-4	1-2
Flash-off/20°C: - between coats	10 minutes	5 minutes
- before stoving	10 minutes	10 minutes

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## DRYING TIMES

	High Build	Surfacer
		
Dust free/20°C	15 minutes	10 minutes
Sandable/20°C	3 hours	2 hours
Through dry/60°C	30 minutes*	30 minutes*
Through dry/IR medium	10 minutes	10 minutes

\* Drying times with substrate at 60°C metal temperature

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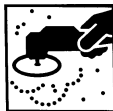
## FILM PROPERTIES

	High Build	Surfacer
Dry Film Builds:		
- maximum	250µ	100µ
- minimum	150µ	75µ
Theoretical coverage**	approx. 3m <sup>2</sup> / litre	approx. 8 m <sup>2</sup> / litre

\*\*Theoretical coverage per ready to spray litre, assuming 100% transfer efficiency and giving dry film thickness between indicated minimum and maximum values.

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## SANDING



Dry: P240 followed by P360



Wet: P600 followed by P800



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## TOPCOATING



D8022 2K HS Filler may be overcoated directly with the following topcoat products :

Global Refinish System/Deltron UHS & Deltron Progress Direct Gloss Colour  
Envirobase Waterborne Basecoat Colour \*(See limitations below)

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## SPOT PRIMING

When spot priming D8022, adopt the following procedure:

1. Ensure that the surface is thoroughly sanded to the panel edge or to a distance several centimetres beyond the damaged area, whichever is smaller.
2. Apply a suitable number of coats to the damaged area, allowing the correct flash-off times. Apply the final coat of material activated and thinned at 3 : 1 : 2, covering a larger area that fully wets out the previous overspray edge.
3. During sanding, be careful to thoroughly level the repair edge.

**NOTE: Do Not Spot Prime under Envirobase.**

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## LIMITATIONS

Use only D858 Hardener with D8022. Accelerators should NOT be used.

D8022 and D858 are sensitive to moisture; so all equipment should be perfectly dry.

When the humidity range is 70-80%, use Very Slow Thinner D869.

Do not use D8022 when humidity levels exceed 80%.

**When used under Envirobase, D8022 should only be used to prime complete panels.**

**DO NOT use as a spot primer.**

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## EQUIPMENT CLEANING

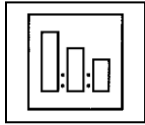
After use, clean spray equipment thoroughly with cleaning solvent or thinner.

**Global at a Glance**

**D8022**

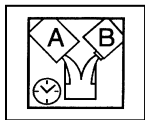


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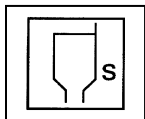


### Mixing by volume

As High Build	3 : 1 : 0.5 using D858 hardener and thinner
As a Surfacer	3 : 1 : 0.9 using D858 hardener and thinner



Pot Life at 20°C	30 - 45 minutes as High Build
	45 - 60 minutes as Surfacer



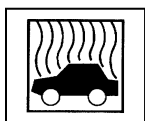
Application viscosities	45 - 50 seconds DIN4 - as High Build
	25 seconds DIN4 - as Surfacer



Spraygun Size	1.6 - 1.8 mm Fluid Tip
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Number of Coats	2 - 4 as High Build
	1 - 2 as Surfacer



Drying Times	
Dust Free	15 minutes
Through dry at 20°C	3 hours as High Build
	2 hours as Surfacer
Through Dry at 60°C	30 minutes
Through Dry using IR	10 minutes

Dry film thicknesses	
	150 - 250 microns, as High Build
	75 - 100 microns, as Surfacer

## 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 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](http://www.ppg.com/PPG_MSDS)

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