



GLOBAL REFINISH
SYSTEM



February 2010

Product Information



GRS Deltron CeramiClear™ 8122

CeramiClear 8122 Clear

PRODUCTS

Deltron CeramiClear 8122 Clear	D8122
Deltron HS Hardeners	D897 / D8208
Deltron Thinners	D808, D807, D812, D869, D8718, D8719
Deltron Catalyst Thinner	D8714

PRODUCT DESCRIPTION

Deltron CeramiClear 8122, is a 2K acrylic urethane Clearcoat, for the repair and repainting of original CeramiClear Clearcoat, over a single or multistage colour basecoat system.

D8122 contains the CeramiClear technology that gives excellent scratch resistance.

D8122 is designed for use over Envirobase Basecoat.

Deltron CeramiClear 8122 has an organic solvent content lower than conventional clearcoats.

This makes it particularly suitable for use in areas where VOC emissions or product VOC content is restricted and productivity is an issue.

PREPARATION OF SUBSTRATE

Deltron D8122 CeramiClear 8122, must be applied on top of a clean and dust free basecoat. The use of a tack rag is recommended.

MIXING RATIOS

Mixing ratios with HS Hardeners (by volume)	D8122	3
	HS Hardener*	1
	Thinner*	0.5

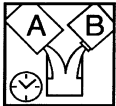
As with all ultra high solids products, cold ready for use paint temperatures can lead to more difficult application and overspray absorption. It is strongly recommended that ready for use product is applied at a temperature greater than 15°C

*HARDENER AND THINNER SELECTION

Choose HS hardener and thinner according to application temperature:

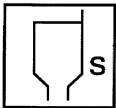
<i>Temperature</i>	<i>HS Hardener</i>	<i>Thinner</i>
Up to 18°C	D8208	D808
18°C - 25°C	D897	D807/D8718
Over 25°C	D897	D812/D8719

For exceptional conditions of temperature and humidity (over 35°C / Over 70%RH) the use of D869 Very Slow thinner is recommended. Use HS Hardener D8208 / D808 for Spot Repairs.



Pot Life at 20°C

1 hour with D897 hardener
30 min. with D897 hardener and D8714 Catalyst Thinner



Application Viscosity 19 - 21 seconds / DIN4 / 20°C

APPLICATION AND FLASH OFF



Spraygun set-up: 1.3 - 1.6 mm

Conventional Two Coat Process

Application

Apply 2 single coats to give 50-60 microns dry film build.

Flash off between spray coats 10 minutes

Flash off before bake or IR dry 5 – 10 minutes

Express Single Visit Process

Application

Apply 1 medium & 1 full coat to give 45-50 microns dry film build.

The first coat should be applied to all repair panels before the second coat is applied.

Flash off between spray coats For less than 3 panels, 2-3 minutes

For more than 3 panels, no flash off is required.

Flash off before bake or IR dry 5 – 10 minutes



DRYING TIMES



Dust Free at 20°C	20 - 25 minutes
Dry to handle at 20°C	6 hours
Through dry at 20°C	24 hours
Through dry at 60°C	30 - 40 minutes
Through dry with IR (medium)	15 minutes (IR drying is colour dependant)

Stoving times are for quoted metal temperature. Additional time should be allowed in the stoving schedule to allow the metal to reach recommended temperature.

Drying times may be reduced by using D8714 Catalyst Thinner together with D897 Hardener.

Total Dry Film Thickness 50 - 60 microns

Theoretical coverage 8 m²/l - Assuming 100% transfer efficiency

REPAIR AND RECOATING

Sanding: Essential before recoating to ensure good adhesion

- *Grade wet* P800
- *Grade dry* P400

Overcoating / Re-Coat time

- *After force drying / IR* After Cooling
- *Air Drying at 20°C* Minimum 12 hours

Overcoat with: Deltron 2K primers, Envirobase, Deltron Topcoats

SPOT REPAIR PROCEDURES

- Apply GRS Deltron D8122 CeramiClear according to the 'Application, Flash-Off and Drying' section above.
- Take care to minimise the clearcoat edge in the fade-out area using spraygun technique.
- Melt overspray edge using D8730 Aerosol Fade-Out Thinner or D8429 Rapid Blender.
- Refer to datasheet No: RLD199V for successful repair.

POLISHING

Low Bake or IR drying Minimum 1 hour after cooling
Air Drying at 20°C Minimum 12 hours after application



WEIGHT MIX TABLE FOR D8122 (using D808/D807/D812/D869 Thinners)

GUIDELINES FOR WEIGHT MIXING			
Where a specific volume of clearcoat mix is required, this may be best achieved by weight mixing, using the guidelines below.			
The weights are cumulative - please do NOT tare the balance between additions.			
Target Volume of RFU Paint required (Litres)	Weight Clearcoat D8122	Weight UHS Hardener D8208/D897	Weight Thinner
0.10 L	66 g	90 g	100 g
0.20 L	133 g	181 g	200 g
0.25 L	166 g	226 g	250 g
0.33 L	219 g	298 g	330 g
0.50 L	332 g	451 g	500 g
0.75 L	499 g	677 g	750 g
1.00 L	665 g	903 g	1000 g
1.50 L	997 g	1354 g	1500 g
2.00 L	1329 g	1805 g	2000 g
2.50 L	1662 g	2257 g	2500 g

WEIGHT MIX TABLE FOR D8122 (using D8718/D8719 Thinners)

GUIDELINES FOR WEIGHT MIXING			
Where a specific volume of clearcoat mix is required, this may be best achieved by weight mixing, using the guidelines below.			
The weights are cumulative - please do NOT tare the balance between additions.			
Target Volume of RFU Paint required (Litres)	Weight Clearcoat D8122	Weight UHS Hardener D8208/D897	Weight Thinner D8718/D8719
0.10 L	66 g	90 g	99 g
0.20 L	133 g	181 g	199 g
0.25 L	166 g	226 g	248 g
0.33 L	219 g	298 g	328 g
0.50 L	332 g	451 g	497 g
0.75 L	499 g	677 g	745 g
1.00 L	665 g	903 g	994 g
1.50 L	997 g	1354 g	1491 g
2.00 L	1329 g	1805 g	1988 g
2.50 L	1662 g	2257 g	2484 g



BEST PRACTICES WITH UHS PRODUCTS

Paint storage conditions

Keep ready for use paint in good conditions to ensure correct viscosity.

RFU temperature above a minimum of 15°C, and ideally over 18°C.
This includes paint, hardeners and thinners.

Mixing and making ready for use

Activate accurately, and by weight where ever possible.

Where mixing must be by volume, only use a round and parallel sided mixing container together with the correct mixing stick. If using a measuring container marked in percentages, you must be sure that the percentages give the correct quantities.

Make sure that Hardener and Thinner is mixed in well. High solids or high viscosity products can take a little longer to mix in, so a good practice is to stir Hardener in first, then add thinner before stirring again.

Use mixed product as quickly as possible.

Choose the correct Hardener for the required bake cycle.

Keep to the recommended levels of additives.

Do not exceed the recommended level of additives such as Flexibilisers.

Application technique, process and equipment choices

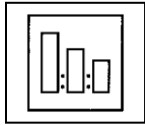
Use correct spraygun set ups, and set up the spraygun correctly.

Use a "Single Visit" application wherever possible, following the advice given in the application section.

Check that the spraybooth is operating effectively. If necessary make an oven check to be sure that metal temperature is reached, especially on low down repair areas.

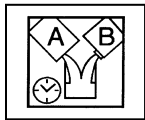
PPG recommendations are based on time at metal temperature, so this should be allowed for in the bake cycle that is set for the job.





Mixing by volume

With HS Hardener - 3:1:0.5



Pot Life at 20°C

1 hour with normal thinner and D897 hardener
30 min. with Catalyst Thinner D8714 and D897 Hardener

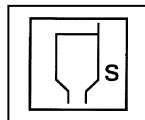
Hardener / Thinner Selection

Up to 18°C D8208 HS Accelerated Hardener
D808 Fast thinner

18 - 25°C D897 HS Hardener
D807/D8718 Thinner

Over 25°C D897 HS Hardener
D812/D8719 Slow thinner

For exceptional conditions of Temperature and humidity (above 35°C or 70% RH) the use of D869 Very Slow thinner is recommended.



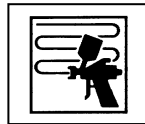
Application viscosity

19 - 21 seconds DIN4



Spraygun Size

1.3 - 1.6 mm fluid tip



Number of Coats

Conventional - 1 medium coat, 10 minute flash off, followed by 1 full coat.
Express - 1 light/medium coat followed by 1 full coat. Allow 2-3 mins flash between coats if painting less than 3 repair panels.

Drying Times

10 minutes flash off before stoving or IR dry.

Dust Free -	20 - 25 minutes
Through dry at 20°C -	24 hours
Through dry at 60°C -	30-40 minutes



ACCELERATED THINNER SELECTION

- Use of D8714 Catalyst Thinner

D8714 Catalyst Thinner can be used for only in combination with D897 Hardener where rapid curing is required. Some reduction in final appearance may be noticed when using D8714. This combination should be used immediately after mixing.

EQUIPMENT CLEANING

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

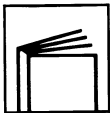
VOC INFORMATION

The EU limit value for this product (product category:11B.d) in ready to use form is max. 420g/litre of VOC.

The VOC content of this product in ready to use form is max. 420g/litre

Depending upon 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.

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: www.ppgrefinish.com

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