



GLOBAL REFINISH  
SYSTEM



March 2011

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# Product Information

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PRIMA D839

*2 Component Primer*

## 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, or as a wet-on-wet surfacer. Prima may be air dried, low baked or IR cured.

Prima may be applied directly to sound original paintwork, bare steel, polyester bodyfillers and suitable adhesion primers. It may be directly overcoated with 2K topcoat materials such as Deltron BC, Deltron DG or Envirobase.

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## PREPARATION OF SUBSTRATE



### ***Substrate***

Bare steel  
Galvanised steel  
Zintec  
Aluminium and alloys  
Electropaint  
Aged painted surfaces  
GRP , Fiber-Glass  
Polyester filler

### ***Preparation***

Must be pre-primed (e.g. D831, D834)  
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P360 (dry)/P800(wet)  
P400 - 500 (dry)/P280 - 320 (wet)  
P320 (dry)  
P240 (high-build version)/  
P400 (wet-on-wet)

These products are for professional use only.

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

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

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## MIXING RATIO

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

	<u>By Volume</u>
D839	5 vol
MS Hardener	1 vol

2. Mixing Ratio with MS Hardener as a surfacer:

	<u>By Volume</u>
D839	5 vol
MS Hardener	1 vol
Thinner	1 vol

3. Mixing Ratios with MS Hardener – Wet on Wet:

	<u>By Volume</u>
D839	5 vol
MS Hardener	1 vol
Thinner	2.5 vol

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## HARDENER AND THINNER SELECTION

<u>Temperature</u>	<u>MS Hardener</u>	<u>Thinner</u>
Up to 18°C	D803 MS Fast	D808 Fast Thinner
18 - 25°C	D841 MS Medium	D866 or D807 2K Primer Thinner
25 - 35°C	D861 MS Slow	D812 Slow Thinner
Over 35°C	D861 MS Slow	D869 Very Slow Thinner

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## MIXED PRODUCT DETAILS



	<i>Spray filler</i>	<i>Surfacer</i>	<i>Wet-on-wet</i>
Potlife at 20°C:	20 minutes	45 minutes	1 hour
Spray viscosity at 20°C:	60 seconds DIN4	25 seconds DIN4	15 seconds DIN4

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## APPLICATION AND FLASH OFF

	<b>Spray filler</b>	<b>Surfacer</b>	<b>Wet-on-wet</b>
 <i>Spray gun set-up:</i>	1.8 - 2.0 mm	1.6 - 1.8 mm	1.6 - 1.8 mm
<i>Number of coats:</i>	Max. 4	2 - 3	1 - 2
 <i>Flash-off at 20°C:</i>			
- <i>Between coats</i>	5 - 10 minutes	5 - 10 minutes	10 minutes
- <i>Before stoving</i>		10 minutes	
- <i>Before topcoating</i>			15 minutes

## DRYING TIMES

	<b>Spray filler</b>	<b>Surfacer</b>	<b>Wet-on-wet</b>
 - Dustfree at 20°C			
- Through dry at 20°C	5 minutes	5 minutes	
 - <i>Through dry at 60°C*</i>	4 hours	2 hours	2 hours (sandable)
- <i>Through dry IR medium</i>	Do not force dry	30 minutes	
	Do not force dry	20 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>	200 - 270 µm	100 - 150 µm	35 - 50 µm
<i>Theoretical coverage:</i>	Assuming 100% transfer efficiency and dry film thickness as indicated:		
	1.75 m <sup>2</sup> /l	2.5 m <sup>2</sup> /l	6 m <sup>2</sup> /l

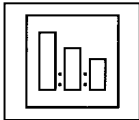
## REPAIR AND RECOATING

 <i>Sanding:</i>	Essential before recoating to ensure good adhesion P800 (wet) P400 (dry)
<i>Overcoat with:</i>	Deltron DG, Deltron BC, Envirobase

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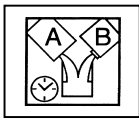
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### Mixing by volume

With MS Hardener -

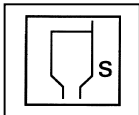
As Spray Filler	5 : 1
As Surfacer	5 : 1 : 1
As Wet on Wet	5 : 1 : 2.5
As Wet on Wet (optimum gloss)	1 : 1 : 1 : 1



Pot Life at 20°C with MS hardeners 20 minutes as Spray filler,  
45 minutes as Primer Filler  
60 minutes as Wet on Wet

### Hardener / Thinner Selection

Up to 18°C	D803 MS Fast Hardener D808 Fast thinner
18 - 25°C	D841 MS Hardener D807 Thinner or D866 Primer Thinner
25 - 35°C	D861 MS Slow Hardener D812 Slow thinner



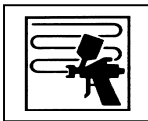
### Application viscosities

60 seconds DIN4 - Spray Filler,  
25 seconds DIN4 - Surfacer  
15 seconds DIN4 - Wet on Wet



### Spraygun Sizes

1.8 - 2.0 mm fluid tip - Spray Filler  
1.6 - 1.8 mm fluid tip - Primer Surfacer/ Wet on Wet



### Number of Coats

Spray Filler - 4 Maximum  
Primer Surfacer 2 - 3  
Wet on Wet 1 - 2



### Drying Times

Dust Free - 5 minutes  
Through dry at 20°C - 4 hours Spray Filler, 2 hours Surfacer  
Through dry at 60°C - Surfacer - 30 minutes  
Spray Filler - DO NOT force dry

### Dry Film Builds

Spray Filler	200 - 275 microns
Surfacer	100 - 150 microns,
Wet on Wet	35 - 50 microns

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## PERFORMANCE AND LIMITATIONS



5:1 ratio can be changed to 4:1 for optimum adhesion on bare steel.

D839 Prima may be tinted, prior to addition of hardener and thinner, with up to 10% by volume of Deltron DG.

For small repairs at low temperatures (up to 18°C) Prima can be mixed 4:1:1 using D863 Accelerated Hardener.

An "extra gloss" option for the wet-on-wet application is possible with the following mixing ratio:

D839	1 vol
D800/DG	1 vol
MS Hardener	1 vol
Thinner	1 vol

Overcoat after 20 minutes flash-off.

When using Prima D839 as a wet-on-wet surfacer, it is important to use the same hardener in both wet-on-wet surfacer and subsequent Deltron topcoat.

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

D839	4 vol
MS Hardener	1.5 vol
D814	1 vol
D807	0.5 vol

Maximum 2 coats.

Wet-on-Wet mode on flexible parts

D839	4 vol
MS Hardener	1.5 vol
D814	1 vol
D807	1.5 vol

1 – 2 coats.

**Note: The use of D814 will prolong flash off and drying times**

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## EQUIPMENT CLEANING

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

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



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