



GLOBAL REFINISH  
SYSTEM



July 2014

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# Product Information



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**GRS DELTRON® D8122 CERAMICLEAR™ 8122**

*CeramiClear 8122 Clear*

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## PRODUCTS

<i>Deltron CeramiClear 8122 Clear</i>	D8122
<i>Deltron HS Hardeners</i>	D897 / D8208
<i>Deltron Thinners</i>	D808/D807/D812/D869, D8717/D8718/D8719/D8720
<i>Deltron Catalyst Thinner</i>	D8714

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## PRODUCT DESCRIPTION

*Deltron CeramiClear 8122*, is a 2K acrylic urethane Clearcoat, for the repair and repainting of original *CeramiClear* Clearcoat, over a single or multistage colour basecoat system. D8122 contains the *CeramiClear* technology that gives excellent scratch resistance.

D8122 is designed for use over ENVIROBASE® High Performance Basecoat.

*Deltron CeramiClear 8122* has an organic solvent content lower than conventional clearcoats. This makes it particularly suitable for use in areas where VOC emissions or product VOC content is restricted and productivity is an issue.

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## PREPARATION OF SUBSTRATE

*Deltron D8122 CeramiClear 8122*, must be applied on top of a clean and dust free basecoat. The use of a tack rag is recommended.

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## MIXING RATIOS

Mixing ratios with HS Hardeners (by volume)	D8122	3
	HS Hardener*	1
	Thinner*	0.5

As with all ultra high solids products, cold ready for use paint temperatures can lead to more difficult application and overspray absorption. It is strongly recommended that ready for use product is applied at a temperature greater than 15°C

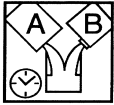
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## \*HARDENER AND THINNER SELECTION

Choose HS hardener and thinner according to application temperature:

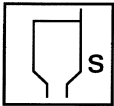
<i>Temperature</i>	<i>HS Hardener</i>	<i>Thinner</i>
Up to 18°C	D8208	D808
18°C - 25°C	D897	D807//D8717/D8718
Over 25°C	D897	D812/D8719

For exceptional conditions of temperature and humidity (over 35°C / Over 70%RH) the use of D869 Very Slow or D8720 Extra Slow thinner is recommended. Use HS Hardener D8208 / D808 for Spot Repairs.



Pot Life at 20°C

1 hour with D897 hardener  
30 min. with D897 hardener and D8714 Catalyst Thinner



Application Viscosity

19 - 21 seconds / DIN4 / 20°C

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## APPLICATION AND FLASH OFF



*Spraygun set-up:*

1.3 - 1.6 mm

### **Conventional Two Coat Process**

*Application*

Apply 2 single coats to give 50-60 microns dry film build.

*Flash off between spray coats*  
*Flash off before bake or IR dry*

10 minutes  
5 – 10 minutes

### **Express Single Visit Process**

*Application*

Apply 1 medium & 1 full coat to give 45-50 microns dry film build.

*Flash off between spray coats*

The first coat should be applied to all repair panels before the second coat is applied.

*Flash off before bake or IR dry*

For less than 3 panels, 2-3 minutes  
For more than 3 panels, no flash off is required.  
5 – 10 minutes



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## DRYING TIMES



Dust Free at 20°C	20 - 25 minutes
Dry to handle at 20°C	6 hours
Through dry at 20°C	24 hours
Through dry at 60°C	30 - 40 minutes
Through dry with IR (medium)	15 minutes ( IR drying is colour dependant)

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

Drying times may be reduced by using D8714 Catalyst Thinner together with D897 Hardener.

Total Dry Film Thickness 50 - 60 microns

Theoretical coverage 8 m<sup>2</sup>/l - Assuming 100% transfer efficiency

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## REPAIR AND RECOATING

*Sanding:* Essential before recoating to ensure good adhesion

- *Grade wet* P800  
- *Grade dry* P400

*Overcoating / Re-Coat time*

- *After force drying / IR* After Cooling  
- *Air Drying at 20°C* Minimum 12 hours  
*Overcoat with:* PPG 2K Primers, *Envirobase* High Performance, *Deltron* GRS Topcoats

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## SPOT REPAIR PROCEDURES

- Apply GRS *Deltron* D8122 *CeramiClear* according to the 'Application, Flash-Off and Drying' section above.
  - Take care to minimise the clearcoat edge in the fade-out area using spraygun technique.
  - Melt overspray edge using D8731 **Aerosol Spot Blender** or D8430 **Spot Blender**.
  - Refer to datasheet No: **RLD 299V** for successful repair.
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## POLISHING

Low Bake or IR drying Minimum 1 hour after cooling  
Air Drying at 20°C Minimum 12 hours after application

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## WEIGHT MIX TABLE FOR D8122 (using D808/D807/D812/D869 Thinners)

<b>GUIDELINES FOR WEIGHT MIXING</b>			
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 <b>NOT</b> tare the balance between additions.			
Target Volume of RFU Paint required (Litres)	Weight Clearcoat D8122	Weight UHS Hardener D8208/D897	Weight Thinner
0.10 L	66 g	90 g	100 g
0.20 L	133 g	181 g	200 g
0.25 L	166 g	226 g	250 g
0.33 L	219 g	298 g	330 g
0.50 L	332 g	451 g	500 g
0.75 L	499 g	677 g	750 g
1.00 L	665 g	903 g	1000 g
1.50 L	997 g	1354 g	1500 g
2.00 L	1329 g	1805 g	2000 g
2.50 L	1662 g	2257 g	2500 g

## WEIGHT MIX TABLE FOR D8122 (using D8717/18/19/20 Thinners)

<b>GUIDELINES FOR WEIGHT MIXING</b>			
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 <b>NOT</b> tare the balance between additions.			
Target Volume of RFU Paint required (Litres)	Weight Clearcoat D8122	Weight UHS Hardener D8208/D897	Weight Thinner D8717/18/19/20
0.10 L	66 g	90 g	99 g
0.20 L	133 g	181 g	199 g
0.25 L	166 g	226 g	248 g
0.33 L	219 g	298 g	328 g
0.50 L	332 g	451 g	497 g
0.75 L	499 g	677 g	745 g
1.00 L	665 g	903 g	994 g
1.50 L	997 g	1354 g	1491 g
2.00 L	1329 g	1805 g	1988 g
2.50 L	1662 g	2257 g	2484 g

## ACCELERATED THINNER SELECTION



## - Use of D8714 Catalyst Thinner

D8714 Catalyst Thinner can be used for only in combination with D897 Hardener where rapid curing is required. Some reduction in final appearance may be noticed when using D8714 This combination should be used immediately after mixing.

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## EQUIPMENT CLEANING

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

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## VOC INFORMATION

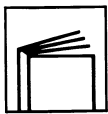
The EU limit value for this product (product category:11B.d) in ready to use form is max. 420g/litre of VOC.

The VOC content of this product in ready to use form is max. 420g/litre

Depending upon 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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