



GLOBAL REFINISH
SYSTEM



May 2012

Product Information

Deltron D894

High Solids Clear

PRODUCTS

Deltron HS Clear	D894
Deltron HS Hardeners	D897, D8208
Deltron MS Hardener	D803, D841, D861, D864
Deltron Thinners	D808, D807, D812, D869
Deltron DG Fadeout Thinner	D868
Deltron Accelerator	D818

For textured finishes or painting of flexible substrates:

Deltron Matt Flexibiliser	D819 for textured appearance over a flexible substrate
Deltron Texture Additive	D843 to create a fine textured 'suede' effect
Deltron Leather Grain Additive	D844 to create a coarser, more pronounced textured finish

PRODUCT DESCRIPTION

Deltron High Solids Clear is a 2K acrylic urethane clearcoat. It is designed for use on original finishes with clearcoat over a single or multistage colour basecoat system.

Deltron High Solids Clear is designed for use over Deltron BC or Envirobase colour.

The performance of Deltron High Solids Clear in a recommended PPG system meets or exceeds warranty requirements.

Deltron High Solids Clear offers:

- savings in materials consumption and process time compared to conventional clearcoats;
- low ready-for-use VOC content.

PREPARATION OF SUBSTRATE

Deltron D894 Clear must be applied on top of a clean and dust free Deltron Basecoat or Envirobase.

The use of a tack rag is recommended to remove dust from the Basecoat or Envirobase film.

These products are for professional use only.

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MIXING RATIOS

1. Mixing Ratios with MS Hardeners

	<u>By Volume</u>
D894	2 parts
MS Hardener	1 part
Thinner	1 part

2. Mixing Ratios with HS Hardeners: D897 / D8208*

	<u>By Volume</u>
D894	4 parts
HS Hardener*	1 part
Thinner*	0,5 parts

**Choose Hardener and Thinner according to application temperature and system*

HARDENER AND THINNER SELECTION

<u>Temperature</u>	<u>MS Hardener</u>	<u>Thinner</u>	<u>HS Hardener</u>	<u>Thinner</u>
Up to 18°C	D803	D808	D8208	D808
18°C - 25°C	D841	D807	D897	D807
Over 25°C	D861	D812**	D897	D812**

*** For exceptional conditions of temperature and humidity (> 35°C / >70%) the use of Very Slow Thinner D869 is recommended*

MIXED PRODUCT DETAILS

Potlife at 20°C:

3.5 - 4 hours

Spray viscosity at 20°C:

16 - 19 seconds DIN4

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APPLICATION AND FLASH OFF

Spraygun set-up:

1.3 - 1.6 mm



MS System	HS System
1 medium coat	1 mist coat
↓	↓
10 min flash-off	no flash-off
↓	↓
1 full coat	1 full coat
↓	↓
5 - 10 min flash-off	no flash-off
↓	↓
Low-bake / IR / airdry	Low-bake / IR / airdry

DRYING TIMES



Drying times: ***

- Dust free at 20 °C 30 - 40 minutes
- Through dry at 20 °C Overnight
- Through dry at 70°C 30 minutes



- Through dry at IR Medium 10 minutes
(dependent on colour of basecoat – darker colours require less time)

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

Drying times may be reduced still further by adding 10ml or 10gms of D818 Accelerator per litre of ready to spray clear.

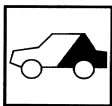
Total dry film build: 50 - 60 µm

Theoretical coverage: 7 m²/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 - P500 (dry)



Overcoat / recoat time:

- Force dry 60°C, 70°C or IR After cooling
- Airdry at 20°C Minimum 12 hours

Overcoat with: PPG 2K Primers, Envirobase, Deltron GRS Topcoats

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PAINTING OF PLASTIC SUBSTRATES - TEXTURED FINISHES

To obtain a textured finish with Deltron D894 HS clear, it is necessary to include flex or texture additives in the mix. Additives are also required when applying D894 over a flexible substrate (typically plastics). The additives required and the appropriate volume and 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.

Note : **Do not use HS hardeners textured finish.**

Substrate	Appearance	D894	D843	D844	D819	MS Hardeners	Thinner
RIGID	Matt Textured	229g	578g	-	-	661g	941g
	Leather Grain	347g	-	606g	-	700g	939g
FLEXIBLE	Matt Textured	191g	482g	-	586g	689g	952g
	Leather Grain	272g	-	476g	625g	772g	960g

SPOT REPAIR PROCEDURE

- Apply Deltron D894 HS Clear according to the 'Application, Flash-Off and Drying' section above.
- Leave to flash-off for 10 minutes/20°C after the 2nd coat.
- A suitable quantity of activated and thinned D894 HS Clear should then be reduced with Deltron DG Fade-Out Thinner D868 at a ratio of 1:3 (1 part activated and thinned Clear to 3 parts D868).
- Apply this 1:3 mix over the repair area, using a reduced gun pressure to minimize overspray. Spray from the outside of the repair inwards, covering an area that extends beyond the edge of the initial application.
- If necessary, repeat the previous step using D868 neat.
- After force dry or IR, buff the repair edges.

POLISHING

*Low bake or IR force
drying:*

Minimum 1 hour after cooling

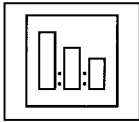
Air drying at 20°C:

Minimum 24 hours after application

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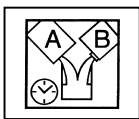
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Mixing by volume

With MS Hardener	2:1:1
With HS Hardeners D897/ 8208	4:1:0,5



Pot Life at 20°C with MS hardener 3,5 -4 Hours

Pot Life at 20°C with D 897 HS hardener 1 Hours

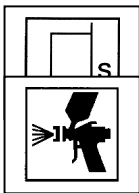
Hardener / Thinner Selection

Up to 18°C D803 MS Hardener D808 Fast thinner
 D8208 HS hardener D808 Fast thinner

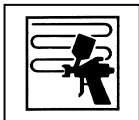
18 - 25°C D841 MS Hardener D807 Thinner
 D897 HS Hardener D807 Thinner

Over 25°C D841 MS Hardener D812 Slow thinner
 D897 HS Hardener D812 Slow thinner

For exceptional conditions of Temperature and humidity (above 35°C or 70% RH) the use of D869 Very Slow thinner is recommended.



Application viscosity 16 - 19 seconds DIN4



Spraygun Size 1.3 - 1.6 mm fluid tip



Number of Coats
 MS System - 1 medium coat, 5 minute flash off, followed by 1 full coat
 HS System - 1 light coat, immediately followed by 1 full coat

Drying Times

10 minutes flash off before stoving for MS system, No flash off for HS system
 Dust Free - 30 - 40 minutes
 Through dry at 20°C - 16 hours Through dry at 70°C - 30 minutes

EQUIPMENT CLEANING

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

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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