



GLOBAL REFINISH  
SYSTEM

December 2016

# Product Information

D8501 D8505 D8507  
2K Primer DP4000

*D8501 2K primer DP4000 White G1  
D8505 2K primer DP4000 Grey G5  
D8507 2K primer DP4000 Dark Grey G7  
D8238 HS Fast Hardener  
D8239 HS Slow Hardener  
D8740 Plastic Primer Additive*

## PRODUCT DESCRIPTION

DP4000, designed on the latest primer technology, can be used to optimise the priming process when used in combination with Deltron BC and Deltron DG. It is designed to deliver a high quality final appearance through a non sand process that is equivalent to a sanded primer. Excellent application, very smooth flow and superb holdout properties are at the core of this product's performance.

Due to the excellent adhesion characteristics of DP4000, no sanding of sound OE electrocoat is required, providing a very fast new panel process. DP4000 can be recoated directly after 25 minutes, or for up to 5 days with no sanding, so new parts can be primed in batches in advance with minimal preparation, and can be held ready for the topcoating process with the rest of the vehicle.

### Do not use an etch primer underneath DP4000.

If large or exposed areas of bare metal are to be painted for best corrosion performance or for OEM warranty standard corrosion performance use D834 Epoxy Primer.

The addition of D8740 Plastic Primer additive will allow new Bare TPO, PP/EPDM panels to be painted with DP4000. This Blend can also be applied to E-coat and other recommended substrates.

## PREPARATION OF SUBSTRATE- SANDING

***DP4000 can be applied over a wide range of substrates including:***

- Well cleaned unsanded Electrocoat.
- Bare steel areas up to 10 cm diameter without the need for an Epoxy Primer
- Galvanised Steel for rub throughs up to 10 cm maximum diameter
- Zintec for rub throughs up to 10 cm maximum diameter
- Aluminium and alloys for rub throughs up to 10 cm maximum diameter
- Aged painted and original surfaces sanded with P320 or finer
- GRP, Fibreglass P120/ P240/P320
- Polyester Filler P120/ P240/P320

**Note:** For best corrosion performance D834 Epoxy Primer should be applied prior to the application of DP4000 for areas of bare metal above 10cm diameter.

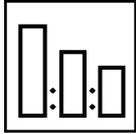


## PREPARATION OF SUBSTRATE – DEGREASING

Before any preparation work, wash all surfaces to be painted with soap and water. Rinse and allow to dry before degreasing with a suitable PPG substrate cleaner. Ensure all substrates are thoroughly cleaned and dried before and after each stage of the preparation work. Always wipe substrate cleaner off the panel surface immediately, using a clean dry cloth.



## MIXING RATIOS



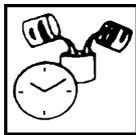
Mixing Ratios

By Volume:

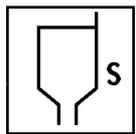
Primer DP4000	2
Hardener	1
Thinner	0.5

Recommended Hardeners: D8238 / D8239  
 Recommended Thinners: D866 / D807 / D812 or D8718 / D8719 / D8720 / D8740 (for adhesion to plastics)

## MIXED PRODUCT DETAILS



Potlife at 20°C: 1 hour.



Spray viscosity at 20°C: 16 - 18 seconds DIN4

## HARDENER AND THINNER SELECTION

<u>Temperature</u>	<u>HS Hardener</u>	<u>Thinner / Plastic Additive</u>
Below 25°C	D8238	D8718 / D807 / D8740
20°C - 30°C	D8238	D866 or D807 or D8718 / D8740
25°C - 35°C	D8238	D807 / D812 or D8718/19 / D8740
Over 30°C	D8239	D812 or D8719/20 / D8740

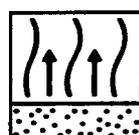
## APPLICATION AND FLASH OFF



Spraygun set-up: 1.2 -1.3mm  
 Spray pressure: See spraygun manufacturers information



Number of coats: Apply 1 full single coat or 1 light + 1 full to give a film thickness of 25-35 microns (1.0 - 1.4 thou.)  
 Apply to achieve an even finish. Do not apply heavy coats.



Flash-off at 20°C:  
 Before topcoat 25 minutes / 1 Hour

## DRYING TIMES



- *Ready for topcoat* 25 minutes
- *Scotch brite and preclean* Up to 3 days
- *Light denibbing and precleaning* After 3 days
- *Dry to sand at 60°C* 30 minutes
- *Dry to sand with Infra Red (Short Wave)* 5 min flash 10 min. cure

*For use with IR please use slowest Hardener and Thinner options.*

## OVERCOATING



Overcoat / Re-coat time: Minimum: 25 minutes – 1 Hour.

Preclean before topcoating if left more than 8 hours.

Light sanding and precleaning is recommended if this primer is left more than 3 days before topcoating.

If used for Spot repair as sandable primer, it is recommended that this primer should be force dried either at 60°C for 30 minutes or Infra Red dried. Once cool sand with P400 / 500 before overcoating.

Overcoat with: Deltron DG, Deltron BC

Normally DP4000 does not require flattening and can be directly topcoated. If some dirt inclusion occurs, light flattening/denibbing can be carried out after the first coat of Deltron BC P800 with foam pad otherwise after force drying for any other need.

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## PROCESSING ALTERNATIVES

DP4000 is especially useful for painting batches of small parts ready for the topcoating process. The excellent flow characteristics allow the OE quality finish to be replicated without sanding.

DP4000 can be topcoated using the following alternatives:

- Flash off between 25 minutes and 1 hour
- Light denibbing and precleaning is required after 8 hrs to prevent any workshop contamination from the environment from affecting the topcoat performance.

## DP4000 CAN BE USED IN PRIMER FILLER MODE USING THE FOLLOWING RECOMMENDATIONS

Mix and use the gun set up as recommended in the main Process note.

Apply 1 light + 2 full coats

This gives a film thickness of approximately 100-110 microns

Bake for 30 minutes at 60°C metal temperature.

IR medium wave – 5 min flash off, followed by a 10 min cure time.

After cooling dry sand with P400 or finer

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## EQUIPMENT CLEANING

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

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## PAINTING PLASTICS

DP4000 can be applied directly over well prepared and cleaned ABS, NORYL, PC/PBT, LEXAN, PUR and SMC, as well as sanded and pre-primed bumpers.

For bare plastic sections or rub through areas on bumpers, e.g. PP, TPO, PP/EPDM DP4000 should be activated normally and thinned with D8740 plastic adhesion additive for primer.

Panels should be prepared according to the Deltron cleaning and preparation of plastic substrate Product information sheet RLD241V.

## MIXING RATIOS FOR GREYMATIC SHADES

% by weight	G1	G3	G5	G6	G7
D8501	100	75	--	--	--
D8505	--	25	100	48	--
D8507	--	--	--	52	100

## MIXING BY WEIGHT

Where a specific volume of primer is required, this may be best achieved by weight mixing using the guidelines below. The tables show weights for 2/1/0,5 mixing ratios.

<b>WEIGHT ACTIVATION:</b>					
<b>Weights are in grams &amp; cumulative.</b>					
<b>Do not tare the balance between additions.</b>					
<b>2 / 1 / 0.5 MIXING RATIO</b>					
Target Paint Volume (L)	0.20 L	0.40 L	0.60 L	0.80 L	1.00 L
Primer	160	320	480	640	800
HS Hardeners	217	433	650	866	1083
Thinner D866 / D807 / D812	243	486	729	973	1216

<b>WEIGHT ACTIVATION:</b>					
<b>Weights are in grams &amp; cumulative.</b>					
<b>Do not tare the balance between additions.</b>					
<b>2 / 1 / 0.5 MIXING RATIO</b>					
Target Paint Volume (L)	0.20 L	0.40 L	0.60 L	0.80 L	1.00 L
Primer	160	320	480	640	800
HS Hardeners	217	433	650	866	1083
D 87** Thinners	240	480	720	969	1211

## PAINTING PLASTICS

<b>WEIGHT ACTIVATION: D8740 ADDITIVE</b>					
<b>Weights are in grams &amp; cumulative.</b>					
<b>Do not tare the balance between additions.</b>					
<b>2 / 1 / 0.5 MIXING RATIO</b>					
Target Paint Volume (L)	0.20 L	0.40 L	0.60 L	0.80 L	1.00 L
Primer	160	320	480	640	800
HS Hardeners	217	433	650	866	1083
D8740 Plastic Primer Additive	242	483	725	966	1208

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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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