



May 2012

Product Information

GRS Deltron D8120

High-solids Clear

PRODUCTS

Deltron Clear	D8120
Deltron Medium Solids Hardeners	D803, D841, D861, D864
Deltron Thinners	D808, D807, D812, D869
Deltron DG Fade-out Thinner	D868
Deltron Accelerator	D818

For textured finishes or painting of flexible substrates:

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

PRODUCT DESCRIPTION

Deltron D8120 High Solids Clear is a premium quality high solids polyurethane clearcoat specifically formulated to give optimum gloss and durability when low-baked.

It is designed to be used over Deltron BC and Envirobase Colour.

PREPARATION OF SUBSTRATE

Deltron D8120 Clear must be applied on top of a clean and dust-free Deltron basecoat or Envirobase. The use of a tack rag is recommended.

These products are for professional use only

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MIXING RATIO

Mixing ratios with MS Hardener:

	<u>By Volume</u>
D8120	3 vol
MS Hardener*	1 vol
Thinner	0.8 vol (20%)

*Choose MS Hardener and Thinner according to application temperature

HARDENER AND THINNER SELECTION

<u>Temperature</u>	<u>MS Hardener</u>	<u>Thinner</u>
Up to 18°C	D803 Fast	D808
18°C - 25°C	D841 Medium	D807
Over 25°C	D861 Slow	D812

For exceptional conditions of temperature and humidity (> 35°C / >70%) the use of Very Slow Thinner D869 is recommended

MIXED PRODUCT DETAILS

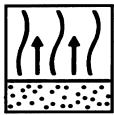
Potlife at 20°C: 2 hours

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

APPLICATION AND FLASHOFF

Spraygun set-up: 1.4 - 1.6 mm

Number of coats: 1 medium , 1 full



Flash-off at 20°C:

- *Between coats* 5 minutes

- *Before stoving* 10 minutes

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DRYING TIMES



Drying times:*

- *Dust free at 20 °C* 40 minutes
- *Dry to handle at 20°C* 6 hours



- *Through dry at 20 °C* 20 hours
- *Through dry at 60°C* 30 - 40 minutes (D841)
- *Through dry at 70°C* 30 minutes



- *Through dry at IR Medium* Dependent on colour of basecoat (darker colours require less time): 15 minutes

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

Drying times may be reduced still further by using the Deltron Accelerated System.

Total dry film build: 50 - 60 µm

Theoretical coverage: assuming 100% transfer efficiency and dry film thickness as indicated:
7 - 7.5 m²/l

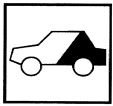
REPAIR AND RECOATING



Sanding:

Essential before recoating to ensure good adhesion

- *Grade wet* P800
- *Grade dry* P400



Overcoat / recoat time:

- *Force dry 60°C, 70°C or IR* after cooling
- *Airdrying at 20°C* Minimum 12 hours

Overcoat with:

Deltron primers
Envirobase
Deltron topcoats

PAINTING OF PLASTIC SUBSTRATES - TEXTURED FINISHES

To obtain a textured finish with Deltron D8120 Clear, it is necessary to include suitable flex or texture additives in the mix. Additives are also required when applying D8120 over a flexible substrate (typically plastics). The additives required and the appropriate volume and 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.

Substrate	Appearance	D8120	D843	D844	D814	D819	MS hardener	Deltron Thinner
RIGID	Gloss	3 vol	-	-	-	-	1 vol	0.8 vol
	Matt Textured	3 vol	3 vol	-	-	-	1.5 vol	1 vol
	Leather Grain	3 vol	-	1.5 vol	-	-	1.5 vol	0.8 vol
FLEXIBLE	Gloss	3 vol	-	-	1 vol	-	2 vol	0.8 vol
	Matt Textured	4 vol	4 vol	-	-	2 vol	3.5 vol	1 vol
	Leather Grain	4 vol	-	2 vol	-	2 vol	3.5 vol	0.8 vol

SPOT REPAIR PROCEDURE

- Apply Deltron D8120 HS Clear according to the 'Application, Flash-Off and Drying' section above.
- Leave to flash-off for 10 minutes / 20°C after the 2nd coat.
- A suitable quantity of activated and thinned D8120 HS Clear should then be reduced with Deltron DG Fade-Out Thinner D868 at a ratio of 1:3 (1 part activated and thinned clear to 3 parts D868).
- Apply this 1:3 mix over the repair area, using a reduced gun pressure to minimise overspray. Spray from the outside of the repair inwards, covering an area that extends beyond the edge of the initial application.
- After force-dry or IR, buff the repair edges.

POLISHING

Low-bake or IR force-drying:

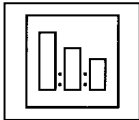
Minimum 1 hour after cooling

Airdrying at 20°C:

Minimum 24 hours after application

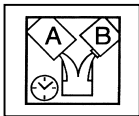
EQUIPMENT CLEANING

After use, clean all equipment thoroughly with cleaning solvent or thinner.



Mixing by volume

With MS Hardener - 3:1:0.8 (20%)

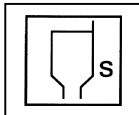


Pot Life at 20°C 3 hours

Hardener / Thinner Selection

Up to 18°C	D803 MS Accelerated Hardener D808 - Fast thinner
18 - 25°C	D841 MS Hardener D807 Thinner
Over 25°C	D861 MS 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 viscosity

16 - 17 seconds DIN4



Spraygun Size

1.4 - 1.6 mm fluid tip



Number of Coats

1 medium coat, 5 minute flash off, followed by 1 full coat



Drying Times

10 minutes flash off before stoving
 Dust Free - 40 minutes
 Through dry at 20°C - 20 hours
 Through dry at 60°C - 30 minutes

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: www.ppgrefinish.com

**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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