



GLOBAL REFINISH  
SYSTEM

September 2019

# Product Information



## D8108 SCR Clearcoat

### PRODUCTS

<i>Deltron</i> SCR Clearcoat	D8108
<i>Deltron</i> Hardener	D841
OEM Hardener	D8259

For textured finishes or painting of flexible substrates:

<i>Deltron</i> 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

*Deltron* SCR Clearcoat D8108 is a 2K acrylic clearcoat developed for warranty repairs. D8108 is developed from OEM specifications and have passed all test criteria from OEM manufacturers. D8108 is designed for use over PPG basecoat systems. It may be used in 2 different modes, standard 2 coat application, or a "One Visit" application. This product is designed to be mixed with hardener only. No thinners are required in standard application.





## MIXING RATIO

Mixing ratios with Hardener:

	<u>By Volume</u>	<u>By Weight</u>
D8108	2 vol	See page 5
D841/D8259	1 vol	

- As with all 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 20°C

## HARDENER SELECTION

<u>UHS Hardener</u>	<u>Application Temperature</u>
D841	Up to 30°C
D8259	> 30°C or robotic application

D841 is the recommended hardener choice in an environment for optimum performance of D8108 up to 30°C application temperature.

## MIXED PRODUCT DETAILS

Potlife at 20°C: 1 hour

Spray viscosity at 20°C 16-17 seconds DIN4.

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## PREPARATION OF SUBSTRATE

*Deltron* D8108 Clearcoat must be applied over clean and dust-free Envirobase High Performance basecoat.

The use of a tack rag is then recommended.



## APPLICATION AND FLASH OFF



*Spraygun set-up:* 1.2 - 1.3 mm

### One Visit Process

*Application*

Apply 1 medium light closed & 1 full coat to give 50-60 microns dry film build.

The first coat should be applied to all repair panels before the second coat is applied.

*Flash off between spray coats*

For 1 panel application - 3 minutes flash off.

*Flash off before bake or IR dry*

For more than 1 panel, no flash off is required.  
3 minutes

### Conventional Two Coat Process

*Application*

Apply 2 single coats to give ~60 microns dry film build.

*Flash off between spray coats*

3 minutes

*Flash off before bake or IR dry*

3 minutes

## DRYING TIMES



- Through dry at 60°C\* 40 minutes with D841
- Through dry at IR (medium wave) 8 - 15 minutes (depending upon colour)

**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

*Theoretical coverage:*

Assuming 100% transfer efficiency and dry film thickness as indicated: 8-10 m<sup>2</sup>/l



## REPAIR AND RECOATING



**Sanding:**

- grade wet
- grade dry

Essential before recoating to ensure good adhesion

P800  
P400 - P500



**Overcoat / Re-coat time:**

- Force dry at 60°C or IR After cooling

**Overcoat with:**

PPG 2K Primers, *Envirobase* High Performance basecoat

## PAINTING OF PLASTIC SUBSTRATES - TEXTURED FINISHES

To obtain a textured finish with *Deltron* D8108 UHS Clearcoat, it is necessary to include flexibiliser or texture additives in the mix. Additives are also required when applying D8108 over a flexible substrate. The additives required and the appropriate volume and/or weight mix ratios are indicated in microfiches if relevant or 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

Substrate	Appearance	D8108	D843	D844	D814	D819	UHS Hardeners	Thinner GRS Deltron
<b>RIGID</b>	Gloss	658,0	-	-	-	-	1004,3	-
	Matt Textured	291,7	650,1	-	-	-	803,6	957,1
	Leather Grain	394,8	-	711,5	-	-	919,3	973,9
<b>FLEXIBLE</b>	Gloss	545,5	-	-	714,9	-	998,3	-
	Matt Textured	226,0	559,2	-	-	679,8	878,1	978,2
	Leather Grain	296,1	-	533,6	-	691,6	899,4	981,4



## POLISHING



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

## FADE - OUT REPAIR PROCEDURE

- Apply D8108 UHS Clearcoat according to the information above
- Take care to minimise the clearcoat edge in the fade-out area
- Melt overspray edge using D8731 Aerosol Spot Blender or D8430 Spot Blender.
- Refer to datasheet No: RLD 299V for successful repair.

## WEIGHT MIX TABLE FOR D8108

GUIDELINES FOR WEIGHT MIXING		
Where a specific volume of clearcoat mix is required, this may be best achieved by weight mixing, using the guidelines below.		
The weights are cumulative - please do <b>NOT</b> tare the balance between additions.		
Target Volume of RFU Paint required (Litres)	Weight UHS Clearcoat D8108	Weight Hardeners
100	65,8g	100,4g
250	164,5g	251,1g
330	217,1g	331,4g
400	263,2g	401,7g
500	329,0g	502,2g
660	434,3g	662,9g
700	460,6g	703,0g
750	493,5g	753,3g
900	592,2g	903,9g
1000	658,0g	1004,3g

## 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.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. 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.

**PPG Industries (UK) Limited.**  
**Auto Refinish**  
**Customer Service and Sales Group,**  
**Needham Road,**  
**Stowmarket,**  
**Suffolk.**  
**IP14 2AD,**  
**England.**

**Tel: 01449 771775**

**Fax: 01449 773480**

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