



GLOBAL REFINISH
SYSTEM



March 2010

Product Information



RAPID GREYMATIC 2K Filler

D8010 Light Grey
D8015 Grey
D8017 Dark Grey
D8237/8/9 Hardeners

PRODUCT DESCRIPTION

2K RAPID GreyMatics are a range of 2K primer surfacers suitable for a wide range of repair work in the refinish bodyshop. Versatile, quick-drying and easy to apply and sand, they offer excellent film build, surface levelling and gloss holdout over a wide range of substrates such as sound original paintwork, bare steel, polyester body fillers and suitable adhesion primers.

These primers may be directly overcoated with Deltron UHS Progress or Envirobase.

By combining D8010, D8015 and D8017, GreyMatic shades 1, 3, 5, 6 and 7 may be obtained (See **GreyMatic** section). In this way the topcoat consumption and the total repair process time may be optimised.

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.

PREPARATION OF SUBSTRATE - PRIMING & SANDING



Bare Steel should be lightly abraded and completely rust free before application. 2K HS Surfacer may be applied directly, but Universel or Epoxy Primers, are recommended where optimum adhesion and corrosion resistance is required.



Other bare metals should be pre-primed with either Universel or an Epoxy Primer.

Electropaint should be sanded with P360 grade paper (dry) or P800 grade (wet).



Original Paintwork or Primers should be sanded using P280-P320 grade paper (dry) or P400-P500 grade paper (wet). Spot prime any exposed bare metal with bare metal primer Universel or an Epoxy Primer.



GRP or Fibreglass should be sanded using P320 grade paper (dry).

Polyester Fillers should be dry sanded using a sequence of grade of paper grades suitable for the chosen application of 2K HS Surfacer :
P80-P120 when using as a spray filler.
P80-P120-P240 when using as a primer surfacer or non-sand surfacer.

HARDENER & THINNER SELECTION

<u>Temperature</u>	<u>HS Hardener</u>	<u>Thinner</u>
Up to 18°C	D8237	D808 Fast Thinner
18 - 25°C	D8238	D807 or D866
25 - 35°C	D8239	D812 Slow Thinner
Above 35°C	D8239	D869 Very Slow Thinner

MIXING

	<u>Primer Filler</u>	<u>Primer Surfacer</u>
Mixing Ratio: RAPID GreyMatic	5.0 vol	5.0 vol
Hardener	1.0 vol	1.0 vol
Thinner	0.5 vols	1.0 vol

MIXED PRODUCT DETAILS

Potlife at 20°C:	30 - 45 minutes	45 - 60 minutes
Spray viscosity DIN4/20°C :	40-50 seconds	24-28 seconds

SPRAYGUN SETUP

Fluid Tip,
Gravity: 1.6 - 1.8 mm

Pressure: Follow spraygun manufacturer's recommendations (normally 2 bar / 30 psi)



APPLICATION GUIDE

Number of coats:	2 - 3 Coats	2 - 4 coats
Flash off/20°C: - between coats	5 - 7 minutes depending upon spraying conditions	
- before stoving	5 - 7 minutes depending upon film thickness applied	

DRYING

	<u>Spray Filler</u>	<u>Primer Surfacer</u>
Dust free/20°C	10 minutes	10 minutes
Touch dry/20°C	1 hour	1 hour
Sandable/20°		
Under 100 microns	3 - 4 hours	2 - 3 hours
100 - 150 microns	4 - 5 hours	3 - 4 hours
Above 150 microns	5 - 7 hours	4 - 6 hours
Through dry at 60°C	20 - 30 minutes* depending on film thickness	
Through dry/ Infra Red	12 minutes	

* Drying time once substrate reaches 60°C metal temperature.

FILM PROPERTIES

Dry film builds:	
- Minimum	75µ
- Maximum	200µ

SANDING

Dry :	P400
Wet :	P800

TOPCOATING

RAPID GreyMatic may be overcoated directly with the following topcoat products:
Global Refinish System/Deltron UHS Direct Gloss Colour
Global Refinish System/Deltron UHS Progress Direct Gloss Colour
Envirobase Waterborne Basecoat Colour



FLEXIBLE SUBSTRATES:

Mixing Ratio:	Rapid GreyMatic	4 vol
	HS Hardener	1, 5 vol
	D814	1 vol
	Thinner	0.5 vol

Number of coats	1 - 2
Spray viscosity DIN4/20°C	16 - 20 sec
Flash-off between coats	10 minutes

Note: Addition of D814 can cause a reduction in the drying and sanding performance.

GREYMATICS

The mixtures below should be activated and thinned in the normal way before spraying.

For each of the GreyMatic primer variants specified the following weight mix ratios apply:

	G1	G3	G5	G6	G7
D8010	100	65	--	--	--
D8015	--	35	100	48	--
D8017	--	--	--	52	100

GreyMatic shades are selected according to topcoat colour. The recommended GreyMatic shade for any colour can be referenced in the PPG colour information systems.

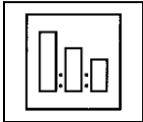
After selecting the correct GreyMatic shade for the topcoat colour, the primer shades are made by reference to the chart above. GreyMatic G1, G5 and G7 are available straight from the can. GreyMatic 3, 5 & 6 can be made using blends of D8010/D8015/D8017 as indicated above.

Mix with hardener & thinner as indicated in this TDS before application.



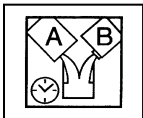
Global at a Glance D8010, D8015, D8017

RAPID GREYMATIC 2K FILLERS D8010, D8015, D8017



Mixing by volume

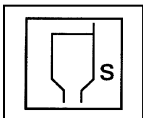
With HS Hardener as Primer Filler - 5 : 1 : 0.5
With HS Hardener as Primer Surfacer - 5 : 1 : 1



Pot Life at 20°C with HS hardeners 30 - 45 minutes

Hardener / Thinner Selection

Up to 18°C	D8237 HS Express Hardener D808 - Fast thinner
18 - 25°C	D8238 HS Fast Hardener D807 Medium Thinner or D866 Primer Thinner
25 - 35°C	D8239 HS Slow Hardener D812 Slow Thinner
Over 35°C	D8239 HS Slow Hardener D869 Extra Slow thinner



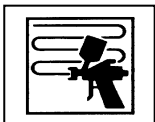
Application viscosities

Primer Filler	40 - 50 seconds DIN4
Primer Surfacer	24 - 28 seconds DIN4



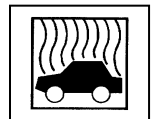
Spraygun Sizes

1.6 - 1.8 mm fluid tip



Number of Coats

2 - 3 as Primer Filler, 2 - 4 coats as Primer Surfacer



Drying Times

Dust Free - 10 minutes
Through dry at 20°C 2 - 3 hours
Through dry at 60°C 30 minutes



WEIGHT MIXING

WEIGHT MIXING FIGURES - as Primer Filler 5:1:0.5:					
Weights are in grams & cumulative. Do not tare the balance between additions					
Target Paint Volume (L)	0.20 L	0.40 L	0.60 L	0.80 L	1.00 L
D8010 / D8015 / D8017	232	465	697	929	1162
Hardener D8237 / D8238 / D8239	263	526	789	1052	1315
Thinner D808/ D807/D812/D869	277	554	830	1107	1384

WEIGHT MIXING FIGURES - as Primer Surfacer 5:1:1:					
Weights are in grams & cumulative. Do not tare the balance between additions					
Target Paint Volume (L)	0.20 L	0.40 L	0.60 L	0.80 L	1.00 L
D8010 / D8015 / D8017	216	431	647	863	1079
Hardener D8237 / D8238 / D8239	244	488	733	977	1221
Thinner D808/ D807/D812/D869	270	539	809	1079	1349

LIMITATIONS

Accelerators should **NOT** be used. Part used cans of hardener must be carefully closed immediately after use. All equipment must be perfectly dry. Use of RAPID GreyMatic is not recommended when humidity levels exceed 80%.

Clean sprayguns immediately after use.



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.

Note:

Combinations of this product with D814, will produce a paint film with special properties as defined by the EU Directive code. The EU limit for these combinations in ready for use form is 840g/litre of VOC. The VOC content of this product in these combinations is max 840g/L.

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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