

GLOBAL REFINISH
SYSTEM

January 2020

Product Information

D8125 HS Clearcoat

PRODUCTS

D8125	HS Clearcoat
D8262	Fast HS Hardener
D8263	Medium HS Hardener
D8264	Slow HS Hardener
D808	Fast Thinner
D807	Medium Thinner
D812	Slow Thinner
D8746	High Temperature Thinner

PRODUCT DESCRIPTION

HS Clearcoat D8125 is a new acrylic two component clearcoat optimised for use over PPG ENVIROBASE® High Performance & DELTRON® basecoats. This new clearcoat was developed to improve the repair process. Suitable for all types of repair, it is easy to apply either in conventional 2 coat mode or a rapid 1 visit application. D8125 gives a faster 15min drying cycle, being hard from the oven - yet easy to polish if needed. D8125 also gives great final appearance.

PREPARATION OF SUBSTRATE

D8125 HS Clear coat should be applied on top of clean and dust-free basecoat.
The use of a tack rag is recommended just prior to clearcoat application.

MIXING RATIO

Mixing ratios with HS Hardener:

	<u>By Volume</u>
D8125	2 vol.
D826x	1 vol.
D808/7/12/8746	0,5 vol.

* See paragraph below for hardener and Thinner selection

MIXING BY WEIGHT:

GUIDELINES FOR WEIGHT MIXING			
Where a specific volume of clearcoat mix is required, weight mixing can be used. The weights are cumulative - please do NOT tare the balance between additions.			
Target Volume of RFU Paint required (Litres)	Weight HS-Clear coat D8125	Weight Hardener D826x	Weight Thinner D808/7/12/D8746
0.10 L	57.0 g	85.3 g	98.2 g
0.20 L	114.1 g	170.6 g	196.3 g
0.5L	285.1 g	426.6 g	490.9 g
0.75 L	427.7 g	639.9 g	736.3 g
1.0 L	570.3 g	853.1 g	981.7 g
1.5L	855.4 g	1279.7 g	1472.6 g

PROCESS																					
	<table border="1"> <tr> <td>Clearcoat D8125</td> <td>Volume 2 parts</td> <td rowspan="3">For weight mixing, please see table on page 2.</td> </tr> <tr> <td>Hardener D826x</td> <td>1 part</td> </tr> <tr> <td>Thinner D808/7/12/8746</td> <td>0.5 part</td> </tr> </table>	Clearcoat D8125	Volume 2 parts	For weight mixing, please see table on page 2.	Hardener D826x	1 part	Thinner D808/7/12/8746	0.5 part													
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	14-16 secs DIN4 at 20°C																				
	Pot-Life at 20°C: 2 hours																				
	Gravity spraygun recommended. Set air-pressure in line with spraygun manufactures recommendations.																				
	Fluid tip : Gravity Gun 1.2-1.3 mm																				
	<p>1. Apply 2 single coats to give 50-60 microns dry film thickness (2 mins flash-off between coats)</p> <p style="text-align: center;">OR</p> <p>2. Apply 1 light coat followed by a full coat to give 50 microns dry film thickness. No flash off is required between coats</p>																				
	<p>Bake at a metal temperature of:</p> <table border="1"> <thead> <tr> <th></th> <th>D8262</th> <th>D8263</th> <th>D8264</th> </tr> </thead> <tbody> <tr> <td>40°C (Low Energy)</td> <td>30 mins</td> <td>30 mins</td> <td>30 mins</td> </tr> <tr> <td>60°C</td> <td>15 mins</td> <td>15 mins</td> <td>20 mins</td> </tr> </tbody> </table> <p><i>Always allow repairs to cool down fully before any sanding, polishing or rectification works</i></p> <p>Air-dry (20°C) :</p> <table border="1"> <thead> <tr> <th></th> <th>D8262</th> <th>D8263</th> <th>D8264</th> </tr> </thead> <tbody> <tr> <td>Polishable</td> <td>4 hours.</td> <td>4 hours</td> <td>4 hours</td> </tr> </tbody> </table>		D8262	D8263	D8264	40°C (Low Energy)	30 mins	30 mins	30 mins	60°C	15 mins	15 mins	20 mins		D8262	D8263	D8264	Polishable	4 hours.	4 hours	4 hours
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	Infra-red drying - Shortwave Approximately 5 min. full power (depending on colour and equipment)	Infra-red drying – Medium wave Approximately 10 min. full power (depending on colour and equipment)																			
	Note: When IR Drying – High Temperature Thinner D8746 should be used.																				

HARDENER SELECTION

<u>Temperature</u>	<u>Hardener</u>	<u>Thinner</u>
Up to 20°C	D8262	D808/D807
20-30°C	D8263	D807/D812
Above 30°C	D8264	D8746 See notes below

Note: The choice of hardener/thinner should be made according to application temperature, air movement and size of job.

- When using IR drying equipment - thinner D8746 must be used.
- At temperatures above 30°C
 - Over *Envirobase* High Performance basecoat, thinner D8746 **must** be used.
 - Over *Deltron GRS* basecoat, either thinner D812, D8746 may be used.

OVERCOATING/RECOATING

Overcoat / Recoat time - If Force dried, after cooling, or after Air drying.

It is essential to sand before recoating to ensure good adhesion.
Sand with P800 (wet) or P400 (Dry).

Overcoat with - Any PPG 2K primer, or GRS Deltron BC.

POLISHING

If polishing is required, i.e. to remove dirt nibs, it is recommended that it is carried out between 1 hour and 24 hours after the quoted drying time.

- Denib dirt with P1200, followed by P1500 dry disc.
- Lightly damp a 3M Trizact P3000 disc or similar with clean water ensuring that the P1500 scratches are eliminated.
- Use Specialty Polishing system SPP1001.
- It is important to start with the lambs wool pad at minimum speed, to avoid the surface becoming too hot.

If necessary, allow the panel to cool down before continuing to polish.

- Complete the process using a hard sponge followed by a soft sponge.
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CLEARCOAT BLENDING PROCEDURE

It is recommended to use GRS *Deltron* Aerosol Spot Blender D8731 or Spot Blender D8430 Refer to PPG datasheet RLD299 for a successful repair.

1. Key the surrounding area with a wet 1000 grade Trizact™ pad on a DA sander (3mm orbit). If clearcoat is to be faded out (up a pillar) this area should be finished with a wet Trizact™ P3000.
2. Prepare less accessible areas using D8407 Water-based Flattening Paste with an abrasive Scotchbrite™ Ultrafine (Grey) or Extra Fine (Copper) pad.
3. Thoroughly clean and tack the area to be refinished, ready for painting.
4. Apply GAT19/27 HS Clearcoat according to the information above.
5. After normal application, the gun is arced away from the panel in the blend area leaving a fine, dry overspray edge.
6. Apply the Spot Blender Aerosol (or the Spot Blender through a spraygun) to the clearcoat edge, in light coats to melt the overspray edge. DO NOT apply heavy coats.
7. Allow the paint film to thoroughly cure following the drying recommendations.
8. Lightly polish the blend area with polishing compound (SPP1001), taking care not to polish through the blend. Finish with a finishing polish.

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.

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