



GLOBAL REFINISH
SYSTEM



December 2008

Product Information



PLASTIC ADHESION PROMOTERS

D816 Flexible Adhesion Promoter for Plastics
D820 Plastic Adhesion Promoter
D8420 Plastic Adhesion Promoter - Aerosol

PRODUCTS

These are special adhesion promoters for a variety of plastic substrates.
The formulations are optimised for use on plastics used in the automotive industry.

D820 is a transparent ready-for-use adhesion promoter for plastic substrates. It is suitable for use on the wide variety of plastics except PE, PC, ABS, PU/PU-RIM, PP and POM.
It is now available as D8420 in an aerosol.

D816 is a plastic adhesion promoter specially designed for use on all PUR, PUR/RIM, PC and ABS.

PREPARATION OF SUBSTRATE

If the plastic surface appears inconsistent, it is recommended that the part be "flamed" or pre-stoved for 30 minutes at 60°C.



Substrate

GRP, Fibre glass
Other plastics (new part)
Other plastics (light damage)
Polyester filler (A652)
Pinhole filler (A655)

Sand

P320 (dry)
Fine sanding pad
P320 -P400 (dry)
P400 (dry)
P400 (dry)



Prior and after any sanding operation, the substrate must be thoroughly degreased with Deltron D846.

Before the adhesion promoter application, D846 may be used sprayed on the panel and allowed to evaporate in order to avoid any static electricity effect.

These products are for professional use only.


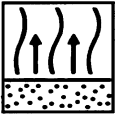
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MIXING RATIO

D816 & D820 are supplied ready for use, no thinning required.
Stir D816 thoroughly before use.

D8420 is ready to spray from the aerosol. Shake to dislodge the ball bearing & then shake for 2 minutes prior to use.

APPLICATION, FLASH-OFF AND DRYING

	D816	D820
 <i>Spraygun set-up:</i>	1.3 - 1.6 mm	1.3 - 1.6 mm
		D8420 - Shake the aerosol can to mix the contents thoroughly (approx 2 minutes), until the mixing pellets can be heard.
<i>Number of coats:</i>	2	1 - 2
 <i>Flash-off at 20°C:</i>		
- <i>Between coats</i>	5 - 10 minutes	n/a
- <i>Before topcoating</i>	60 minutes	30 minutes – D820 20 minutes – D8420
<i>Total dry film build:</i>	15 - 25 µm	3 - 7 µm

REPAIR AND RECOATING

Sanding: Not necessary in normal use.



Overcoat with: Deltron topcoats*
Envirobase*

* Failure to observe the recommended flash time before topcoat may result in adhesion failure.



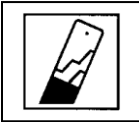
Global at a Glance **D816/D820/D8420**

PLASTIC ADHESION PROMOTERS



Prior and after any sanding operation, the substrate must be thoroughly cleaned using D846 Antistatic Agent.

If the plastic surface appears to be inconsistent, it is recommended that the part be "flamed" or pre - stoved at 60°C for 30 minutes.



D816 and D820 are supplied "Ready for Use" so no mixing is required. D816 should be thoroughly stirred before use. D8420 is supplied in an aerosol - dislodge the ball bearing and shake for 2 minutes before use.



D816 / D820 1.3 - 1.6 mm Fluid Tip

D8420 is supplied in an aerosol - shake can thoroughly for 2 minutes After ball bearing is released.

Number of coats

D816 - 2 coats with 5 - 10 minutes flash off between coats.

D820 : D8420 - 1 to 2 coats

Flash off before topcoating / overcoating

D816 - 40 minutes before topcoating / overcoating

D820 - 30 minutes before topcoating / overcoating

D8420 - 20 minutes before topcoating / overcoating

Dry Film Thickness

D816 15 - 25 microns

D820 / D8420 3 - 7 microns



PERFORMANCE AND LIMITATIONS

It is necessary to shake the plastic adhesion promoter can a few seconds before use.

When higher build is necessary, D839 flexibilised or D8023 flexibilised (see relevant individual technical datasheet for details) may be used on top of the plastic adhesion promoters.

AEROSOL CAN DISPOSAL

When aerosol is empty, turn it upside down and press the nozzle until all propellant is exhausted. Place empty can or cans that will no longer be used into properly labeled metal containers. The waste containers should be managed as a hazardous waste according to legislation.

EQUIPMENT CLEANING

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

VOC INFORMATION

D8420 Aerosol

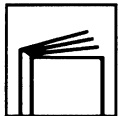
The EU limit value for this product (product category: IIB.e) in ready to use form is max. 840g/litre of VOC. The VOC content of this product in ready to use form is max. 840g/litre.

D816/D820

This product falls outside of the scope of EU Directive 2004/42 and therefore does not have a VOC product category classification.

This product can be used by professional motor vehicle repairers.

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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