



GLOBAL REFINISH
SYSTEM



January 2016

Product Information

DP6000 2K Rapid Primer

D8531 Light Grey
D8535 Grey
D8537 Dark Grey
D8237 HS Hardener
D8716 Productive Thinner
D8715 For high temperature application
D8719 For force drying and IR

PRODUCT DESCRIPTION

DP6000, 2K Rapid Primer, is a high quality primer that is easy to apply with excellent sanding properties whilst focusing on the efficiency of the bodyshop. A simple, one-visit, application process with little to no flash off, gives a repair ready to sand in only an hour. Versatile and easy to apply and sand, the primers 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[®] GRS BC,
DELTRON[®] GRS DG,
DELTRON[®] UHS Progress or
ENVIROBASE[®] High Performance basecoat.

DP6000 is offered in the Greymatic System; available in three grey shades, and providing the opportunity to mix a further range of greys to find the most suitable to optimise each topcoat colour. This further improves process times and also reduces basecoat consumption.

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 2K Etch primer or Epoxy Primers, are recommended where optimum adhesion and corrosion resistance is required.

Other bare metals should be pre-primed with either 2K Etch primer 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 2K Etch primer 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 application of DP6000.

P80-P120-P240 when using as a primer surfacer.

HARDENER & THINNER SELECTION

<u>Temperature</u>	<u>Hardener</u>	<u>Thinner</u>
Below 25°C	D8237	D8716
Over 30°C	D8237	D8715

Note: For accurate activation and thinning, weight mixing is recommended (See Page 4).

MIXING

Mixing Ratio: DP6000	4 vol
Hardener	1 vol
Thinner	1 vol

MIXED PRODUCT DETAILS

Pot-life at 20°C:	45 minutes
Spray viscosity DIN4/20°C:	25 - 30 seconds (@ 4 : 1 : 1)

SPRAYGUN SETUP

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

APPLICATION GUIDE

Number of coats:	1 medium coat + 2 full/wet coats
Flash off between coats:	1 minute flash off after first coat (No flash off on following coats)
Flash off before force drying:	Until matt

DRYING

Sandable @ 20°C	1 hour
Sandable below 20°C	1 hour
Through dry at 60°C	20 - 25 minutes* depending on film thickness
Through dry/ Infra Red	12 minutes

* D8719 For force drying and IR

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

* Max 120 microns when using force dry process.

FILM PROPERTIES

Dry film builds:	
- Minimum	75µ
- Maximum	120µ

SANDING



Finish with the following grades: - P360 or finer: Single layer solid colours (Direct Gloss)
P400 or finer: Basecoats



Finish with the following grades: - P600 or finer: Single layer solid colours (Direct Gloss)
P800 or finer: Basecoats

TOPCOATING

DP6000 may be overcoated with the following topcoat products:

Deltron BC Basecoat Colour

Deltron DG Direct Gloss Colour

Deltron UHS Direct Gloss Colour

Deltron UHS Progress Direct Gloss Colour

Envirobase High Performance basecoat colour

GREYMATICS

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

For each of the DP6000 primer variants specified the following weight mix ratios apply:

	G1	G3	G5	G6	G7
D8531	100	58	--	--	--
D8535	--	42	100	48	--
D8537	--	--	--	52	100

WEIGHT MIXING

Weight Activations for use with HS hardeners (D8237) Ratio 4 : 1 : 1			
	Please note the weights are cumulative. Do not tare or zero scale between additions		
RFU Sprayable Volume (@ 4 : 1 : 1 ratio)	D8531 Grams (4 Parts)	D8237 Grams (1 Part)	D8715/16 Grams (1 Part)
1.0L	971	1134	1150
RFU Sprayable Volume (@ 4 : 1 : 1 ratio)	D8535 Grams (4 Parts)	D8237 Grams (1 Part)	D8715/16 Grams (1 Part)
1.0L	878	1042	1184
RFU Sprayable Volume (@ 4 : 1 : 1 ratio)	D8537 Grams (4 Parts)	D8237 Grams (1 Part)	D8715/16 Grams (1 Part)
1.0L	885	1048	1191

Flexible Additive Weight Activations for use with HS hardeners (D8237)				
	Please note the weights are cumulative. Do not tare or zero scale between additions			
RFU Sprayable Volume	D8531	D814	D8237	D8715/16
1.0L	882	995	1173	1252
RFU Sprayable Volume	D8535	D814	D8237	D8715/16
1.0L	796	910	1088	1166
RFU Sprayable Volume	D8537	D814	D8237	D8715/16
1.0L	803	917	1095	1173

LIMITATIONS

Part used cans of hardener must be carefully closed immediately after use. All equipment must be perfectly dry.

Clean sprayguns immediately after use.

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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