



GLOBAL REFINISH
SYSTEM



June 2010

Product Information



GRS Deltron Lamborghini Matt Finishing D8113_D8239

D8113 Matt Clearcoat

PRODUCTS

Deltron Matt Clearcoat	D8113
Deltron HS Hardener	D8239
Deltron Thinner	D807, D812

PRODUCT DESCRIPTION

Deltron Matt Clearcoat, D8113, is designed for use over Envirobase basecoat, but can be used over Deltron basecoat for repair work not controlled by EU Directive 2004/42.

D8113 is a versatile and durable 2K acrylic urethane clearcoat designed for the specialised repairs of vehicles originally finished with matt clearcoat, over a single or multistage colour basecoat system. D8113 may be used over rigid plastics without the need for special additives.

The **Matt Finishing Process** has been specifically optimized to repair large matt areas and is designed to ensure a completely even matt finish.

D8113 Matt Clearcoat should only be used with Deltron HS hardener, D8239 and Deltron Thinner, D807 or D812 for this specialized process.

This Matt Clearcoat process datasheet is approved by Lamborghini for the repair of matt vehicles, including repair of Lamborghini 0109 Black Nemesis.

When repairing Lamborghini vehicles you should contact your PPG representative for full documentation for the approved product systems and processes.

PREPARATION OF SUBSTRATE

Deltron D8113 Clear must be applied on top of a clean and dust-free basecoat. The use of a tack cloth is recommended.

For detailed Lamborghini basecoat process recommendations refer to Technical Bulletins from PPG Industries Limited or Automobili Lamborghini S.p.A.

MIXING RATIO

Mixing ratios with HS Hardeners D8239

	<u>By Volume</u>	<u>By Weight</u>
D8113*	3 volumes	See table below
HS Hardener	1 volume	
Thinner (D812 preferred)	1.5 volumes	

WEIGHT MIX TABLE FOR D8113

***Note:** For **Lamborghini Black Nemesis** colour the Clearcoat should be mixed as follows:-

1 Litre Clearcoat mix = 1034.0g D8113 + 2.1g D740 toner

The Black Nemesis Clearcoat mix should be activated and thinned by weight using the standard clearcoat chart below.

Target Volume of RFU Paint required (Litres)	Weight Clearcoat D8113 *(+ D740 where necessary)	Weight HS Hardener D8239	Weight Thinner D807 / D812
0.10 L	56g	75g	100g
0.20 L	113g	150g	201g
0.25 L	141g	188g	251g
0.33 L	186g	248g	332g
0.50 L	282g	375g	503g
0.75 L	423g	563g	754g
1.00 L	564g	751g	1005g
1.50 L	846g	1127g	1508g
2.00 L	1128g	1502g	2010g
2.50 L	1410g	1878g	2513g

MIXED PRODUCT DETAILS

Potlife at 20°C: 4 hours

Spray viscosity at 20°C 15 seconds DIN4.



APPLICATION AND FLASHOFF



Spraygun set-up:

1.2 - 1.4 mm

Use a Compliant / HVLP spraygun



Two/Three Coat Process

The preparation of colour test panels to check the colour and number of coats of clearcoat to achieve the correct matt effect is strongly recommended. The original matt finish can sometimes become less matt over time due to weathering and cleaning processes used by car owners, and D8113 can be used to copy this gloss level by applying an additional coat.

Notes: No Fade-out process is possible for matt colours.

The clearcoat can be de-nibbed to remove minor dirt inclusions after the flash off time between coats listed below. Any de-nibbing must be completed before the final coat of matt clearcoat is applied.

Dirt removal from the final Matt Finish is not possible.

*Application
(1st coat)*

Apply 1 full single coat to whole panel being repaired.

Flash off for at least 40-50 minutes ensuring clearcoat is **completely matt** before applying the next coat.

If colour test panel indicated that 3 coats of clearcoat are required to achieve the correct level of gloss, then :-

*Application
(2nd coat if necessary)*

Apply 1 full single coat to panel being repaired.

Flash off for at least 40-50 minutes ensuring clearcoat is **completely matt** before applying the next coat.

*Application
(Final coat)*

Apply the final coat of clearcoat as a cross coat, i.e. 1 pass in one direction, followed immediately by a second pass at right angles to the first pass. The second pass applied at approx. 40% greater distance between spraygun and panel.

Flash off before bake

At least 40 minutes ensuring clearcoat is **completely matt** before baking.



DRYING TIMES

Through dry at 60°C**

60 minutes



**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

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*

After cooling



Overcoat with:

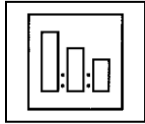
Deltron primers

Envirobase

Deltron BC

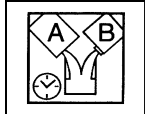


GRS Deltron Matt Clearcoat



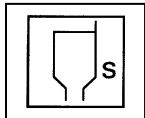
Mixing by volume

With HS Hardener 3 : 1 : 1.5



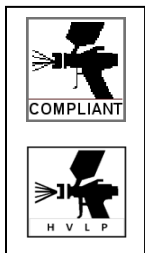
Pot Life at 20°C

4 hours



Application Viscosity

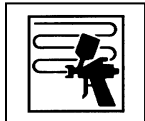
15 seconds DIN4



Spraygun Size

1.2 - 1.4 mm fluid tip

The use of a Compliant / HVLP spraygun is highly recommended



Number of Coats

1 to 2 single coats, 40 - 50 minutes flash-off between coats.
Final cross coat, 1 pass followed by
1 pass at right angles to 1st (40% greater gun distance from panel).

At least 40 minutes ensuring clearcoat is **completely matt** before baking.



Drying Times

Through dry at 60°C 60 minutes



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.

EQUIPMENT CLEANING

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

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

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