



GLOBAL REFINISH
SYSTEM



January 2007

Product Information



PRIMA D839

*2 Component Primer
with HS Hardeners*

PRODUCT DESCRIPTION

Prima is a grey 2K primer surfacer, suitable for a wide range of day-to-day repair work.

Versatile, quick drying and easy to apply and sand, it offers excellent corrosion resistance, film build, surface levelling and gloss holdout over a wide range of substrates.

By simple adjustment of the thinning ratio, Prima may be applied as a conventional primer surfacer, as a high build spray filler. Prima may be air dried, low baked or IR cured.

Prima may be applied directly to sound original paintwork, bare steel (small areas), polyester bodyfillers and suitable adhesion primers. It may be directly overcoated with compliant 2K topcoat materials such as Deltron Progress UHS DG or Envirobase Basecoat.

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. Prima may be applied directly, but Universel or Epoxy Primers are recommended where optimum adhesion and corrosion resistance is required.

Other bare metals should be pre-primed with either Universel or 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 bare metal primer Universel 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 Prima :
P80-P120 when using as a spray filler.
P80-P120-P240 when using as a primer surfacer or non-sand surfacer.

MIXING RATIO

1. Mixing Ratio with HS Hardener as a Spray Filler:

	<u>By Volume</u>
D839	4 vol
HS Hardener	1 vol

2. Mixing Ratio with HS Hardener as a Surfacer:

	<u>By Volume</u>
D839	4 vol
HS Hardener	1 vol
Thinner	0.5 vol

HARDENER AND THINNER SELECTION

<u>Temperature</u>	<u>HS Hardener</u>	<u>Thinner</u>
Up to 18°C	D8237 HS Express	D808 Fast Thinner
18 - 25°C	D8238 HS Fast	D866 or D807 2K Primer Thinner
25 - 35°C	D8239 HS Slow	D812 Slow Thinner
Over 35°C	D8239 HS Slow	D869 Very Slow Thinner

MIXED PRODUCT DETAILS

	Spray Filler	Surfacer
Potlife at 20°C	45 minutes	75 minutes
Spray viscosity at 20°C:	55 seconds DIN4	25 seconds DIN4



APPLICATION AND FLASH OFF



	Spray filler	Surfacer
<i>Spray gun set-up:</i>	1.8 - 2.0 mm	1.6 - 1.8 mm
<i>Number of coats:</i>	Max. 3	2 - 3
<i>Flash off at 20°C;</i> <i>- Between coats</i>	5 - 10 minutes	5 - 10 minutes
<i>- Before stoving</i>	10 minutes	10 minutes

DRYING TIMES



	Spray Filler	Surfacer
<i>Dustfree at 20°C</i>	5 minutes	5 minutes
<i>Through dry at 20°C</i>	8 hours	3 hours
<i>Through dry at 60°C*</i>	30 minutes	30 minutes
<i>Through dry IR MW</i>	30 minutes	20 minutes



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

<i>Total film build:</i>	150 - 200 µm	70 - 120 µm
<i>Theoretical coverage:</i>	1.75 m ² /l	2.5 m ² /l

Assuming 100% transfer efficiency and dry film thickness as indicated:

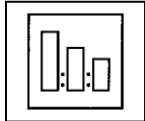
REPAIR AND RECOATING



Sanding: Essential before recoating to ensure good adhesion
P800 (wet)
P400 (dry)

Overcoat with: Deltron Progress UHS,
Envirobase Basecoat,

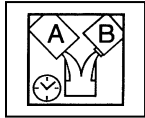




Mixing by volume

With HS Hardener -

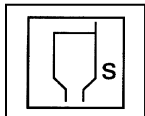
As Spray Filler 4 : 1
As Surfacer 4 : 1 : 0.5



Pot Life at 20°C with HS hardeners Spray filler - 45 minutes
Surfacer - 75 minutes

Hardener / Thinner Selection

Up to 18°C	D8237 HS Express Hardener D808 Fast thinner
18 - 25°C	D8238 HS Fast Hardener D807 Thinner or D866 Primer Thinner
25 - 35°C	D8239 HS Slow Hardener D812 Slow thinner



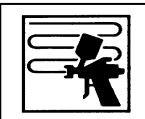
Application viscosities

55 seconds DIN4 - Spray Filler,
25 seconds DIN4 - Surfacer



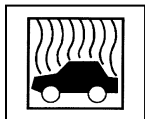
Spraygun Sizes

1.8 - 2.0 mm fluid tip - Spray Filler
1.6 - 1.8 mm fluid tip - Primer Surfacer



Number of Coats

Spray Filler - 3 maximum,
Primer Surfacer 2 - 3



Drying Times

Dust Free -

5 minutes
Through dry at 20°C - Spray Filler - 8 hours
Surfacer - 3 hours
Through dry at 60°C - Spray Filler - 30 minutes
Surfacer - 30 minutes

Dry Film Builds

Spray Filler 150 - 200 microns,
Surfacer 70 - 120 microns,



WEIGHT MIX TABLE FOR D839

WEIGHT MIXING FIGURES - as Primer Filler 4:1:					
Weights are in grams & cumulative. Do not tare the balance between additions					
Target Paint Volume (L)	0.20 L	0.40 L	0.60 L	0.80 L	1.00 L
D839	252	504	756	1008	1260
Hardener D8237 / D8238 / D8239	292	584	876	1168	1460

WEIGHT MIXING FIGURES - as Primer Surfacer 4:1:0.5					
Weights are in grams & cumulative. Do not tare the balance between additions					
Target Paint Volume (L)	0.20 L	0.40 L	0.60 L	0.80 L	1.00 L
D839	229	458	687	916	1145
Hardener D8237 / D8238 / D8239	265	531	796	1062	1327
Thinner D808/ D807/D812/D869	282	564	845	1127	1409

FLEXIBILISING

When high build is needed on flexible parts, D839 Prima can be applied on top of a plastics adhesion promoter according the following mixing ratio:

D839	4 vol
MS Hardener	1 vol
D814	1.5 vol
Thinner	0.5 vol

Maximum 2 coats.

Note: The addition of Plasticiser may lead to deterioration of the flattening and drying properties.

LIMITATIONS

Accelerators should **NOT** be used. Part used cans of hardener must be carefully closed immediately after use. All equipment must be perfectly dry. Use of RAPID GreyMatic is not recommended when humidity levels exceed 80%.

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.

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: http://www.ppg.com/PPG_MSDS

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