



GLOBAL REFINISH
SYSTEM



November 2011

Product Information



DP3000 ENVIRO PRIMER SURFACER

D8511 Light Grey G1
D8515 Grey G5
D8517 Dark Grey G7
D8225 Hardener
D8718/19/20 Thinners

PRODUCT DESCRIPTION

DP3000 is a range of 2K primer surfacers which incorporate a raw material made from recycled waste plastic bottles (PET flakes). The DP3000 is suitable for a wide range of repair work in the refinish bodyshop. Versatile 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 High Performance.

By combining D8511, D8515 and D8517 (see **GreyMatic** section), the GreyMatic range of primers can be obtained. 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. Etch Primer or Epoxy Primer, are recommended where optimum adhesion and corrosion resistance is required.



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

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



Original Paintwork or Primers should be sanded using P320 grade paper (dry) or P400 - P500 grade paper (wet). Spot prime any exposed bare metal with bare metal primer Etch Primer or 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 DP3000 Primer Surfacer :
P80 - P120 when using as a High Build filler.
P180 - P320 when using as a primer surfacer.

HARDENER & THINNER SELECTION

<u>Temperature</u>	<u>HS Hardener</u>	<u>Thinner</u>
18 - 25°C	D8225	D8718
25 - 35°C	D8225	D8719
Above 35°C	D8225	D8720

MIXING

	<u>High Build</u>	<u>Primer Surfacer</u>
Mixing Ratio: DP3000	3 vol	3 vol
Hardener	1 vol	1 vol
Thinner	0.5 vols	1 vol

MIXED PRODUCT DETAILS

Potlife at 20°C:	20 - 30 minutes	30 - 45 minutes
Spray viscosity DIN4/20°C :	25 - 30 seconds	18 - 20 seconds

SPRAYGUN SETUP

Fluid Tip,
Gravity: 1.6 - 1.8 mm
Pressure: Follow spraygun manufacturer's recommendations (normally 2 bar / 30 psi)



APPLICATION GUIDE

	<u>High Build</u>	<u>Primer Surfacer</u>
Number of coats:	2 Coats	2 - 3 coats
Flash off/20°C: - between coats	5 minutes depending upon spraying conditions	
- before stoving	0 - 5 minutes depending upon film thickness applied	

DRYING

	<u>High Build</u>	<u>Primer Surfacer</u>
Dust free/20°C	15 minutes	10 minutes
Touch dry/20°C	1 hour	1 hour
Sandable/20°C	4 - 6 hours	3 - 4 hours
Through dry at 60°C	30 - 40 minutes* depending on film thickness	
	* Drying time once substrate reaches 60°C metal temperature.	
Through dry/ Infra Red	8 - 12 minutes**	
	** Actual times will depend on equipment used and film thickness.	

FILM PROPERTIES

Dry film builds:		
- Minimum	150µ	75µ
- Maximum	200µ	125µ

SANDING

Dry :	P400 – P500
Wet :	P800 – P1000

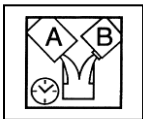
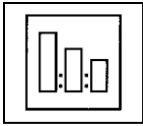
TOPCOATING

DP3000 may be overcoated directly with the following topcoat products:
Global Refinish System/Deltron UHS Progress Direct Gloss Colour
Envirobase High Performance Waterborne Basecoat Colour



Global at a Glance D8511, D8515, D8517

DP3000 Enviro Primer Surfacer



Mixing by volume

With HS Hardener as High Build 3 : 1 : 0.5
With HS Hardener as Primer Surfacer 3 : 1 : 1

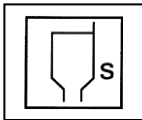
Pot Life at 20°C with HS hardeners:
20 - 30 minutes when mixed 3:1:0.5
30 - 45 minutes when mixed 3:1:1

Hardener / Thinner Selection

18 - 25°C D8225 Hardener
 D8718 Thinner

25 - 35°C D8225 Hardener
 D8719 Thinner

Over 35°C D8225 Hardener
 D8720 Thinner

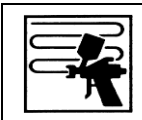


Application viscosities

Primer Filler 25 - 30 seconds DIN4
Primer Surfacer 18 - 20 seconds DIN4



Spraygun Sizes
1.6 - 1.8 mm fluid tip



Number of Coats
2 as High Build, 2 - 3 coats as Primer Surfacer



Drying Times
Dust Free 10 - 15 minutes
Through dry at 20°C 3 - 6 hours
Through dry at 60°C 30 - 40 minutes

All depending on mode of use and film thickness



WEIGHT MIXING

<u>WEIGHT MIXING FIGURES - as High Build 3:1:0.5</u> Weights are in grams & cumulative. Do not tare the balance between additions						
Target Paint Volume (L)	0.25 L	0.33 L	0.50 L	0.66 L	0.75 L	1.00 L
D8511 / D8515 / D8517	263	348	527	695	790	1053
Hardener D8225	323	426	646	852	968	1291
Thinner D8718 / D8719 / D8720	346	456	691	912	1037	1382

<u>WEIGHT MIXING FIGURES - as Primer Surfacer 3:1:1</u> Weights are in grams & cumulative. Do not tare the balance between additions						
Target Paint Volume (L)	0.25 L	0.33 L	0.50 L	0.66 L	0.75 L	1.00 L
D8511 / D8515 / D8517	237	313	474	626	711	948
Hardener D8225	290	383	581	767	871	1162
Thinner D8718 / D8719 / D8720	331	438	663	875	994	1326

LIMITATIONS

Part used cans of hardener must be carefully closed immediately after use.
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

PPG Industries (UK) Limited.
Auto Refinish
Customer Service and Sales Group,
Needham Road,
Stowmarket,
Suffolk.
IP14 2AD,
England.
Tel: 01449 771775
Fax: 01449 77348

