



GLOBAL REFINISH
SYSTEM

February 2018

Product Information

D8131 UHS Clearcoat

PRODUCTS

UHS Clearcoat	D8131
UHS Hardener	D8254
UHS Hardener Slow	D8255

For textured finishes or painting of flexible substrates:

DELTRON® Plasticiser	D814 to plasticise finishes over a flexible substrate
<i>Deltron</i> Matt Flexibiliser	D819 for textured appearance over a flexible substrate
<i>Deltron</i> Texture Additive	D843 to create a fine textured 'suede' effect
<i>Deltron</i> Leather Grain Additive	D844 to create a coarser, more pronounced textured finish

PRODUCT DESCRIPTION

D8131 UHS Clearcoat has been developed using the latest PPG clearcoat technology to enhance the innovative PPG paint system.

D8131 provides bodyshops with an easy to use clearcoat which combines the high speed drying, easy polish for all repairs. It comes with a smart and simple package with hardeners dedicated for standard & high temperature application.

- Application in 2 coats. 5 min flash off between coats and 5 min flash before bake.
- 1 Visit application; 1 light and 1 full coat.
- Fast drying; 15 minutes @ 60°C
- Very good gloss and flow;
- Easy to polish.

PREPARATION OF SUBSTRATE

Apply on top of a clean and dust free GRS Deltron BC (the use of a tack rag is recommended to remove dust from the basecoat film).

MIXING RATIO

Mixing ratios with UHS Hardener:

	<u>By Volume</u>
D8131	2 vol
D8254/D8255*	1 vol

* See paragraph below for hardener selection

- 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.

MIXING BY WEIGHT:

The weights are cumulative - please do **NOT** tare the balance between additions.

Volume of RFU paint required (Litres)	Clearcoat D8131	Hardener D8254/D8255
0,1 L	65,9g	100,5g
0,20 L	131,9g	201,1g
0,25 L	164,8g	251,3g
0,50 L	329,7g	502,7g
0,75 L	494,5g	754,0g
1,00 L	659,3g	1005,3g

HARDENER SELECTION

UHS Hardener

Application Temperature

D8254

Up to 35°C

D8255

Above 35°C or when the humidity is high

RFU MIXED PRODUCT DETAILS

Pot-life at 20°C

60 min at 20°C DIN4cup.

90 minutes double viscosity

Viscosity RFU 16-18 seconds DIN4 cup at 20°C.

SPRAYGUN SET UP

Spray Nozzle: 1.2-1,3 mm Fluid Tip

Spray Pressure: 2.0 - 2.2 Bar

APPLICATION AND FLASH OFF



Application

2 full coats

Flash off between coats

5 minutes flash off.

OR

**1 Visit application. 1 light/medium & 1 full coat.
The first coat should be applied as a light closed coat.
Second coat is applied as a full coat.**

Flash off between coats

If only 1-2 panels, 1½-2 minutes flash off between coats.

Flash off before bake or IR

5 minutes

Recommended film thickness:

50-60 µm dry film thickness

DRYING TIMES

- | | |
|------------------------|-----------------------------------|
| - Through dry at 60°C* | 15 minutes at 60°C |
| - Through dry at 40°C* | 40 minutes at 40°C |
| - Air-dry at 20°C* | 8 Hours at 20°C |
| - Through dry at IR | 8 minutes (depending upon colour) |
| - Dry to handle | After cooling down |



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: 50 – 60 µm

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

After the indicated baking time it is ready to polish after cooling down.

When air dry, ready to polish after 8 Hours @ 20°C.

FADE - OUT REPAIR PROCEDURE

- Prepare the fade out area with a 3000 grade soft pad on a DA sander.
- Take care to minimise the clearcoat edge in the fade-out area.
- Immediately melt the overspray edge using Spot Blender(Can version), applied by spray-gun (Mini-jet 1,0-1,2mm)
- After a thorough bake and cool down, polish process can be done.

PAINTING OF PLASTIC SUBSTRATES - TEXTURED FINISHES

To obtain a textured finish with D8131 Rapid Performance Clearcoat, it is necessary to include flex or texture additives in the mix. Additives are also required when applying D8131 over a flexible substrate.

The additives required and the appropriate volume and/or weight mix ratios are indicated in the tables below.

Note: The majority of plastics used on cars are considered **Rigid**. These plastics may have some flexibility when painted off the car, but are rigid once mounted. UHS Clearcoats only require the addition of the Plasticiser Additive (See **Flexible** chart below) when painting very flexible plastics, mostly found on older vehicles, e.g. foam type.

Cumulative Mixing by Weight

Do not tare the balance between additions

<u>Substrate</u>	<i>Appearance</i>	<i>D8131</i>	<i>D843</i>	<i>D844</i>	<i>D814</i>	<i>D819</i>	<i>D8254 or D8255</i>	<i>D8717/18/ 19/20</i>
RIGID	Gloss	659,3	-	-	-	-	1005,3	-
	Matt Textured	292,3	650,7	-	-	-	814,3	959,7
	Leather Grain	380,4	-	684,9	-	-	884,5	968,6
FLEXIBLE	Gloss	554,6	-	-	685,2	-	995,7	-
	Matt Textured	221,4	547,2	-	-	665,0	843,2	971,7
	Leather Grain	264,9	-	477,0	-	618,0	812,6	966,4

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.

VOC INFORMATION

The EU limit value for this product (product category: IIB.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 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.

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