



AUTO REFINISH



Product Information

UHS PRIMA D8023

Grey 2K UHS Surfacer

PRODUCT DESCRIPTION

D8023 UHS Prima is a grey 2K UHS surfacer. Versatile, quick-drying and easy to apply and sand, it may be used over a wide range of substrates. D8023 offers excellent corrosion resistance, gloss holdout and surface levelling, with film builds of up to 200µ attainable.

By simple adjustment of the thinning ratio, D8023 may be applied as a high-build spray-filler, as a primer-surfacer or as a non-sand surfacer. It may be used with both MS and HS hardeners and may be mixed to have a ready-to-spray VOC content below 540g/lt.

D8023 may be applied directly to suitably prepared sound original paintwork, bare steel, polyester bodyfillers and bare metal adhesion primers. D8023 may be air-dried, low-baked or IR cured, and may be directly overcoated with a variety of topcoat materials, including Global Refinish System/Deltron BC, DG & UHS and Envirobase waterborne basecoat colour.

	Primer	Hardener	Thinner	Version	V.O.C . content
	6	1 (HS)	0-0,5	Spray Filler	Below 540 g/L
	6	1 (HS)	1	Surfacer	Below 540 g/L
	6	1 (HS)	1,5	Wet on Wet	Below 540 g/L
	4	1 (MS)	0-0,5	Spray Filler	Below 540 g/L

PREPARATION OF SUBSTRATE – DEGREASING

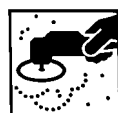
Before any preparation work, wash all surfaces to be painted with soap and water. Rinse and allow to dry before degreasing with a suitable PPG substrate cleaner :



		VOC Content
D842*	DX380 Low-VOC Cleaner	below 200g/l
<i>(If using D842, rinse the surface with T494 Deionised water immediately after degreasing, then dry the panel surface.)</i>		
D8401*	Waterborne Low-VOC Cleaner	below 200g/lt
D845	DX310 High Strength Degreaser	above 200g/lt
D837	DX330 Spirit Wipe	above 200g/lt

Ensure all substrates are thoroughly cleaned and dried before and after each stage of the preparation work. Always wipe substrate cleaner off the panel surface immediately, using a clean, dry cloth.

* Do not degrease polyester fillers using D842 or D8401.



PREPARATION OF SUBSTRATE - PRIMING & SANDING

Bare Steel should be lightly abraded and completely rust free before application. D8023 may be applied directly, but bare metal primers Universel or DP40 are recommended where optimum adhesion and corrosion resistance is required.



Other bare metals should be pre-primed with either Universel or DP40.

Electropaint should be sanded with P360 grade paper (dry) or P800 grade (wet).



PRIMING AND SANDING continued

Original Paintwork or Primers should be sanded using P280-P320 grade paper (dry) or P400-P500 grade paper (wet). Spot prime any exposed bare metal with bare metal primer Universel or DP40.



GRP or Fibreglass should be sanded using P320 grade paper (dry).

Polyester Fillers should be dry sanded using a sequence of grade of paper grades suitable for the chosen application of D8023 :

P80-P120 when using as a spray filler.

P80-P120-P240 when using as a primer surfacer or non-sand surfacer.

HARDENER & THINNER SELECTION

Using :

HS Hardeners

MS Hardeners

Temperature	HS Hardener	Thinner	MS Hardener	Thinner
Up to 18°C	D8208	D808	D803	D808
18-25°C	D897	D866/D807	D841	D866
25-35°C	D897	D812	D861	D812
Above 35°C	D897	D869	D861	D869

When using D8023 as a non-sand surfacer, it is recommended that the same hardener be used in subsequently applied direct gloss colour or clearcoat. Consult the appropriate technical datasheets(s) to identify a suitable common hardener.

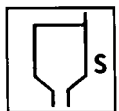
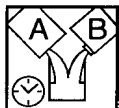
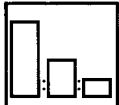
MIXING

Using :

HS Hardeners

MS Hardeners

Applied as a : **Spray Filler** **Primer Surfacer** **Spray Filler** **Primer Surfacer**



	HS Hardeners		MS Hardeners	
				
Mixing Ratio :	D8023 6 vol	D8023 6 vol	D8023 4 vol	D8023 4 vol
	Hardener 1 vol	Hardener 1 vol	Hardener 1 vol	Hardener 1 vol
	Thinner 0-0,5 vol	Thinner 1 vol	Thinner 0-0,5 vol	Thinner 1 vol

(For use on flexible substrates mix 6 : 1.5 : 1 D8023 : D841 : D814)

Potlife at 20°C : 30-40min 60min 30-60 min 75 min

Spray viscosity
DIN4/20°C : 40 – 85 seconds 25-35sec 25-60sec 25-35sec

SPRAYGUN SETUP

Using :

HS Hardeners

MS Hardeners

Applied as a : **Spray Filler** **Primer Surfacer** **Spray Filler** **Primer Surfacer**



Fluid Tip,
Gravity : 2.0-2.2mm 1.6-1.8mm 2.0-2.2mm 1.6-1.8mm



Suction : not recommended 1.8-2.0mm not recommended 1.8-2.0mm

Pressure : Follow spraygun manufacturer's recommendations

APPLICATION GUIDE

Using :

HS Hardeners

MS Hardeners

Applied as a :

Spray Filler

Primer Surfacer

Spray Filler

Primer Surfacer



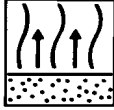
Number of coats :

max. 3

2-3

max. 3

2-3



Flash off/20°C:

- between coats

10 minutes

10 minutes

10 minutes

10 minutes

- before stoving

Do not
force dry

10 minutes

Do not
force dry

10 minutes

DRYING

Using :

HS Hardeners

MS Hardeners

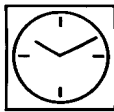
Applied as a :

Spray Filler

Primer Surfacer

Spray Filler

Primer Surfacer



Dust free/20°C

10 minutes

10 minutes

10 minutes

10 minutes

Touch dry/20°C

3½-4 hours

1½-2 hours

3½-4 hours

1½-2 hours

Sandable/20°C

5 hours

4 hours

5 hours

4 hours

Through dry/60°C

Do not
force dry

30 minutes*

Do not
force dry

30 minutes*



Through dry/
IR medium

Do not
force dry

20 minutes

Do not
force dry

20 minutes

* Drying time once substrate reaches 60°C metal temperature.

FILM PROPERTIES

Using :

HS Hardeners

MS Hardeners

Applied as a :

Spray Filler

Primer Surfacer

Spray Filler

Primer Surfacer

Dry film builds :

- maximum

200µ

140µ

200µ

140µ

- minimum

100µ

80µ

100µ

80µ

SANDING

Using :

HS Hardeners

MS Hardeners

Applied as a :

Spray Filler

Primer Surfacer

Spray Filler

Primer Surfacer



Dry :

P400

P400

P400

P400



Wet :

P800

P800

P800

P800

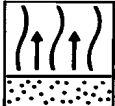
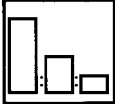
TOPCOATING



D8023 UHS Prima may be overcoated directly with the following topcoat products :

Global Refinish System/Deltron BC Basecoat Colour
Global Refinish System/Deltron DG Direct Gloss Colour
Global Refinish System/Deltron UHS Ultra High Solids Direct Gloss Colour
Envirobase Waterborne Basecoat Colour

APPLICATION AS A NON-SAND SURFACER



Using :

HS Hardeners

MS Hardeners



Mixing Ratio :	D8023	6 vol	6 vol	D8023	4 vol
	Hardener	1 vol	1 vol	Hardener	1 vol
	Thinner	1.5 vol	2.5 vol	Thinner	2 vol

Number of coats :	1-2	1-2
-------------------	-----	-----

Flash off/20°C:		
- between coats	10 minutes	10 minutes
- before BC, DG or UHS topcoat	20-30 minutes	20-30 minutes
- before Envirobase topcoat	30 minutes	30 minutes

Do not exceed 30 minutes/20°C flash-off time before application of topcoat.

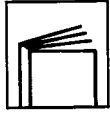
When using D8023 as a non-sand surfacer, it is recommended that the same hardener be used in subsequently applied direct gloss colour or clearcoat. Consult the appropriate technical datasheets(s) to identify a suitable common hardener.

LIMITATIONS

Accelerators should NOT be used. Part used cans of hardener must be carefully closed immediately after use. All equipment must be perfectly dry. Use of D8023 is not recommended when humidity levels exceed 80%.

SPOT PRIMING

When spot priming, smooth repair edges may be achieved by adding an additional 1 part of thinner to the last coat and thoroughly sanding the repair edge.



HEALTH AND SAFETY

PRODUCT FOR PROFESSIONAL USE ONLY. See Manufacturer's Safety Data Sheet relating to this product at: http://www.ppg.com/PPG_MSDS.
Use the recommended safety equipment.

THIS PRODUCT IS FOR PROFESSIONAL USE ONLY.

The information given in this sheet is for guidance only. Any person using the product without first making further enquiries as to the suitability of the product for the intended purpose does so at his own risk and we can accept no liability for the performance of the product or for any loss or damage (other than death or personal injury resulting from our negligence) arising out of such use. The information contained in this sheet is liable to modification from time to time in the light of our experience and our policy of continuous product development.

Drying times quoted are average times at 20° C.
Film thickness, humidity and temperature can all affect drying times.



**PPG Industries (UK) Limited.
Auto Refinish
Customer Service and Sales
Group,
Needham Road,
Stowmarket,
Suffolk.
IP14 2AD,
England.
Tel: 01449 771775
Fax: 01449 773480**