



GLOBAL REFINISH
SYSTEM



August 2015

Product Information



Premium UHS Clearcoat D8173

D8173 Premium UHS Clearcoat

PRODUCTS

Premium UHS Clearcoat	D8173
UHS Hardener	D8302
Thinners	D8717/D8718/D8719
Accelerator Thinner for Clearcoat – Intermediate	D8713
Accelerated Thinner	D8714

For textured finishes or painting of flexible substrates:

DELTRON® Plasticiser	D814 to plasticise finishes over a flexible substrate
<i>Deltron</i> Matt Flexibiliser	D819 for textured appearance over a flexible substrate
<i>Deltron</i> Texture Additive	D843 to create a fine textured 'suede' effect
<i>Deltron</i> Leather Grain Additive	D844 to create a coarser, more pronounced textured finish

PRODUCT DESCRIPTION

PREMIUM UHS CLEARCOAT - D8173 is an acrylic 2 component clearcoat optimized for use over ENVIROBASE® High Performance basecoat.

PREPARATION OF SUBSTRATE

D8173 Clear must be applied on top of clean and dust-free *Envirobase* High Performance basecoat. The use of a tack rag is recommended.

MIXING RATIO

Mixing ratios with UHS Hardener:

	<u>By Volume</u>	<u>By Weight</u>
D8173	3 vol	See table, Page 4
UHS Hardener	1 vol	
Thinner*	0.6 vol	

- Choose Thinner 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 AND THINNER SELECTION

<u>System</u>	<u>UHS Hardener</u>	<u>Thinner</u>	<u>Bake Schedule</u>
Accelerated	D8302	D8714	15 mins at 60°C
Accelerated - Intermediate	D8302	D8713	25 mins at 60°C
Standard	D8302	D8717/D8718/D8719	35 mins at 60°C
Slow for high Temperatures	D8302	D8719	35 mins at 60°C

The choice of thinner should be made according to application temperature, air movement and size of job.

MIXED PRODUCT DETAILS

Potlife at 20°C: 40 minutes with D8302 and D8714
 60 minutes with D8302 and D8713
 75 minutes with D8302 hardener

Spray viscosity at 20°C 18 - 20 seconds DIN4.

APPLICATION AND FLASH OFF



Spraygun set-up: 1.2 - 1.3 mm

Express Single Visit Process

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.

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

Flash off before bake or IR dry 0 – 5 minutes

DRYING TIMES

- Through dry at 60°C* 15 minutes with D8302 + D8714
 25 minutes with D8302 + D8713
 35 minutes with D8302 + D8717/18/19
- Through dry at IR 8 - 15 minutes (depending upon colour)
 (medium wave) metal temperature 90°C-100°C



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



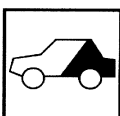
REPAIR AND RECOATING



Sanding: Essential before recoating to ensure good adhesion

- *grade wet* P800
- *grade dry* P400 - P500

Overcoat / Re-coat time:



- *Force dry , or IR* After cooling

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.

Denib with P1200, followed by P1500 dry disc.

Lightly damp a 3M Trizact P3000 disc or similar with clean water ensuring that the P1500 scratches are eliminated.

Use PPG Specialty Polishing system SPP1001.

It is important to polish at minimum speed, to avoid the surface becoming too hot. If necessary, allow the panel to cool down before continuing to polish.

FADE - OUT REPAIR PROCEDURE

- Apply D8173 PREMIUM UHS CLEARCOAT Premium UHS Clearcoat according to the information above
- Take care to minimise the clearcoat edge in the fade-out area
- Melt overspray edge using D8731 Aerosol Spot Blender or D8430 Spot Blender.
- Refer to datasheet No: RLD 299V for successful repair.

WEIGHT MIX TABLE FOR D8173 PREMIUM UHS CLEARCOAT

Target Volume of RFU Paint required (Litres)	Weight Clearcoat D8173 PREMIUM UHS CLEARCOAT	Weight UHS Hardener	Weight Thinner
0.10 L	65	88	98
0.25 L	161	219	246
0.33 L	213	289	325
0.60 L	390	528	588
0.75 L	484	657	738
1.00 L	646	877	983



PAINTING OF PLASTIC SUBSTRATES - TEXTURED FINISHES

To obtain a textured finish with D8713 Premium UHS Clearcoat, it is necessary to include flex or texture additives in the mix. Additives are also required when applying D8713 over a flexible substrate. 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 some flexibility when painted off the car, but are rigid once mounted. UHS Clearcoats only require the addition of the Plasticiser Additive (See **Flexible** chart below) when painting very flexible plastics, mostly found on older vehicles, e.g. foam type.

Cumulative Mixing by Weight

Do not tare the balance between additions

Substrate	Appearance	D8173	D843	D844	D814	D819	UHS Hardener	Deltron Thinner
RIGID	Gloss	652g	-	-	-	-	883g	990g
	Matt Textured	267g	590g	-	-	-	732g	949g
	Leather Grain	375g	-	672g	-	-	871g	973g
FLEXIBLE	Gloss	545g	-	-	646g	-	877g	984g
	Matt Textured	207g	508g	-	-	616g	836g	1053g
	Leather Grain	300g	-	538g	-	694g	906g	1008g

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.

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.

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