



GLOBAL REFINISH  
SYSTEM



December 2008

# Product Information



## WATERBORNE EPOXY PRIMER

*Waterborne Epoxy Primer* D8012  
*Hardener for Waterborne Epoxy Primer* D8212

### PRODUCT DESCRIPTION

Waterborne Epoxy Primer is a two component primer that has excellent sealing properties over paint films that are sensitive to solvents. It is fast drying with excellent corrosion resistance.

Epoxy Primer Filler may be applied directly to properly prepared bare steel, zinc coated steels, galvanised steel, aluminium, sound original paintwork, and polyester bodyfillers. It can be directly overcoated with any Deltron 2K Primers

### PREPARATION OF SUBSTRATE - SANDING



#### **Substrate**

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

#### **Preparation**

P80 – 120 (dry)  
P400 (dry)  
Scotchbrite  
P280-320(dry)  
P280/320 (dry) / P600 (wet)  
P280/320 (dry) / P280 - 320 (wet)  
P320 (dry)  
P80 - P120 (dry) finish with P180 (dry)

### 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 **Deltron Cleaners (RLD63V)** Technical Data Sheet for appropriate substrate cleaning and degreasing products.

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## MIXING RATIOS

### 1. Mixing Ratios by volume:

D8012	8 parts
D8212	1 parts
Thinner	2 - 3 parts

### 2. Mixing Ratios by weight:

D8012	110 g
D8212	10 g
Thinner	20 – 30 g

Notes: Mix primer and hardener until homogeneous, before addition of Thinner. After adding Thinner, mix again. An induction period of 10 minutes after mixing is necessary before use. T494 thinner should be used with this Primer, or T495 in conditions of high temperature (above 35°C).

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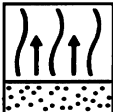
## MIXED PRODUCT DETAILS

Potlife at 20°C: 2 hours.  
Note: Material does not gel, but must not be used more than 2 hours after mixing.

Spray viscosity at 20°C: 30 - 35 seconds DIN4


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## APPLICATION AND FLASH-OFF

	<i>Spraygun set-up</i>	1.3 - 1.4 mm Fluid Tip
	<i>Number of coats:</i>	1 - 2
	<i>Flash-off between coats at 20°C:</i>	10 - 15 minutes or until matt Thin coats may be dried with an air blower

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## DRYING TIMES

	- <i>Dust free</i>	10 - 15 minutes or when matt, can be gently dried with an air blower
	- <i>Dry to sand at 20°C</i>	Can be gently dry de-nibbed after 20 minutes

*Total dry film build:* Max 10 – 15 microns



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## REPAIR AND RECOATING - Spot Primer for Sensitive Substrates



Sanding: Denib around overspray edge.

Use fine grade paper, or sponge backed abrasive P1200 or finer

Overcoat / Re-coat time: After drying, by blowing with air, overcoat when matt



Directly Overcoat with: It can be directly overcoated with any Deltron 2K Primers.

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## PERFORMANCE AND LIMITATIONS



Use only the D8212 hardener recommended on this datasheet.

The pot life of this product is about 2 hours. Be aware that this product does not gel, therefore care should be taken NOT to use after 2 hours.

Storage: Between +5°C and 35°C

Only to be used as Wet-on Wet primer for sensitive substrates.

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## EQUIPMENT CLEANING

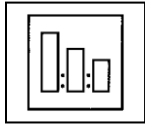
After use, clean all equipment thoroughly with cleaning solvent or thinner.



# Global at a Glance

## WATERBORNE EPOXY PRIMER

# D8012

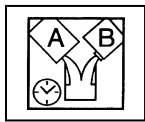


### Mixing by volume

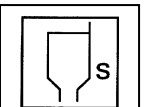
With D8212 Hardener and Thinner - 8 : 1 : 2 - 3

### Mixing by Weight

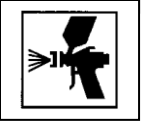
D8012 - 110g : D8212 - 10g : Thinner - 20 / 30g



Pot Life at 20°C - 2 hours maximum.



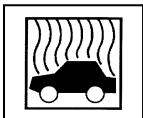
Application viscosity 30 - 35 seconds DIN4



Spraygun Sizes 1.3 - 1.4 mm Fluid Tip



Number of Coats 2 maximum



### Drying Times

Dust Free - 10 - 15 minutes or until matt,  
can be gently dried with an air blower.

Through dry at 20°C Can be gently dry de-nibbed after 20 minutes



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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)

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

