



GLOBAL REFINISH  
SYSTEM



Feb 2016

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# Product Information



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GRS Deltron Matt Textured Clearcoat System

D8117 Semi Gloss Clearcoat  
D843 Texture Base

## PRODUCTS

Deltron Semi Gloss Clearcoat	D8117
Deltron UHS Express Clearcoat	D8135
Deltron HS Hardeners	D8302
Deltron Texture Additive	D843 to create a fine textured 'suede' effect
Deltron Low VOC Thinners	D8718, D8719, D8720

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## PRODUCT DESCRIPTION

The Clearcoat D8117 (Semi-Gloss) are designed for use over ENVIROBASE<sup>®</sup> High Performance.

Deltron Matt Textured Clearcoat System consists of two versatile 2K acrylic urethane clearcoats and a texture additive designed to reproduce a range of low gloss levels and texture for the specialised repairs of vehicles or areas of vehicles originally finished with a low gloss textured clearcoat over a single or multistage colour basecoat system (e.g. Peugeot full body Matt textured system). The Matt Textured blend may be used over rigid plastics without the need for special additives.

The D8117 & D843 Blends can be used with Deltron HS hardener D8302.



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## PREPARATION OF SUBSTRATE

When masking a repair, care should be taken to minimize direct contact of masking tape onto the original Matt finish. Where it is necessary to use masking tape directly on the original finish, the tape must be removed before baking to avoid marking of the original which may not recover.

The Deltron D8117 / D843 Blends must be applied on top of a clean and dust-free basecoat. The light use of a tack cloth is recommended after the basecoat has flashed off.

Care should be taken to avoid dirt inclusion at all stages. Rectification of dirt inclusion in Textured finishes is not possible after the final coat of clearcoat.

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## D8117 / D843 MIX RATIOS

To allow for normal variations in the gloss level, depending on colour, model, position of repair on vehicle, it is possible to mix the D8115 and D8117 together in any ratio to match the required gloss for a particular repair. The weight % ratio's quoted below are the best start point for the 5 gloss level ranges.

Texture Level	T01	T02	T03	T04	T05
Clearcoat	Parts by Weight				
<b>D8117</b>	3	3.5	4	4.5	5
<b>D843</b>	3	2.5	2	1.5	1

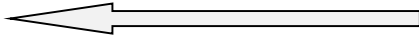
The resulting mix is then activated and thinned as below.

**Note: Test panels MUST be produced using the intended hardener/thinner/ratio/spraygun combination to check for colour, gloss level and texture against the vehicle to be repaired. D8718 Thinner is recommended to only be used on small areas or components (Mirror covers, wheel arches etc.)**

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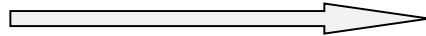
## \* HARDENER / THINNER / MIX RATIO SELECTION

Smaller areas / Verticals / Higher Gloss  
Below 25°C  
Smaller Spraygun tip size



Faster Hardener/Thinner

Larger Areas / Horizontals / Lower Gloss  
Above 25°C  
Larger Spraygun tip size



Slower Hardener/Thinner



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## MIXING RATIO

Mixing ratios with HS Hardener D8302

	More texture less Gloss				Less texture More Gloss
D8117	3	3.5	4	4.5	5
D843	3	2.5	2	1.5	1
D8302	1	1	1	1	1
D8718/9/20	4	4	4	4	4

If coarser texture is required it is possible to blend with D844  
If lower gloss is required it is possible to blend D8117 with D8115  
**Always do spray out cards to test the match to a vehicle**

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## MIXED PRODUCT DETAILS

Potlife at 20°C: 1 - 2 hours depending on hardener/thinner  
Spray viscosity at 20°C 15-16 seconds DIN4.

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## APPLICATION AND FLASH-OFF

*Initially 1 coat of D8135 activated with D8302 / D8718 will need to be applied to the whole panel. This should be baked for 15 mins and allowed to cool before application of the Matt / Textured coating. Please refer to the D8135 TDS for activation and application information.*



*Spraygun set-up:*

1.4 mm

*Application* 1 Full single coat  
Flash off until evenly Matt all over  
+  
1 Full single coat followed immediately by a lighter  
(½ coat) cross coat.  
Flash off until evenly Matt all over before baking.

*Flash off between spray coats* 10 - 15 minutes or until fully and evenly matt over the whole repair area.\*

*Flash off before bake or IR dry* 15 - 20 minutes or until fully and evenly matt over the whole repair area.\*



**\*Note:** Allowing the Clearcoat Mix to flash off fully between coats and before bake is important to achieve an even appearance and gloss level over the whole area.  
The actual flash off times will depend on the hardener/thinner combination required to achieve the correct gloss effect and could vary between 15 – 30 minutes.

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## DRYING TIMES

Through dry at 60°C\*

40 minutes with D8302



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

Total dry film build:

45 – 55 µm

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## REPAIR AND RECOATING



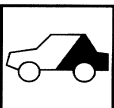
*Sanding:*

Essential before recoating to ensure good adhesion

- *grade wet*
- *grade dry*

P800  
P400 - P500

*Overcoat / Re-coat time:*



- *Force dry at 60°C, or IR*
- *Air drying at 20°C*

After cooling  
12 hours

*Overcoat with:*

Deltron primers  
Envirobase High Performance  
Deltron topcoats



## WEIGHT MIX TABLES FOR D8117 / D843

### GUIDELINES FOR WEIGHT MIXING

Where a specific volume of clearcoat mix is required, this may be best achieved by weight mixing, using the guidelines below. The weights are cumulative - please do **NOT** tare the balance between additions.

Target Volume of RFU Paint required (Litres) @ 3/3/1/4	Weight Clearcoat D8117	Weight Texture Additive D843	Weight HS Hardener D8239	Weight Thinner D8718/9/20
<b>DO NOT TARE THE SCALE BETWEEN ADDITIONS</b>				
0.10 L	29g	57g	67g	95g
0.25 L	74g	143g	168g	238g
0.50 L	147g	286g	336g	476g
0.75 L	221g	429g	504g	714g
1.00 L	294g	571g	672g	952g

Target Volume of RFU Paint required (Litres) @ 3.5/2.5/1/4	Weight Clearcoat D8117	Weight Texture Additive D843	Weight HS Hardener D8239	Weight Thinner D8718/9/20
<b>DO NOT TARE THE SCALE BETWEEN ADDITIONS</b>				
0.10 L	33g	55g	64g	95g
0.25 L	82g	137g	161g	238g
0.50 L	164g	274g	322g	475g
0.75 L	221g	429g	539g	738g
1.00 L	328g	548g	645g	950g

Target Volume of RFU Paint required (Litres) @ 4/2/1/4	Weight Clearcoat D8117	Weight Texture Additive D843	Weight HS Hardener D8239	Weight Thinner D8718/9/20
<b>DO NOT TARE THE SCALE BETWEEN ADDITIONS</b>				
0.10 L	37g	55g	65g	95g
0.25 L	94g	138g	162g	238g
0.50 L	187g	275g	324g	476g
0.75 L	281g	413g	485g	715g
1.00 L	375g	551g	647g	953g



Target Volume of RFU Paint required (Litres) @ 4.5/1.5/1/4	Weight Clearcoat D8117	Weight Texture Additive D843	Weight HS Hardener D8239	Weight Thinner D8718/9/20
<b>DO NOT TARE THE SCALE BETWEEN ADDITIONS</b>				
0.10 L	42g	55g	65g	96g
0.25 L	105g	138g	163g	239g
0.50 L	211g	277g	325g	478g
0.75 L	316g	415g	488g	717g
1.00 L	421g	554g	650g	955g

Target Volume of RFU Paint required (Litres) @ 5/1/1/4	Weight Clearcoat D8117	Weight Texture Additive D843	Weight HS Hardener D8239	Weight Thinner D8718/9/20
<b>DO NOT TARE THE SCALE BETWEEN ADDITIONS</b>				
0.10 L	47g	56g	65g	96g
0.25 L	117g	139g	163g	240g
0.50 L	234g	278g	326g	479g
0.75 L	351g	417g	490g	719g
1.00 L	468g	556g	653g	958g

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## PERFORMANCE AND LIMITATIONS

The Gloss levels and texture achieved with this process may vary depending upon film thickness and application. Low film thickness and dry application will give a Lower Gloss and more texture. High film thickness and wet application will give a higher gloss level and will hide some of the texture.

Care should be taken to avoid too high clearcoat film thicknesses because the final colour could be affected. In this situation, the repair will require sanding and recoating with Basecoat and Clearcoat.

Dirt removal from the final Matt Textured Finish is not possible.

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## EQUIPMENT CLEANING

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



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## GENERAL CARE AND MAINTENANCE OF MATT TEXTURED FINISHES

The following guidance on Care and Cleaning of matt finish vehicles is aimed at the car owner, and applies to both the OE and the repair finish. Particular care must be taken with Matt Finishes to maintain an original even Matt effect.

### Guidance for the car owner on maintaining the even matt effect over time

Matt/Gloss finishes can be relatively easily marked with general handling and day to day use (door/bonnet/boot opening, shoe scuffing on entry or exit of vehicle etc.). Care should be taken with these operations because marking or changing of the Matt effect could result.

Care should be taken to avoid spillage of fuel onto the Matt/Low Gloss finishes. Spilt fuel should be removed as soon as possible using the washing guidelines below, to avoid permanent damage or altering of the Matt/Low Gloss effect.

1. In order to keep the Matt surface effect, the use of paint cleaner, abrasives or polishes and wax polishes **must** be avoided. The vehicle **must** not be polished.
2. Polishing will lead to a higher, uneven gloss effect.
3. Cleaning/Polishing with unsuitable materials could alter the Matt effect (generally increased gloss).
4. Automated car washing machines should be avoided. The preferred car washing method is by hand with a soft sponge, neutral soap and lots of water. Too frequent car washing could over a period of time lead to increased and inconsistent gloss levels across a car panel. Washing under direct sunlight should be avoided.
5. Insects and bird residues should be removed immediately. The residues should be soaked in water to soften and/or removed carefully with a high pressure cleaning equipment. In the case of strongly adhered residues, a spray on insect remover should be used prior to washing.
6. Whenever using any type of cleaning fluids with soft sponges or cloths, it is essential not to apply pressure or rub the Matt finish. A gentle wipe/spray on, wipe off technique should be used. Applying pressure will alter the Matt effect and result in an uneven appearance.



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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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