



May 2006

Product Information

KOBA 2K 5+1 D838

PRODUCT INFORMATION

Koba 2K 5+1 D838 yellow is a versatile, high build 2K primer, suitable for use under any PPG Deltron 2K Topcoat and Deltron BC. It offers exceptional film build and isolating properties when used as a high-build spray or primer filler, and by simple adjustment of thinning ratio may also be used as a primer surfacer or wet-on-wet surfacer.

Koba 2K 5+1 can be applied over suitably prepared knifing putties, or over sound, fully cured original paintwork or adhesion primers. Options are available for air-drying and for conventional or IR stove-drying.

PREPARATION OF SUBSTRATE



Substrate

Bare steel
Galvanised steel
Zintec
Aluminium and alloys
Electropaint
Aged painted surfaces
Polyester filler



Preparation

Must be pre-primed (e.g. D831, D834)
Must be pre-primed (e.g. D832, D834)
Must be pre-primed (e.g. D831, D834)
Must be pre-primed (e.g. D831, D834)
P360 (dry) / P800 (wet)
P400 – P500 (dry) / P280 - 320 (wet)
P320 (dry)
P240 (high-build version)

Prior and after any sanding operation, the substrate must be thoroughly degreased. See TDS **RLD163 Deltron Cleaners** for an appropriate PPG cleaner.

MIXING RATIOS

1. Mixing Ratios with MS Hardener – Used as a Spray Filler:

	<u>By Volume</u>
D838	5 vol
MS Hardener	1 vol

2. Mixing Ratios with MS Hardener – Used as a Primer Filler:

	<u>By Volume</u>
D838	5 vol
MS Hardener	1 vol
Thinner	0.5 vol

3. Mixing Ratios with MS Hardener – Used as a Surfacer:

	<u>By Volume</u>
D838	5 vol
MS Hardener	1 vol
Thinner	1 vol

4. Mixing Ratios with MS Hardener – Used as a Wet on Wet:

	<u>By Volume</u>
D838	1 vol
D800/DG	1 vol
MS Hardener	1 vol
Thinner	1 vol

HARDENER AND THINNER SELECTION

Temperature

Up to 18°C
18 - 25°C
25 - 35°C
Over 35°C

MS Hardener

D803 MS Fast
D841 MS Medium
D861 MS Slow
D861 MS Slow

Thinner

D808 Fast Thinner
D866 2K Primer Thinner
D812 Slow Thinner
D869 Very Slow Thinner

MIXED PRODUCT DETAILS

Potlife at 20°C:	<u>Spray Filler</u> 30 minutes	<u>Primer Filler</u> 35 minutes	<u>Surfacer</u> 45 minutes	<u>Wet on Wet</u> 45 minutes
Spray viscosity: DIN4 at 20°C	55 - 60 Seconds	35 - 40 Seconds	25 - 30 Seconds	14 - 16 Seconds

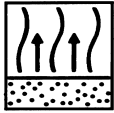
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APPLICATION AND FLASH OFF

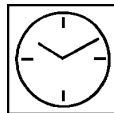


	<u>Spray Filler</u>	<u>Primer Filler</u>	<u>Surfacer</u>	<u>Wet-on-Wet</u>
<i>Spraygun set-up:</i>	2.0 - 2.2 mm	2.0 - 2.2 mm	1.6 mm	1.6 mm
<i>Number of coats:</i>	3	3	2 - 3	1 - 2



<i>Flash-off at 20°C:</i>				
- <i>Between coats</i>	15 minutes	10 minutes	10 minutes	15 minutes
- <i>Before stoving</i>	Do not force dry	Do not force dry	10 minutes	n/a
- <i>Before topcoating</i>	15 minutes	10 minutes	10 minutes	15 minutes

DRYING TIMES



- <i>Dust free at 20°C</i>	15 minutes	10 minutes	10 minutes	15 minutes
- <i>Through dry at 20°C</i>	Overnight	5 hours	3 hours	2 hours (sandable)
- <i>Through dry at 60°C*</i>	Do not force dry	Do not force dry	30 minutes	30 minutes
- <i>Through dry IR medium</i>	Do not force dry	Do not force dry	10 minutes	10 minutes



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

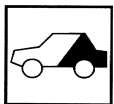
FILM PROPERTIES

	<i>Spray Filler</i>	<i>Primer Filler</i>	<i>Surfacer</i>	<i>Wet-on-Wet</i>
<i>Total dry film build:</i>	200 - 260 µm	160 - 220 µm	50 - 100 µm	15 - 30 µm
<i>Theoretical coverage:</i>	Assuming 100% transfer efficiency and dry film thickness as indicated:			
	2 m ² /l	2 m ² /l	6 m ² /l	10 m ² /l

REPAIR AND RECOATING

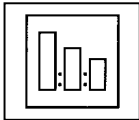


<i>Sanding:</i>	Essential before recoating to ensure good adhesion
- <i>grade wet</i>	P800
- <i>grade dry</i>	P400



<i>Overcoat with:</i>	Deltron DG Deltron BC Deltron UHS Deltron Progress UHS DG
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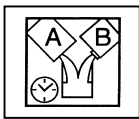
KOBA 2K 5+1 D838



Mixing by volume

With MS Hardener -

As Spray Filler	5 : 1
As Primer Filler	5 : 1 : 0.5
As Surfacer	5 : 1 : 1
As "Wet on Wet"	1 : 1 : 1 : 1

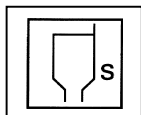


Pot Life at 20°C 30 minutes as Spray filler, 35 minutes as Primer Filler
45 minutes as Surfacer, 45 minutes as Wet on Wet

Hardener / Thinner Selection

Up to 18°C	D803 MS Fast Hardener D808 Fast thinner
18 - 25°C	D841 MS Medium Hardener D807 Thinner - or D866 Primer Thinner
Over 25°C	D861 MS Slow 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.



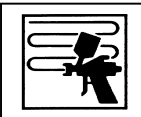
Application viscosities (DIN 4)

55 - 60 seconds - Spray Filler,	35 - 40 secs - Primer Filler
25 - 30 secs - Surfacer,	14 - 16 secs - Wet on Wet



Spraygun Sizes

2.0 - 2.2 mm fluid tip - Spray Filler or Primer Filler
1.6 mm fluid tip - Surfacer or Wet on Wet



Number of Coats

Spray Filler, Primer Filler	3 Coats maximum,
Surfacer	2 - 3 Coats
Wet on Wet	1 - 2 Coats



Drying Times

Dust Free -	10 - 15 minutes
Through dry at 20°C -	Overnight as Spray Filler, 5 hours as Primer Filler, 3 hours as a Surfacer.
	Wet on wet - 15 minutes before topcoat
Through dry at 60°C	30 minutes as Surfacer DO NOT Force dry - Spray Filler or Primer Filler.

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PERFORMANCE AND LIMITATIONS



Do **not** use accelerated MS hardener D864 in Koba 5+1.

When using D838 as a wet-on-wet surfacer it is important to use the same hardener in both wet-on-wet surfacer and subsequent Deltron topcoat.

Do not attempt to use D838 at humidity levels exceeding 80%.

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](http://www.ppg.com/PPG_MSDS)

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