



GLOBAL REFINISH
SYSTEM



October 2010

Product Information



GRS Deltron UHS Clearcoat D8130

D8130 UHS Clearcoat

PRODUCTS

Deltron UHS Clearcoat	D8130
Deltron UHS Hardeners	D8242, D8243, D8244

For matt, satin and textured finishes or painting of flexible substrates:

Deltron Matting Base	D8456 to create a matt or satin appearance
Deltron Plasticiser	D814 to plasticise finishes over a flexible substrate
Deltron Matt Flexibiliser	D819 to create a matt or satin appearance over a flexible substrate
Deltron Texture Additive	D843 to create a fine textured 'suede' effect
Deltron Leather Grain Additive	D844 to create a coarser, more pronounced textured finish

PRODUCT DESCRIPTION

Deltron UHS Clearcoat is a 2K acrylic urethane clearcoat for the repair and repainting of panels originally finished with clearcoat over a single or multistage colour basecoat system.

D8130 is designed for use over Envirobase basecoat colour. It may be used in 2 different modes, standard 2 coat application, or a "One Visit" application, where 1 medium / continuous coat is followed by a full coat with no flash off between coats. This Product is designed to be mixed with Hardener only. No thinners are required.

PREPARATION OF SUBSTRATE

Deltron D8130 Clear must be applied on top of clean and dust-free Envirobase basecoat. The use of a tack rag is recommended.

MIXING RATIO

Mixing ratios with HS Hardener:

	<u>By Volume</u>	<u>By Weight</u>
D8130	2 vol	See page 5
HS Hardener*	1 vol	

Choose HS Hardener according to application temperature *

- 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 SELECTION

<u>UHS Hardener</u>	<u>Application Temperature</u>
D8242	Up to 18°C
D8243	18°C-30°C
D8244	Above 30°C

D8243 is the recommended Hardener choice in a Low Bake environment for optimum performance of D8130 up to 30°C application temperature. D8242 can be used but will not provide drying benefits over D8243 in these situations, and is best suited to an air dry process.

MIXED PRODUCT DETAILS

Potlife at 20°C:	1 hour with D8242 hardener 1.5 hours with D8243/8244 hardeners
Spray viscosity at 20°C	17-19 seconds DIN4.

APPLICATION AND FLASHOFF



Spraygun set-up: 1.3 - 1.4 mm

Express Single Visit Process - Recommended

Application Apply 1 medium & 1 full coat to give 50-60 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 flash off.

Flash off before bake or IR dry For more than 3 panels, no flash off is required.

0 – 5 minutes

Conventional Two Coat Process

Application Apply 2 single coats to give ~60 microns dry film build.

Flash off between spray coats 5 – 7 minutes

Flash off before bake or IR dry 0 – 5 minutes



DRYING TIMES

- Through dry at 60°C*
 - 30 minutes with D8243
 - 30 minutes with D8242
 - 35 minutes with D8244
- Through dry at 20°C
 - 16 hours with D8242
- 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.

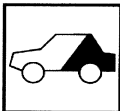
**D8243 is the recommended Hardener choice in a Low Bake environment for optimum performance of D8130 up to 30°C application temperature. D8242 can be used but will not provide drying benefits over D8243 in these situations, and is best suited to an air dry process.

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, 70°C or IR* After cooling
 - *Air drying at 20°C* 12 - 24 hours - depending on hardener.

Overcoat with: Deltron primers
Envirobase
Deltron topcoats



MATT, SATIN AND TEXTURED FINISHES PAINTING OF FLEXIBLE SUBSTRATES

To obtain a matt, semi-matt (satin) or textured finish with Deltron D8130 UHS Clearcoat, it is necessary to include matt, flex or texture additives in the mix. Additives are also required when applying D8130 over a flexible substrate (typically plastics). The additives required and the appropriate volume and/or weight mix ratios are indicated in microfiches if relevant or in the tables below.

Note: The majority of plastics used on cars are considered **Rigid**. These plastics may have flexibility when painted off the car, but are rigid once mounted. UHS Clearcoats only require addition of the Flexible Additive (See **Flexible** chart below) when painting very flexible plastic mostly found on older vehicles, e.g. foam type.

Cumulative Mixing by Weight

Do not tare the balance between additions

<i>Substrate</i>	<i>Appearance</i>	<i>D8130</i>	<i>D8456</i>	<i>D843</i>	<i>D844</i>	<i>D814</i>	<i>D819</i>	<i>UHS Hardener</i>	<i>Thinner GRS Deltron</i>
RIGID	Gloss	648g	-	-	-	-	-	978g	-
	Satin	486g	733g	-	-	-	-	980g	-
	Matt	389g	784g	-	-	-	-	982g	-
	Matt Textured	299g	-	672g	-	-	-	824g	959g
	Leather Grain	417g	-	-	756g	-	-	968g	-
FLEXIBLE	Gloss	616g	-	-	-	740g	-	977g	-
	Satin	259g	500g	-	-	-	640g	937g	985g
	Matt	216g	582g	-	-	-	697g	972g	989g
	Matt Textured	208g	-	520g	-	-	632g	897g	975g
	Leather Grain	271g	-	-	492g	-	638g	983g	-

POLISHING



If polishing is required, i.e. to remove dirt nibs, it is recommended that it is carried out between 1 hour and 24 hours after the quoted drying time. Use PPG Specialty Polishing system SPP1001.



FADE - OUT REPAIR PROCEDURE

- Apply D8130 UHS Clearcoat according to the information above
- Take care to minimise the clearcoat edge in the fade-out area
- Melt overspray edge using D8730 Aerosol Fade-Out Thinner or D8429 Rapid Blender.
- Refer to datasheet No: RLD 199V for successful repair

WEIGHT MIX TABLE FOR D8130

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 UHS Clearcoat D8130	Weight UHS Hardener D8242 / 8243 / 8244
0.10 L	65 g	98 g
0.20 L	130 g	196 g
0.25 L	162 g	245 g
0.33 L	214 g	323 g
0.50 L	324 g	489 g
0.75 L	486 g	734 g
1.00 L	648 g	978 g
1.50 L	972 g	1467 g
2.00 L	1296 g	1956 g
2.50 L	1620 g	2445 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

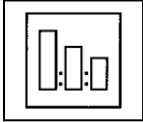
Use correct spraygun set ups, and set up the spraygun correctly.

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.

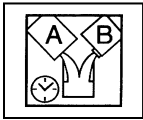
PPG recommendations are based on time at metal temperature, so this should be allowed for in the bake cycle that is set for the job.





Mixing by volume

With UHS Hardener 2:1



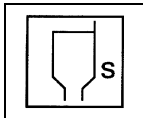
Pot Life at 20°C

Using D8242 1 hour
Using D8243/4 1.5 hours

Hardener Selection

Up to 18°C D8242 UHS Hardener
18°C-30°C D8243 UHS Hardener**
Above 30°C D8244 UHS Hardener

**D8243 is the recommended Hardener choice in a Low Bake environment for optimum performance of D8130 up to 30°C application temperature. D8242 can be used but will not provide drying benefits over D8243 in these situations, and is best suited to an air dry process.



Application Viscosity

17 - 19 seconds DIN4



Spraygun Size

1.3 - 1.4 mm fluid tip

Number of Coats

Express - Recommended

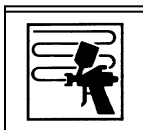
1 light/medium coat, plus by 1 full coat. The first coat should be applied to all repair panels before the second coat is applied.

For less than 3 panels, allow 2-3 minutes flash off.

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

Conventional -

2 single coats, 5 - 7 minute flash-off between coats.



Drying Times

Through dry at 20°C 16 hours with D8242

Through dry at 60°C
30 minutes with D8243
30 minutes with D8242
35 minutes with D8244



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.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 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 D8456, D814, D819, D843 or D844 will produce a paint film with special properties as defined by the EU Directive code.

In these specific combinations: 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.

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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