GLOBAL REFINISH SYSTEM

March 2012

Product Information

PLASTIC ADHESION PROMOTERS

D816 Flexible Adhesion Promoter for Plastics
D820 Plastic Adhesion Promoter
D8420 Plastic Adhesion Promoter - Aerosol

PRODUCTS

The **PPG** Plastic Painting System gives a range of products for the successful refinishing of all paintable plastic substrates*, from cleaning and preparation through to texturing and topcoating.

D820 Plastic Adhesion Promoter is a fast, transparent 1 pack primer suitable for use on the vast majority if paintable plastic substrates and avoids the need to identify the plastic prior to spraying.

D8420 Plastic Adhesion Promoter - Aerosol, is a fast, 1 pack primer in an aerosol. It is suitable for use on the vast majority of paintable plastic substrates avoiding the need to identify the substrate before spraying, and is designed for priming spot repairs or small components.

D816 Flexible Adhesion Promoter for Plastics, is a ready for use, flexible, pigmented adhesion promoter for use over solvent sensitive substrates such as 1K PUR plastic.

Thorough preparation and cleaning are essential for the successful refinishing of plastic parts. The **PPG** plastic cleaning and preparation system is designed to produce the best performance from the adhesion promoter, undercoat and topcoat systems.

Refer to the Cleaning and Preparation of Plastic Substrates PDS RLD241V.

*** Note: These adhesion promoters are not suitable for use on Polystyrene (PS), or on pure PE, which is considered un-paintable.**

PREPARATION OF SUBSTRATE

If the plastic surface appears inconsistent, it is recommended that the part be "flamed" or pre-stoved for 30 minutes at 60°c.

Substrate	***Sand***
GRP, Fibre glass	P320 (dry)
Other plastics (new part)	Fine sanding pad
Other plastics (light damage)	P320 -P400 (dry)
Polyester filler (A652)	P400 (dry)
Pinhole filler (A655)	P400 (dry)

Prior and after any sanding operation, the substrate must be thoroughly degreased with Deltron D846.

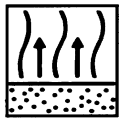
Before the adhesion promoter application, D846 may be used sprayed on the panel and allowed to evaporate in order to avoid any static electricity effect.

MIXING RATIO

D816 & D820 are supplied ready for use, no thinning required. Stir D816 thoroughly before use.

D8420 is ready to spray from the aerosol. Shake to dislodge the ball bearing & then shake for 2 minutes prior to use.

APPLICATION, FLASH-OFF AND DRYING



	D816	***D820***
Spraygun set-up:	1.3 - 1.6 mm	1.3 - 1.6 mm D8420 - Shake the aerosol can to mix the contents thoroughly (approx 2 minutes), until the mixing pellets can be heard.
Number of coats:	2	1 - 2
Flash-off at 20°C:		
- Between coats	5 - 10 minutes	n/a
- Before topcoating	40 minutes	30 minutes – D820 20 minutes – D8420
Total dry film build:	15 - 25 µm	3 - 7 µm

REPAIR AND RECOATING

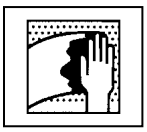
Sanding: Not necessary in normal use.

Overcoat with: Deltron topcoats*
Envirobase*

* Failure to observe the recommended flash time before topcoat may result in adhesion failure.

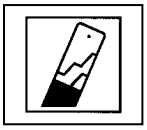
Global at a Glance D816/D820/D8420

PLASTIC ADHESION PROMOTERS



Prior and after any sanding operation, the substrate must be thoroughly cleaned using D846 Antistatic Agent.

If the plastic surface appears to be inconsistent, it is recommended that the part be "flamed" or pre - stoved at 60°C for 30 minutes.



D816 and D820 are supplied "Ready for Use" so no mixing is required.
D816 should be thoroughly stirred before use.
D8420 is supplied in an aerosol - dislodge the ball bearing and shake for 2 minutes before use.

D816 / D820 1.3 - 1.6 mm Fluid Tip

D8420 is supplied in an aerosol - shake can thoroughly for 2 minutes After ball bearing is released.

Number of coats

D816 - 2 coats with 5 - 10 minutes flash off between coats.
D820 : D8420 - 1 to 2 coats

Flash off before topcoating / overcoating

D816 - 40 minutes before topcoating / overcoating
D820 - 30 minutes before topcoating / overcoating
D8420 - 20 minutes before topcoating / overcoating

Dry Film Thickness

D816	15 - 25 microns
D820 / D8420	3 - 7 microns

PERFORMANCE AND LIMITATIONS

It is necessary to shake the plastic adhesion promoter can a few seconds before use.

When higher build is necessary, D839 flexibilised or D8023 flexibilised (see relevant individual technical datasheet for details) may be used on top of the plastic adhesion promoters.

AEROSOL CAN DISPOSAL

When aerosol is empty, turn it upside down and press the nozzle until all propellant is exhausted. Place empty can or cans that will no longer be used into properly labeled metal containers. The waste containers should be managed as a hazardous waste according to legislation.

EQUIPMENT CLEANING

After use, clean all equipment thoroughly with cleaning solvent or thinner.

VOC INFORMATION

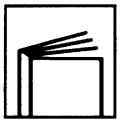
D8420 Aerosol

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.

D816/D820

This product falls outside of the scope of EU Directive 2004/42 and therefore does not have a VOC product category classification.
This product can be used by professional motor vehicle repairers.

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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