



GLOBAL REFINISH
SYSTEM



March 2010

Product Information



GRS Deltron Low Gloss Clearcoat - D8113/D8122 Mix (Approx. 20 – 30% Gloss @ 60°)

D8113 Matt Clearcoat
D8122 Ceramiclear™

PRODUCTS

Deltron Matt Clearcoat	D8113
Deltron CeramiClear™	D8122
Deltron HS Hardeners	D8238, D8239
Deltron Thinners	D807, D812
Deltron Low VOC Thinners	D8718, D8719

PRODUCT DESCRIPTION

The mix of D8113 and D8122 Clearcoats is designed for use over Envirobase or Deltron basecoats. Deltron basecoat must only be used for repair work not controlled by EU Directive 2004/42.

Deltron Low Gloss Clearcoat Mix is a versatile 2K acrylic urethane clearcoat designed for the specialised repairs of vehicles or areas of vehicles originally finished with low gloss clearcoat over a single or multistage colour basecoat system (e.g. Mercedes full body Matt Finish). To allow for the normal gloss variations - due to colour, model, position of repair on vehicle etc., the actual mix of the two Clearcoats can be varied to match the vehicle to be repaired.

The D8113/D8122 Mix may be used over rigid plastics without the need for special additives.

The D8113/D8122 Mix Clearcoat can be used with Deltron HS hardeners D8238 / D8239.



PREPARATION OF SUBSTRATE

The Deltron D8113/D8122 Mix Clearcoat must be applied on top of a clean and dust-free basecoat. The light use of a tack cloth is recommended after the basecoat has flashed off.

Care should be taken to avoid dirt inclusion at all stages. Rectification of dirt inclusion in Matt or Low Gloss finishes is not possible after the final coat of clearcoat.

D8113/D8122 MIX RATIOS

To allow for normal variations in the gloss level, depending on colour, model, position of repair on vehicle, it is possible to mix the D8113 and D8122 as follows to match the required gloss for a particular repair.

	Lower Gloss Option <u>By Weight</u>	Higher Gloss Option <u>By Weight</u>
D8113	85	80
D8122	15	20

The resulting mix is then activated and thinned as below.

Note: It is strongly recommended that test panels are produced to check for colour and gloss level against the vehicle to be repaired.

MIXING RATIO

Mixing ratios with MS Hardeners D8238 / D8239

	<u>By Volume</u>	<u>By Weight</u>
D8113 / D8122 Mix	3 volumes	See table, Page 4
HS Hardener*	1 volume	
Thinner*	1 volumes	

- Choose HS Hardener / Thinner according to application temperature *
- As with all high solids products, cold ready for use paint temperatures can lead to more difficult application and overspray absorption.

HARDENER SELECTION

<u>System</u>	<u>HS Hardener</u>	<u>Bake Schedule</u>
For use at Temperatures 18 - 25°C	D8238 Fast	30 minutes @ 60°C
For use at Temperatures Above 25°C	D8239 Slow	40 minutes @ 60°C

Note: The choice of thinner depends upon size of area to be painted.



MIXED PRODUCT DETAILS

Potlife at 20°C: 2 hours with D8238 hardener

Spray viscosity at 20°C 16 - 19 seconds DIN4.

APPLICATION AND FLASHOFF



Spraygun set-up: 1.2 - 1.4 mm

Conventional Two/Three Coat Process

Application Apply 2 - 3 single coats to give 50 - 60 microns dry film build.

Flash off between spray coats Minimum 15 minutes or until fully and evenly matt over the whole repair area.*

Flash off before bake or IR dry Minimum 15 minutes or until fully and evenly matt over the whole repair area.*

***Note:** Allowing the Clearcoat Mix to flash off fully between coats and before bake is important to achieve an even appearance and gloss level over the whole area.

DRYING TIMES

Dust free time at 20°C	30 minutes with D8238,
Dry to handle at 20°C	3 hours with D8238
Through dry at 20°C	12 hours with D8238
Through dry at 60°C*	30 minutes with D8238, 40 minutes with D8239
Through dry at IR (medium wave)	8 - 15 minutes (depending upon colour)



*Bake times are for quoted metal temperature. Additional time should be allowed in the bake schedule to allow metal to reach recommended temperature.

Total dry film build: 50 – 60 µm

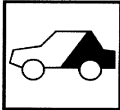
Theoretical coverage: Assuming 100% transfer efficiency and dry film thickness as indicated: 8 m²/l



REPAIR AND RECOATING



- Sanding:** Essential before recoating to ensure good adhesion
- *grade wet* P800
 - *grade dry* P400 - P500



- Overcoat / Re-coat time:**
- *Force dry at 60°C, or IR* After cooling
 - *Air drying at 20°C* 12 hours

- Overcoat with:**
- Deltron primers
 - Envirobase
 - Deltron topcoats

WEIGHT MIX TABLE FOR D8113/D8122 MIX

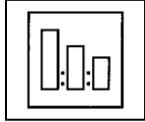
Target Volume of RFU Paint required (Litres)	Weight Clearcoat D8113/D8122 Mix	Weight HS Hardeners D8238/D8239	Weight D807 or D812 Thinner	Weight D8718, D8719 Low VOC Thinner
DO NOT TARE THE SCALE BETWEEN ADDITIONS				
0.10 L	62g	82g	100g	99g *
0.20 L	124g	164g	199g	197g *
0.25 L	155g	205g	249g	246g *
0.33 L	207g	273g	332g	328g *
0.50 L	311g	410g	498g	492g *
0.75 L	466g	615g	747g	738g *
1.00 L	622g	820g	996g	984g *
1.50 L	932g	1230g	1493g	1476g *
2.00 L	1244g	1640g	1992g	1969g *
2.50 L	1555g	2050g	2490g	2461g *

* The thinner options above are alternatives.



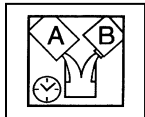
Global at a Glance D8113/D8122 Mix

GRS Deltron Low Gloss Clearcoat



Mixing by volume

With HS Hardener 3 : 1 : 1



Pot Life at 20°C

Using D8238 2 hours

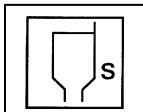
Hardener Selection

For application temperatures
18 - 25°C

D8238 Fast Hardener

For application temperatures
Above 25°C

D8239 Medium Hardener



Application Viscosity

16 - 19 seconds DIN4



Spraygun Size

1.2 - 1.4 mm fluid tip

Number of Coats

Conventional -

2/3 single coats, flash-off until fully matt between coats.
Flash off until fully matt before baking.



Drying Times

Dust free at 20°C

30 minutes with D8238,

Through dry at 60°C

30 minutes with D8238
40 minutes with D8239



PERFORMANCE AND LIMITATIONS

The Gloss levels achieved with this clear may vary depending upon film thickness and application. Low film thickness and dry application will give a Low Gloss. High film thickness and wet application will give a higher gloss level.

It is recommended that this clear be used for complete panel repair only.

To remove minor dirt inclusions in the final finish, the repair should be fully dried, de-nibbed after cooling and **one** further coat of the Clearcoat Mix applied. Care should be taken to avoid too high clearcoat film thicknesses because the final colour could be affected. In this situation, the repair will require sanding and recoating with Basecoat and Clearcoat.

Dirt removal from the final Matt Finish is not possible.

EQUIPMENT CLEANING

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

GENERAL CARE AND MAINTENANCE OF MATT FINISHES

The following guidance on Care and Cleaning of matt finish vehicles is aimed at the car owner, and applies to both the OE and the repair finish. With Matt Finishes to maintain an original even Matt effect.

Guidance for the car owner on maintaining the even matt effect over time

1. In order to keep the Matt surface effect, the use of paint cleaner, abrasives or polishes and wax polishes **must** be avoided. The vehicle **must** not be polished.
2. Polishing will lead to a higher, uneven gloss effect.
3. Cleaning/Polishing with unsuitable materials could lead to increased gloss.
4. Automated car washing machines should be avoided. The preferred car washing method is by hand with a soft sponge, neutral soap and lots of water. Too frequent car washing could over a period of time lead to increased and inconsistent gloss levels across a car panel. Washing under direct sunlight should be avoided.
5. Insects and bird residues should be removed immediately. The residues should be soaked in water to soften and/or removed carefully with a high pressure cleaning equipment. In the case of strongly adhered residues, a spray on insect remover should be used prior to washing.



VOC INFORMATION

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.

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.

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

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



Copyright © 2010 PPG Industries, all rights reserved.

