



GLOBAL REFINISH  
SYSTEM



February 2010

# Product Information



## **CERAMICLEAR™ DELTRON D8105**

High Solids Clearcoat

### **PRODUCT DESCRIPTION**

PPG CeramiClear™ Deltron D8105 is a mar and scratch resistant high solids clearcoat.

PPG CeramiClear™ Deltron D8105 has excellent surface properties which, compared with conventional clearcoats, protect the finish against scratches & abrasion therefore preserving the glossy finish for a long time.

PPG CeramiClear™ Deltron D8105 is compatible with Envirobase Basecoat

### **PREPARATION OF SUBSTRATES**

	<p><b>ATTENTION!</b> If a damaged part has to be repaired without replacing it, it is absolutely necessary to sand the OE CeramiClear™ thoroughly. Superficial sanding can result in adhesion problems.</p>
	<p>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.</p> <p>Please see <b>Deltron Cleaners (RLD63V)</b> Technical Data Sheet for appropriate substrate cleaning and degreasing products</p>

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## BASECOAT DRY TIME

Basecoat flash-off at 20°C: Envirobase:20 - 30 minutes  
(use of hand held or freestanding airblower recommended)

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## MIXING RATIO

	<u>By Vol</u>
D8105	2 vol
D8215	1 vol

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## MIXED PRODUCT DETAILS

Spray viscosity  
DIN4 at 20°C: 16 - 18 seconds

Potlife at 20°C: 1 hour

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## APPLICATION AND FLASH OFF

Spraygun set-up (conventional): 1.3 – 1.4 mm fluid nozzle.  
Flow knob open to 2.5 turns from fully shut

Pressure at Gun: See spraygun manufactures recommendation.

Number of coats: 1 light and continuous coat, 1 full

Flash-off:  
- Between coats 10 minutes  
- Before stoving 10 minutes

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## DRYING TIMES

Through dry at 60°C 30 minutes

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## TECHNICAL INFORMATION

Dry Film Thickness 45 - 60 microns



## FADE OUT PROCESS

Fade Out Thinner D8425 has been developed to allow a simple and easy fade-out of PPG Deltron CeramiClear D8105 on panels with OE CeramiClear finish.

Follow the process below to achieve a successful repair.



Clean the OE finish thoroughly first to remove any water soluble dirt prior to commencing preparation work. Use an appropriate substrate cleaner/degreaser. PPG make a range of cleaning & degreasing products. See Technical Datasheet: **Deltron Cleaners RLD63** for suitable cleaners & degreasers

### Blending Area Basecoat



Sand the surface with an eccentric sander (sanding stroke 3-5 mm) and with 3M™ Hook-it™ 260L grade P800 - P1200; sand Edges and borders again with 3M™ Soft Pad Ultrafine.



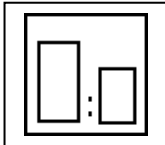
Moist sanding of the blending area with an Eccentric sander (sanding stroke 3mm) And 3M™ Trizact™ Finesse-It™ fine Sanding disc P3000 supported by a Preparation gel, e.g. Matt Gel or 3M™ Prep & Blend.



Clean & degrease surface again thoroughly.



Apply CeramiClear™ As usual and fade out into the matted blending area. Do not apply the clearcoat on the unsanded surface.



Mix the Ready- for - use D8105 CeramiClear™ approximately 1 : 3 with D8425 CeramiClear™ Fade Out Thinner.

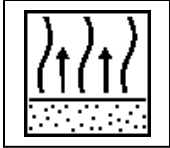


Apply the thinned CeramiClear™ in light coats over the fade out area, (always stay within the prepared area). Apply enough to give a smooth edge. Finish with Neat D8425 Fade' Out Thinner.

### Blending Area Clear - Fade Out Area

Moist sanding of the Fade Out area with 3M™ Trizact™ Finesse-It™ fine sanding disc P3000 and an eccentric sander (sanding stroke 3mm). The surface must be 100% matt. Do not use Scotchbrite! The sanded Fade Out area must be sufficiently large.





Flash off time before baking - 10 minutes at 20°C.



Bake for 30 - 35 minutes at 60°C (metal temperature), and allow to cool.



After cooling, cure the fade out area for another 15 minutes (approx) with Infra Red (medium) at 100% power. Allow to cool for 20 - 30 minutes.



If necessary, sand out any dirt in the fade out area, or remove any texture with 3M™ Trizact P3000 disc. Do not use any other abrasives.



Polish the fade out area with PPG Specialty Performance Products SPP1001

- always start the polishing process with the black SPP final polishing pad.
- use only a small amount of the polishing compound
- Max; 1500 rpm
- Always lead the polishing machine from the repair to the OE.
- Always check the surface temperature (Do not allow to get hot)

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## REMOVAL OF DUST AND DIRT



3M™ Trizact™ Finesse-It™ P3000 discs are recommended to sand out dust and / or dirt.



Remove any sanding scratches with a 75mm 3M™ Trizact™ Finesse-It™ P3000 fine sanding disc (wet) and an eccentric sander (sanding stroke 3mm).



Polish the repair area with PPG Specialty Performance Products SPP1001 Using the Orange SPP compounding foam pad (SPN1902) on a polishing machine at approx. 1500 rpm. To achieve a mirror gloss, finish the repair using the SPP final polishing pad (SPN1903).

Note: for more aggressive polishing, use the orange SPP compounding foam pad Use SPP Lambswool compounding pad (SPN1905) only in a difficult polishing situation. Following the recommended procedures ensure the original texture and scratch resistance remain at the highest possible level.



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# **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**

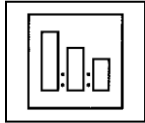
Use correct spraygun set ups, and set up the spraygun correctly.

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.

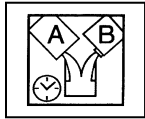
PPG recommendations are based on time at metal temperature, so this should be allowed for in the bake cycle that is set for the job.



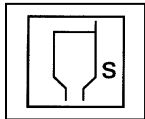


Mixing by volume

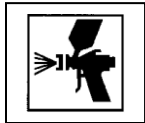
With HS Hardener - 2 : 1



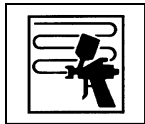
Pot Life at 20°C 1 hour



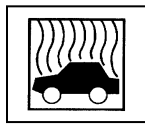
Application viscosity 16 - 18 seconds DIN4



Spraygun Size 1.3 - 1.4 mm fluid tip



Number of Coats 1 light but continuous coat,  
10 minute flash off, followed by 1 full coat



Drying Times

Flash before bake: 10 minutes flash off before stoving.  
Through dry at 60°C - 30 minutes

Dry Film build 45 - 60 microns



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## VOC INFORMATION

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.

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.

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## 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](http://www.ppgrefinish.com)

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