



May 2006

Product Information

DELTRON D821

High Solids Chip Resistant Primer

PRODUCT DESCRIPTION

D821 is a transparent-grey primer surfacer with excellent anti-chip and anti-corrosion properties. It is ideal for the repair and repainting of any panel surfaces, particularly those areas most susceptible to chip damage.

Tintable with Deltron DG colour, D821 may be applied directly to bare steel, suitably prepared aluminium and pretreated steel. It may be overcoated, with or without sanding, with any Deltron GRS topcoat and Envirobase. D821 may be air dried, IR cured or low baked .

D821 offers significant economies in stock and process time. A single stage application of D821 can replace a conventional two stage primer system. D821 gives the adhesion and anticorrosion performance of an epoxy or wash etch primer together with the film build and surface levelling of a 2K surfacer.

PREPARATION OF SUBSTRATE



Substrate

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

Preparation

P80 - 120 (dry)
P400 (dry)
Fine sanding pad
P280 - 320 (dry)
P360 (dry) / P800 (wet)
P400 - 500 (dry) / P280 - 320 (wet)
P320 (dry)
P240 (dry)



Before and after any sanding operation, the substrate must be thoroughly degreased. Use an appropriate substrate cleaner/degreaser. PPG make a range of cleaning & degreasing products. See Technical Datasheet **Deltron Cleaners, RLD63** for suitable cleaners & degreasers.

MIXING RATIOS

1. Mixing Ratio – Untinted:

	<u>By Volume</u>		<u>By Volume</u>
D821	5 vol	D821	3 vol
D884/D897	1 vol	D841/D86	1 vol
Thinner	1 vol	Thinner	1 vol

2. Mixing Ratio – Tinted:

	<u>By Volume</u>		<u>By Volume</u>
D821	3 vol	D821	3 vol
UHS	1 vol	DG	1 vol
D884/D897	1 vol	D841/D861	1.5 vol
Thinner	1 vol	Thinner	1 vol



HARDENER AND THINNER SELECTION

<u>Temperature</u>	<u>MS Hardener</u>	<u>HS Hardener</u>	<u>Thinner</u>
Up to 18°C	D841	D884/D897	D808 Fast Thinner
18 - 25°C	D841	D884/D897	D866 or D807 2K Primer Thinner
25 - 35°C	D861	D884/D897	D812 Slow Thinner
Over 35°C	D861	D884/D897	D869 Very slow thinner




MIXED PRODUCT DETAILS

Potlife at 20°C:	3 - 4 hours
Spray Viscosity at 20°C:	18 - 25 seconds DIN4

APPLICATION AND FLASHOFF

	<i>Untinted</i>	<i>Tinted</i>
	<p><i>Spraygun set-up:</i></p>	<p>1.4 - 1.6 mm</p>
	<p><i>Number of coats:</i></p>	<p>2 - 3</p>
	<p><i>Flash-off at 20°C:</i></p> <ul style="list-style-type: none"> - Between coats - Before topcoating 	<p>10 - 15 minutes</p> <p>solventborne topcoat: 30 minutes waterborne topcoat: 45 minutes</p>

DRYING TIMES


	<p>Drying times at 20°C:</p>		
	<ul style="list-style-type: none"> - Dustfree - Touch dry - Through dry 	<p>35 minutes</p> <p>1.5 - 2 hours</p> <p>Overnight</p>	<p>35 minutes</p> <p>2 - 2.5 hours</p> <p>Overnight</p>
	<p>Through dry at 60°C:*</p>	<p>20 -25 minutes</p>	<p>30 minutes</p>
	<p>Through dry IR medium</p>	<p>10 -15 minutes</p>	<p>10 - 15 minutes</p>

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

Total dry film build:	70 - 110 µm	60 - 90 µm
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Theoretical coverage:	assuming 100% transfer efficiency and dry film thickness as indicated:	
	5 - 6 m ² /l	6 - 7 m ² /l

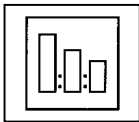
REPAIR AND RECOATING

	<p>Sanding:</p>	<p>Essential before recoating to ensure good adhesion</p> <p>P800 (wet)</p> <p>P400 (dry)</p>
	<p>Overcoat with:</p>	<p>Deltron GRS topcoats, Envirobase</p>

Global at a Glance

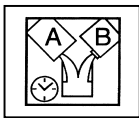
D821

DELTRON HS CHIP RESISTANT PRIMER D821



Mixing by volume

Untinted with HS Hardener -	5 : 1 : 1	D821:D884/897:thinner
Tinted with HS Hardener -	3 : 1 : 1 : 1	D821:UHS:D884/897:thinner
Untinted with MS Hardener -	3 : 1 : 1	D821:D841/861:thinner
Tinted with MS Hardener -	3 : 1 : 1.5 : 1	D821:DG:D841/861:thinner

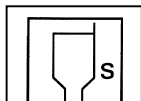


Pot Life at 20°C 3 - 4 hours

Hardener / Thinner Selection

Up to 18°C	D841 MS Fast Hardener or D884/897 HS Hardener D808 Fast thinner
18 - 25°C	D841 MS Medium Hardener or D884/897 HS Hardener D807 Thinner - or D866 Primer Thinner
Over 25°C	D861 MS Slow Hardener or D884/897 HS Hardener D812 Slow thinner

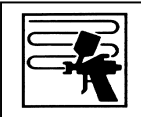
For exceptional conditions of Temperature and humidity (above 35°C or 70% RH) the use of D869 Very Slow thinner is recommended.



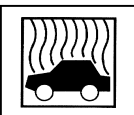
Application viscosities 18 - 25 seconds DIN4



Spraygun Sizes 1.4 - 1.6 mm fluid tip



Number of Coats 2 - 3



Drying Times
Dust Free - 35 minutes
Through dry at 20°C - Overnight or 30 minutes before topcoat
Through dry at 60°C - 25 - 30 minutes

PERFORMANCE AND LIMITATIONS



Use only the hardeners and thinners recommended on this data sheet.
Do NOT use Hardeners D803, D864 or D8208, Accelerator D818, Enhancer D885.

Where humidity is in the range 70 - 80%, use of D869 Deltron Very Slow Thinner is recommended.

EQUIPMENT CLEANING

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

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:

http://www.ppg.com/PPG_MSDS

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