



GLOBAL REFINISH  
SYSTEM



November 2007

# Product Information



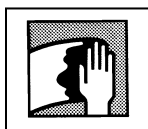
## Hi-Build Primer D8046

### Product Description

Global Refinish System D8046 is a versatile, high build 2K primer, suitable for use under Deltron UHS Direct Gloss topcoats. It offers exceptional film build when used as a spray filler or primer surfacer.

D8046 may be applied over suitably prepared knifing putties, or over sound, fully cured, original paintwork, or adhesion primers. Options are available for air drying, and for conventional baking or Infra Red drying.

## PREPARATION OF SUBSTRATE



In all cases, wash all surfaces to be painted with soap and water, rinse thoroughly and dry. Then apply appropriate GRS Surface cleaner. See **RLD63V Deltron Cleaners** for selection and usage instructions. Ensure that the substrate is thoroughly clean and dry both before and after application work.

### Substrate

### Preparation



Bare Steel  
Galvanised Steel  
Zintec  
Aluminium and Alloys  
Electropaint  
Aged painted surfaces  
Polyester Filler

Must be pre-primed (D831 or compliant Epoxy)  
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Must be pre-primed (D831 or compliant Epoxy)  
P360 (dry), P800 (wet)  
P400 (dry), P280 (wet)  
P320 (dry)

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## MIXING RATIOS

### 1. Mixing Ratios with MS Hardeners - Used as a Primer Filler:

	<u>By Volume</u>	<u>By Weight</u>
D8046	6 vols	1000 g
MS Hardener	1 vol	105 g
Thinner	1 vol	90 g

### 2. Mixing Ratios with MS Hardeners - Used as a Primer Surfacer:

	<u>By Volume</u>	<u>By Weight</u>
D8046	6 vols	1000 g
MS Hardener	1 vol	105 g
Thinner	2 vols	180 g

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## HARDENER AND THINNER SELECTION

<u>Temperature</u>	<u>Hardener</u>	<u>Thinner</u>
Below 15°C	D864 MS Accelerated Hardener	D808 - Fast
15 - 20°C	D864 MS Accelerated Hardener	D808 / D807
20 - 25°C	D803 MS Hardener	D807 / D866

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## MIXED PRODUCT DETAILS

Pot Life at 20°C      90 - 120 minutes as Primer Filler, 4 - 5 hours as Primer Surfacer

Application viscosity      30 - 40 seconds as Primer Filler, 18 - 22 seconds as Primer Surfacer

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## SPRAYGUN SET UP

2.0 - 2.2 mm Fluid tip for Primer Filler - Pressure as per manufacturers recommendations

1.8 - 2.0 mm Fluid Tip for Primer Surfacer - Pressure as per manufacturers recommendations

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## NUMBER OF COATS

Apply 2 coats as a Primer Filler to give a dry film thickness of 100 - 150 microns

Apply 2 - 3 coats as a primer surfacer to give a dry film thickness of 80 - 100 microns



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## FLASH OFF AT 20°C

10 minutes between each coat  
10 minutes before stoving / baking

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## DRYING TIMES

Dust Free at 20°C      15 minutes as Primer Filler, 10 minutes as Primer Surfacer  
Through Dry at 20°C      16 hours as Primer Filler, 5 hours as Primer Surfacer  
Through Dry at 60°C      30 minutes as Primer Filler or as Primer Surfacer

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## OVERCOATING / RECOATING

It is essential to sand before recoating / overcoating. If overcoating with Topcoat, sand with P400 (dry) P800 (wet). Remove all sanding residue and clean thoroughly.

Can be overcoated with:      GRS Deltron DG  
   GRS Deltron BC/Clearcoat  
   GRS Deltron Progress UHS DG

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## TECHNICAL DATA

Theoretical coverage - 1.6 - 2.2 m<sup>2</sup>/l as Primer Filler  
Theoretical coverage - 2.6 - 4.0 m<sup>2</sup>/l as Primer Surfacer  
Theoretical coverage assumes 100% transfer efficiency

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## PERFORMANCE AND LIMITATIONS

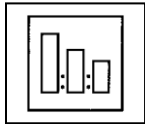
Do not use D8046 at humidity levels above 80% RH.

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## EQUIPMENT CLEANING

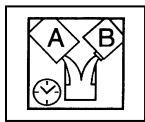
After use clean all equipment thoroughly with cleaning solvent or thinner





### Mixing by volume

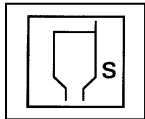
D8046:D864 or D803: Thinner - as Primer Filler - 6:1:1  
 D8046:D864 or D803: Thinner - as Primer Surfacer - 6:1:2



Pot Life at 20°C 90 - 120 minutes as Primer Filler  
 Pot Life at 20°C 4 - 5 hours as Primer Surfacer

### Hardener / Thinner Selection

<u>Temperature</u>	<u>Hardener</u>	<u>Thinner</u>
Below 15°C	D864 MS Accelerated Hardener	D808 - Fast
15 - 20°C	D864 MS Accelerated Hardener	D808 / D807
20 - 25°C	D803 MS Hardener	D807 / D866



### Application viscosity

30 - 40 seconds as Primer Filler  
 18 - 22 seconds as Primer Surfacer



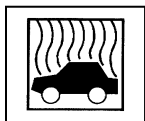
### Spraygun Size

2.0 - 2.2 mm fluid tip for Primer Surfacer application  
 1.8 - 2.0 mm fluid tip for Primer Surfacer application



### Number of Coats

2 coats as Primer Filler  
 2 - 3 coats as Primer Surfacer



### Drying Times

Dust Free 15 minutes - Spray Filler  
 10 minutes - Primer Surfacer  
 Through Dry @ 20°C 16 hours - Spray Filler  
 5 hours - Primer Surfacer  
 Through Dry @ 60°C 30 minutes

Over coat with: GRS Deltron UHS  
 GRS Deltron Progress UHS DG



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## 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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