



GLOBAL REFINISH
SYSTEM



April 2015

Product Information



2K AEROSOLS

D8470 2K Etch Primer (Chromate Free)
D8410 2K Epoxy Primer
D8163 2K Clearcoat

Product Description

2K Etch Primer (Chromate Free), D8470, has easy application, fine overspray, fast flash off and a long pot life.

2K Epoxy Primer, D8410, is a superb isolator for sensitive substrates and has excellent adhesion and corrosion protection, ideal for rub-throughs.

2K Clearcoat, D8163, is a premium water white, high solids 2-pack Clearcoat for use over ENVIROBASE[®] High Performance waterborne basecoat.

Substrates and Preparation

D8470/D8410 should only be applied over :

Well scuffed and degreased bare steel and aluminium.
Well-flatted GRP, polyester fillers, works primer and old finishes in sound condition.

Good preparation is vital in order to obtain the best results from this product.
The following grades of flating paper are recommended :-

Wet or dry paper	P280-P320 (GRP P400)
Machine dry sanding	P220-P280

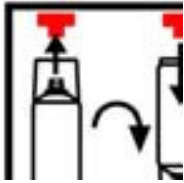
NOTE

1. Old synthetic finishes must be thoroughly through hardened.
2. Not recommended over thermoplastic acrylic substrates.

ACTIVATION GUIDE 2K AEROSOL



Before activating, shake aerosol for 2 min vigorously.



Take red button from cap. Turn aerosol by 180° and attach button to pin on aerosol bottom.



Place aerosol on firm ground - upside down. Press red button with the ball of your hand until stop is reached.



After activating, shake aerosol again vigorously for 2 min.

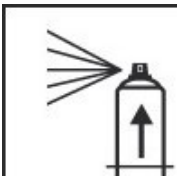
Note: 2K Etch Primer (Chromate Free), D8470, should be left to stand for 10 minutes before using.



Protections: Personal protection is required Respirator mask type A2/P2



Protective gloves, e.g. from latex or nitrile

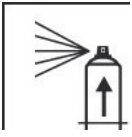


Note: When activating a 2K aerosol, make a note on the tin of the time and date, this will give guidance of how much Pot Life/Usable time is left for a particular tin. See below for Pot Life/Usable time of each product.



APPLICATION GUIDE

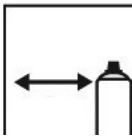
D8470 2K ETCH PRIMER (CHROMATE FREE)



Pot Life at 20°C (Usable time of Aerosol)

5 Days

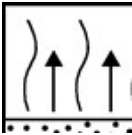
Maximum usable time of the aerosol, once activated, is achieved by storing the aerosol upside down between spraying sessions.



Spraying range : 15 - 20 cm



Apply 1 - 2 coats to give a film thickness of 10 - 20 microns

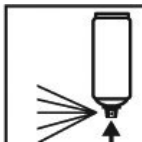


Allow 2 - 3 minutes flash between spray coats.



Air Dry for 15 minutes @ 20°C before recoating with 2K solventborne acrylic undercoat

Maximum recoat time – 24 hours



When work is finished, invert aerosol and spray valve empty

Maximum usable time of the aerosol, once activated, is achieved by storing the aerosol upside down between spraying sessions.

Recoat

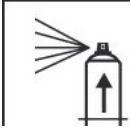
At 20°C : Recoatable after 10-15 minutes
(depending on film thickness)

D8470 must be recoated with a PPG 2K solventborne acrylic undercoat, before being topcoated with PPG 2K topcoat systems.



APPLICATION GUIDE

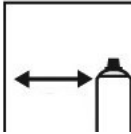
D8410 2K EPOXY PRIMER



Pot Life at 20°C (Usable time of Aerosol)

48 Hours

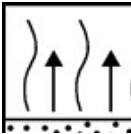
Maximum usable time of the aerosol, once activated, is achieved by storing the aerosol upside down between spraying sessions.



Spraying range : 15 - 20 cm



Apply 1 light coat + 1 medium coat to give a minimum film thickness of approx. 25 – 30 microns.



Allow 15 minutes flash-off time between coats.

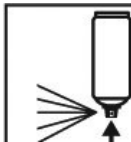


Air Dry for 60 minutes @ 20°C before recoating with 2K solventborne acrylic undercoat



Short Wave - 3 mins @ 50°C (half power) + 7 mins @ 70°C (full power)

Actual IR drying times may vary depending equipment used. Refer to lamp manufacturers recommendations.



When work is finished, invert aerosol and spray valve empty.

Maximum usable time of the aerosol, once activated, is achieved by storing the aerosol upside down between spraying sessions.

Recoat

At 20°C : Recoatable after 60 minutes

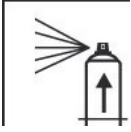
For best results, D8410 should be recoated with a PPG 2K solventborne acrylic undercoat, before being topcoated with PPG 2K topcoat systems.

D8410 can be directly recoated with PPG 2K topcoat systems after fully curing with IR and sanding.



APPLICATION GUIDE

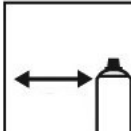
D8163 2K CLEARCOAT



Pot Life at 20°C (Usable time of Aerosol)

12 Hours

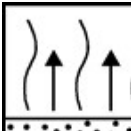
Maximum usable time of the aerosol, once activated, is achieved by storing the aerosol upside down between spraying sessions.



Spraying range : 15 - 20 cm



Apply 1 light/medium coat followed by a full coat to give 50 microns dry film thickness.



Allow 2-3 minutes flash between spray coats.

0 - 5 minutes flash-off required before baking, depending on oven type.

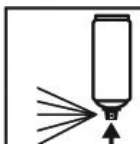


25 minutes @ 60°C (metal temperature).



Short-wave: 8 -15 mins full power (depending on colour and equipment).

Metal temperature between 90°C and 100°C



When work is finished, invert aerosol and spray valve empty.

Recoat

Recoatable when fully cooled after baking.

Polishing

Polishing of D8163 is easiest between 1 and 24 hours after "into service" drying times.



VOC INFORMATION

The EU limit value for this product (product category: IIB.e) in ready to use form is max.840g/litre of VOC. The VOC content of this product in ready to use form is max. 840g/litre

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:

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