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GLOBAL REFINISH SYSTEM

April 2018

Product Information

D8595 Epoxy Primer

Epoxy Primer	*D8595*
Hardener for Epoxy Primer	*D8298*
Performance Hardener	*D8294*
Thinner For Epoxy Primer	*D8752*

PRODUCT DESCRIPTION

D8595 is a multi-mode 2K Epoxy Surfacer. It is light grey in colour, chromate-free and has good corrosion resistance over bare metal.
D8595 has good adhesion to a wide variety of suitably prepared substrates. These include bare and galvanised steel, aluminium, painted surfaces and fillers.

D8595 and its two dedicated hardeners - together forming a versatile package.

- Hardener D8298 offers three modes of use - As a sanding filler, an isolator/sealer under 2K primers & surfacers or as a wet-on-wet for small spot repairs & run-throughs.

- Performance Hardener D8294 gives warranty capability as a sanding filler and can also be used as an isolator/sealer under 2K primers & surfacers.

Primer + Hardener	**Possible Modes Of Use**		
D8595 + Epoxy Hardener D8298	Sanding Filler	Isolator	Wet-on-Wet - Spot Repair
D8595 + Performance Hardener D8294	Sanding Filler	Isolator	

PREPARATION OF SUBSTRATE

SUBSTRATE	SAND
Bare Steel	P80-P120
Galvanised steel	P400 (dry)
Zintec	Fine sanding pad
Aluminium and alloys	P240-P320(dry)
Electropaint	P320(dry)/P800(wet)
Aged painted surfaces	P240/P320/P400/P500
GRP , Fibre - glass	P320(dry)
Polyester filler	P80-P120-P180(dry)

Degrease all surfaces to be painted with appropriate PPG substrate cleaner before and after sanding operation.

Clean off residues and dry thoroughly before re-cleaning with appropriate PPG substrate cleaner. See Technical Data Sheet **DELTRON® Cleaners RLD63.**

MIXING RATIOS

FULL WEIGHT MIX TABLES ARE AVAILABLE ON PAGE 5 OF THIS DATASHEET.

1. Mixing Ratios as Sanding Filler:

	Using Hardener D8298		Using Hardener D8294	
	Volume	**Weight**	**Volume**	**Weight**
D8595	3 Parts	100g	3 Parts	100g
D8298	1 Part	20.7g		
D8294			1 Part	20.7g
D8752	0.8 Parts	15.8g	1 Part	19.8g

2. Mixing Ratios as isolator:

	Using Hardener D8298 or D8294	
	Volume	**Weight**
D8595	3 Parts	100g
D8298 / D8294	1 Part	20.7g
D8752	1.7 Parts	33.7g

3. Mixing Ratios for use as a Wet-on-Wet for Spot Repair:

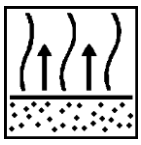
	Using Hardener D8298	
	Volume	**Weight**
D8595	3 Parts	100g
D8298 only	1 Part	20.7g
D8752	1 Part	19.8g

Note: the Wet-on-Wet Spot Repair mode is not recommended with Performance Hardener D8294

MIXED PRODUCT DETAILS

	FILLER	*ISOLATOR*	*SPOT REPAIR/WOW*
Pot-life 20°C			
Using D8298	4 Hours	3 Hours	4 Hours
Using D8294	4 Hours	8 Hours	*Not Recommended*
Spray Viscosity			
Using D8298	23 - 25	16 - 20	21 - 23
Using D8294	27 - 29	16 - 20	*Not Recommended*
(Sec DIN4 / 20°C)			

APPLICATION AND FLASH-OFF



	FILLER	*ISOLATOR*	*SPOT REPAIR WOW*
Spraygun set-up			
	1.4 - 1.6 mm	1.3 - 1.4 mm	1.3 - 1.4 mm
	Adjust pressure according to gun manufactures recommendations		
Number of coats			
	1 light coat 2 full coats	1 light coat 1 full coat	1 light coat 1 full coat
Flash-off at 20°c			
- Flash off Between coats			
Using D8298	5-10 min	5 - 10 min	5 - 10 min
Using D8294	10 min	5 - 10 min	*Mode not Recommended*
- Flash off before topcoat			
Using D8298	After Sanding	10-20 min (Until matt) before primer *See Note - DP4000 **	30-60 min Depending on temp & humidity *See Note - DP4000 **
Using D8294	After Sanding	20-30 min * Before sandable primer	*Mode not Recommended*
Note: If DP4000 is to be used on top of D8595 in Isolator or spot prime/wet-on-wet mode, a minimum of 30 mins flash off is required.			

DRYING TIMES

	FILLER	*ISOLATOR*	*SPOT REPAIR/WOW*
-Through dry at 60°c			
	30mins*	N/A	N/A
- Airdry 20°c	Overnight		

-Through dry IR medium wave			
	10 min*	N/A	N/A

*Stoving times are for quoted metal temperature. Additional time should be allowed in the stoving schedule to allow metal to reach recommended temperature

DRY FILM BUILD

	FILLER
Dry Film Build	100-120 microns

REPAIR & RECOATING

When used as an isolator - D8595 must be overcoated with a primer within 8 hours.

D8595 can be overcoated with: Any *Deltron* 2K primer.

***NOTE* When used in isolator or spot repair/wet-on-wet mode, D8595 should be left to flash off a minimum of 30 minutes if overcoating with DP4000**

In Filler mode D8595 should be sanded after drying prior to the application of topcoat.

- Sand P360 or finer if topcoating with Direct Gloss.
- Sand P400 or finer if topcoating with Basecoat + Clearcoat

Topcoats - D8595 can be topcoated with :

- *Deltron* Progress UHS Direct Gloss.
- ENVIROBASE® High Performance Basecoat

Note: See appropriate topcoat Technical Datasheet

PERFORMANCE & LIMITATIONS

-D8595 should not be used at lower temperature than 10°c and humidity higher than 80%.

MIXING BY WEIGHT

The weights in the tables below are cumulative in grams - please do **NOT** tare or zero the scale between additions.

1. Weight mixing for Sanding Filler mode.

	Using Epoxy Hardener D8298				Using Performance Hardener D8294		
Vol Ratio	**3 Parts**	**1 Part**	**0.8 Parts**		**3 Parts**	**1 Part**	**1 Part**
Total Vol Sprayable	Epoxy Primer D8595	Hardener D8298	Thinner D8752		Epoxy Primer D8595	Hardener D8294	Thinner D8752
0.25 L	231.3	279.2	315.8		222.0	268.0	312.0
0.33 L	305.3	368.5	416.9		293.0	353.8	411.8
0.5 L	462.5	558.3	631.7		444.0	536.0	624.0
0.66 L	610.5	737.0	833.8		586.1	707.5	823.7
0.75 L	693.8	837.5	947.5		666.0	804.0	936.0
1.0 L	925.0	1116.7	1263.3		888.0	1072.0	1248.0
1.5 L	1387.5	1675.0	1895.0		1332.0	1608.0	1872.0

2. Weight mixing for Isolator mode.

Using Epoxy Hardener D8298 or Performance Hardener D8294			
Vol Ratio	**3 Parts**	**1 Part**	**1.7 Parts**
Total Vol Sprayable	Epoxy Primer D8595	Hardener D8298/D8294	Thinner D8752
0.25 L	194.7	235.1	300.7
0.33 L	257.1	310.3	396.9
0.5 L	311.6	376.1	481.1
0.66 L	514.1	620.6	793.9
0.75 L	545.3	658.2	842.0
1.0 L	778.9	940.4	1202.8
1.5 L	1168.4	1410.5	1804.2

3. Weight mixing Wet-on-Wet for Spot Repair.

Using Epoxy Hardener D8298			
Vol Ratio	**3 Parts**	**1 Part**	**1 Parts**
Total Vol Sprayable	Epoxy Primer D8595	Hardener D8298 Only	Thinner D8752
0.25 L	222.0	268.0	312.0
0.33 L	293.0	353.8	411.8
0.5 L	444.0	536.0	624.0
0.66 L	586.1	707.5	823.7
0.75 L	666.0	804.0	936.0
1.0 L	888.0	1072.0	1248.0
1.5 L	1332.0	1608.0	1872.0

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.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.

HEALTH & 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: **http://www.ppg.com/PPG_MSDS**

PPG Industries (UK) Limited.
Auto Refinish
Customer Service and Sales Group,
Needham Road,
Stowmarket,
Suffolk.
IP14 2AD,
England.
Tel: 01449 771775
Fax: 01449 773480