



GLOBAL REFINISH
SYSTEM



Feb 2016

Product Information



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 | D8239 |
| Deltron Texture Additive | D843 to create a fine textured 'suede' effect |
| Deltron Low VOC Thinners | D8718, D8719, D8720 |

PRODUCT DESCRIPTION

The Clearcoat D8117 (Semi-Gloss) are designed for use over ENVIROBASE[®] 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 D8239.



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.

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.

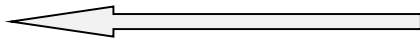
| Texture Level | T01 | T02 | T03 | T04 | T05 |
|---------------|-----------------|-----|-----|-----|-----|
| Clearcoat | Parts by Weight | | | | |
| D8117 | 2 | 2.3 | 2.7 | 3 | 3.3 |
| D843 | 2 | 1.7 | 1.3 | 1 | 0.7 |

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.)

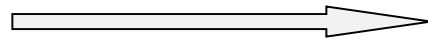
* HARDENER / THINNER / MIX RATIO SELECTION

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



MIXING RATIO

Mixing ratios with HS Hardener D8239

| | More texture less Gloss | | | | Less texture More Gloss |
|------------|----------------------------|-----|-----|---|----------------------------|
| D8117 | 2 | 2.3 | 2.7 | 3 | 3.3 |
| D843 | 2 | 1.7 | 1.3 | 1 | 0.7 |
| D8302 | 1 | 1 | 1 | 1 | 1 |
| D8718/9/20 | 2 | 2 | 2 | 2 | 2 |

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

MIXED PRODUCT DETAILS

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

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.

DRYING TIMES

Through dry at 60°C*

40 minutes with D8239



*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

REPAIR AND RECOATING



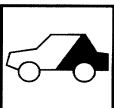
Sanding:

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) @ 2/2/1/2 | Weight Clearcoat D8117 | Weight Texture Additive D843 | Weight HS Hardener D8239 | Weight Thinner D8718/9/20 |
|--|------------------------|------------------------------|--------------------------|---------------------------|
| DO NOT TARE THE SCALE BETWEEN ADDITIONS | | | | |
| 0.10 L | 29g | 57g | 72g | 96g |
| 0.25 L | 74g | 143g | 180g | 240g |
| 0.50 L | 147g | 286g | 359g | 479g |
| 0.75 L | 221g | 429g | 539g | 719g |
| 1.00 L | 294g | 571g | 719g | 959g |

| Target Volume of RFU Paint required (Litres) @ 2.3/1.7/1/2 | Weight Clearcoat D8117 | Weight Texture Additive D843 | Weight HS Hardener D8239 | Weight Thinner D8718/9/20 |
|--|------------------------|------------------------------|--------------------------|---------------------------|
| DO NOT TARE THE SCALE BETWEEN ADDITIONS | | | | |
| 0.10 L | 34g | 57g | 72g | 96g |
| 0.25 L | 85g | 144g | 180g | 240g |
| 0.50 L | 169g | 287g | 361g | 481g |
| 0.75 L | 254g | 431g | 541g | 721g |
| 1.00 L | 338g | 574g | 721g | 961g |

| Target Volume of RFU Paint required (Litres) @ 2.7/1.3/1/2 | Weight Clearcoat D8117 | Weight Texture Additive D843 | Weight HS Hardener D8239 | Weight Thinner D8718/9/20 |
|--|------------------------|------------------------------|--------------------------|---------------------------|
| DO NOT TARE THE SCALE BETWEEN ADDITIONS | | | | |
| 0.10 L | 40g | 58g | 72g | 96g |
| 0.25 L | 99g | 144g | 181g | 241g |
| 0.50 L | 199g | 289g | 362g | 482g |
| 0.75 L | 298g | 433g | 543 g | 723g |
| 1.00 L | 397g | 577g | 725g | 965g |



| Target Volume of RFU Paint required (Litres) @ 3/1/1/2 | Weight Clearcoat D8117 | Weight Texture Additive D843 | Weight HS Hardener D8239 | Weight Thinner D8718/9/20 |
|--|------------------------|------------------------------|--------------------------|---------------------------|
| DO NOT TARE THE SCALE BETWEEN ADDITIONS | | | | |
| 0.10 L | 44g | 55g | 73g | 97g |
| 0.25 L | 110g | 145g | 182g | 242g |
| 0.50 L | 221g | 290g | 364g | 484g |
| 0.75 L | 331g | 435g | 545g | 725g |
| 1.00 L | 441g | 580g | 727g | 967g |

| Target Volume of RFU Paint required (Litres) @ 3.3/0.7/1/2 | Weight Clearcoat D8117 | Weight Texture Additive D843 | Weight HS Hardener D8239 | Weight Thinner D8718/9/20 |
|--|------------------------|------------------------------|--------------------------|---------------------------|
| DO NOT TARE THE SCALE BETWEEN ADDITIONS | | | | |
| 0.10 L | 49g | 58g | 73g | 97g |
| 0.25 L | 121g | 146g | 182g | 242g |
| 0.50 L | 243g | 291g | 365g | 485g |
| 0.75 L | 364g | 437g | 547g | 727g |
| 1.00 L | 486g | 583g | 730g | 970g |

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.

EQUIPMENT CLEANING

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



GENERAL CARE AND MAINTENANCE OF MATT TEXTURED FINISHES

The following guidance on Care and Cleaning of matt textured 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 Textured Finishes to maintain an original even Matt Textured effect.

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

Matt/Textured 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/Textured 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 Textured 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 Textured 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.



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.

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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