



GLOBAL REFINISH  
SYSTEM



May 2006

# Product Information

## DELTRON D825

*2K Tintable Surfacer Base*

### PRODUCT DESCRIPTION

K93 is suitable for the top quality repair of substrates which have coloured surfacers as the original equipment. It is also suitable for general purpose repair work, where its high build and wide colour range can help produce savings in overall material usage.

K93's colour range is achieved by tinting the D825 base with any Deltron DG colour and UHS colour. A range of standard colours may be found on the K93 sales brochure. Alternatively, the D825 base may be tinted with Deltron DG and UHS colour intended for use as the topcoat.

K93 can be applied over any sound paintwork or adhesion primer. If applied as a build surfacer, it can be stoved or air-dried before sanding; alternatively; it may be applied as a wet-on-wet surfacer suitable for use with Deltron topcoats or Envirobase.

### PREPARATION OF SUBSTRATE

#### *Substrate*



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



#### *Preparation*

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

Before and after any sanding operation, the substrate must be thoroughly degreased.

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## MIXING RATIOS

Mixing Ratios using a K93 Formulation:

<u>By Volume</u>	
Tinted D825	5 vol
MS Hardener	1 vol
Thinner	1 vol

1. Mixing Ratios using Wet on Wet Surfacer:

<u>By Volume</u>	
Tinted D825 Colour Mix	5 vol
MS Hardener	1 vol
Thinner	2.5 vol

2. Mixing Ratios using a Customised Formulation:

<u>Build Version</u>	
D825	4 vol
DG colour mix	1 vol
MS hardener	1 vol
Thinner	1 vol

3. Mixing Ratios using Wet on Wet Surfacer:

<u>By Volume</u>	
D825 colour mix	4 vol
DG colour mix	1 vol
MS hardener	1 vol
Thinner	2.5 vol

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## THINNER SELECTION

<u>Temperature</u>	<u>MS Hardener</u>	<u>Thinner</u>
Up to 18°C	D803	D808 Fast Thinner
18 – 25°C	D841	D866 2K Primer Thinner
25 – 35°C	D861	D869 Very Slow Thinner

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## MIXED PRODUCT DETAILS

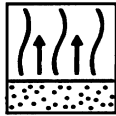
	Build Surfacer	Wet-On-Wet Surfacer
Potlife at 20°C:	1 hour	1.5 hour
Spray viscosity DIN4 at 20°C:	30 seconds	16 seconds

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## APPLICATION AND FLASH OFF



	<i>Build version</i>	<i>Wet-On-Wet Surfacer</i>
<i>Spraygun set-up:</i>	1.4 – 1.8 mm	1.4 – 1.8 mm



<i>Number of coats:</i>	2-4	2
<i>Flash-off at 20°C:</i>	5 - 10 minutes	5 - 10 minutes

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## DRYING TIMES



- <i>Dustfree at 20°C</i>	30 minutes	30 minutes
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- <i>Through dry at 20°C</i>	3 hours	3 hours
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- <i>Through dry at 60°C *</i>	30 minutes	30 minutes
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- <i>Through dry IR medium</i>	5 -10 minutes	5 - 10 minutes
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\* 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 dry film build:</i>	70 - 130 µm	30 - 70 µm
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<i>Theoretical coverage:</i>	Assuming 100% transfer efficiency and dry film thickness as indicated:	
	3 m <sup>2</sup> /l	6 m <sup>2</sup> /l

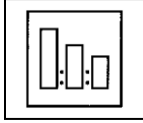
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## REPAIR AND RECOATING

<b>Sanding:</b>	Essential before recoating to ensure good adhesion
Grade wet	P800
Grade dry	P400

<b>Overcoat with:</b>	Deltron BC
	Deltron DG
	Deltron UHS ( See 'Performance and Limitations')
	Envirobase

## K93 2K Tintable Surfacer D825



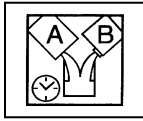
### Mixing by volume

Using ready tinted D825 -

As Surfacer 5 : 1 : 1 - Tinted D825 : MS Hardener : thinner  
As Wet on Wet 5 : 1 : 2.5 - Tinted D825 : MS Hardener : thinner

Using a customized formula

As Surfacer 4 : 1 : 1 : 1 - D825 : DG : MS Hardener : thinner  
As Wet on Wet 4 : 1 : 1 : 2.5 - D825 : DG : MS Hardener : thinner



Pot Life at 20°C 1 hour as Surfacer, 1.5 hours as Wet on Wet

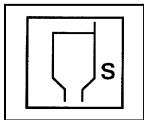
### Hardener / Thinner Selection

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 viscosity

30 seconds DIN4 - as Surfacer  
16 seconds DIN4 - as Wet on Wet



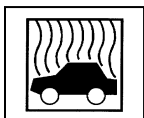
Spraygun Sizes

1.4 - 1.8 mm Fluid Tip



Number of Coats

Surfacer 2 – 4 Coats, Wet on Wet 2 Coats



Drying Times

Dust Free - 30 minutes  
Through dry at 20°C - 3 hours  
Through dry at 60°C - 30 minutes, 20 minutes for wet on wet before topcoating  
Through dry - IR (medium wave) 5 - 10 minutes

Dry Film Thickness - 70 - 130 microns as Surfacer,  
30 - 70 microns as Wet on Wet

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## PERFORMANCE AND LIMITATIONS



Do **not** use D818 Accelerator in D825 K93.

D825 K93 may be a suitable undercoat for Deltron UHS if used wet-on-wet.

Use only the hardeners and thinners recommended on this data sheet. Do **not** use hardener D864.

D825 K93 may be used with D897 using the following mixing ratio:

D825	4 vol
UHS	1 vol
D897	0.75 vol
Thinner	1.5 vol

When using K93 D825 as a wet-on-wet surfacer, it is important to use the same hardener in both wet-on-wet surfacer and subsequent Deltron topcoat.

Where humidity is in the range of 70-80%, the use D869 Deltron Very Slow Thinner is recommended.

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## EQUIPMENT CLEANING

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

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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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