



GLOBAL REFINISH
SYSTEM



July 2008

Product Information



GRS Deltron Matt Clearcoat D8113

D8113 Matt Clearcoat

PRODUCTS

Deltron Matt Clearcoat	D8113
Deltron HS Hardeners	D8237, D8238, D8239
Deltron Low VOC Thinners	D8718, D8719

PRODUCT DESCRIPTION

D8113 is designed for use over Envirobase basecoat. D8113 may be used over Deltron basecoat for repair work not controlled by EU Directive 2004/42.

Deltron Matt Clearcoat is a versatile 2K acrylic urethane clearcoat designed for the specialised repairs of vehicles or areas of vehicles originally finished with matt clearcoat over a single or multistage colour basecoat system. D8113 may be used over rigid plastics without the need for special additives.

D8113 Matt Clearcoat can only be used with Deltron HS hardeners D8237 / D8238 / D8239.

PREPARATION OF SUBSTRATE

Deltron D8113 Clear must be applied on top of a clean and dust-free basecoat. The use of a tack cloth is recommended.

MIXING RATIO

Mixing ratios with MS Hardeners D8237 / D8238 / D8239

	<u>By Volume</u>	<u>By Weight</u>
D8113	3 volumes	See table, Page 4
HS Hardener*	1 volume	
Thinner*	1 volumes	

- Choose HS Hardener / Thinner according to application temperature *
- As with all high solids products, cold ready for use paint temperatures can lead to more difficult application and overspray absorption.

HARDENER SELECTION

<u>System</u>	<u>HS Hardener</u>	<u>Bake Schedule</u>
For use at Temperatures 18 - 25°C	D8237 Express	20 minutes @ 60°C
For use at Temperatures 25 - 35°C	D8238 Fast	30 minutes @ 60°C
For use at Temperatures Above 35°C	D8239 Slow	35 minutes @ 60°C

MIXED PRODUCT DETAILS

Potlife at 20°C: 2 hours with D8237 hardener

Spray viscosity at 20°C 16 - 19 seconds DIN4.



APPLICATION AND FLASHOFF



Spraygun set-up: 1.2 - 1.4 mm

Conventional Two Coat Process

Application Apply 2 single coats to give 50 - 60 microns dry film build.

Flash off between spray coats 5 - 10 minutes - for best results, allow to dry matt

Flash off before bake or IR dry 5 - 10 minutes - for best results, allow to dry matt

For Optimum results on large horizontal surfaces, allow 10 minutes between the first and second coat. 1 minute after the second coat, apply a low pressure "Drop coat" into the wet film. (1.5 bar at the spraygun)

DRYING TIMES

Dust free time at 20°C	20 minutes with D8237,
Dry to handle at 20°C	2 hours with D8237
Through dry at 20°C	8 hours with D8237
Through dry at 60°C*	20 minutes with D8237, 30 minutes with D8238, 35 minutes with D8239
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 m²/l



REPAIR AND RECOATING



Sanding:

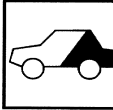
- *grade wet*
- *grade dry*

Essential before recoating to ensure good adhesion

P800

P400 - P500

Overcoat / Re-coat time:



- *Force dry at 60°C, or IR*
- *Air drying at 20°C*

After cooling

12 hours

Overcoat with:

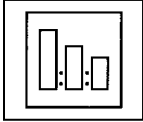
Deltron primers
 Envirobase
 Deltron topcoats

WEIGHT MIX TABLE FOR D8113

Target Volume of RFU Paint required (Litres)	Weight Clearcoat D8113	Weight HS Hardeners D8237/8238/8239	Weight D8718, D8719 Low VOC Thinner
0.10 L	62g	82g	99g
0.20 L	124g	164g	197g
0.25 L	155g	205g	246g
0.33 L	207g	273g	328g
0.50 L	311g	410g	492g
0.75 L	466g	615g	738g
1.00 L	622g	820g	947g
1.50 L	932g	1230g	1476g
2.00 L	1244g	1640g	1969g
2.50 L	1555g	2050g	2461g

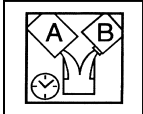


GRS Deltron Matt Clearcoat



Mixing by volume

With HS Hardener 3 : 1 : 1



Pot Life at 20°C

Using D8237 2 hours

Hardener Selection

For application temperatures
18 - 25°C

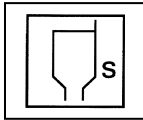
D8237 Express Hardener

For application temperatures
25 - 35°C

D8238 Fast Hardener

For application temperatures
Above 35°C

D8239 Medium Hardener



Application Viscosity

16 - 19 seconds DIN4



Spraygun Size

1.2 - 1.4 mm fluid tip



Number of Coats

Conventional -

2 single coats, 5 - 10 minute flash-off between coats.

5 - 10 minutes flash off before baking.



Drying Times

Dust free at 20°C

20 minutes with D8237,

Through dry at 60°C

20 minutes with D8237

30 minutes with D8238

35 minutes with D8239

PERFORMANCE AND LIMITATIONS

These products are for professional use only.

RLD216V

Page 5



The Gloss levels achieved with this clear may vary depending upon film thickness and application. Low film thickness and dry application will give a Low Gloss. High film thickness and wet application will give a higher gloss level.
It is recommended that this clear be used for complete panel repair only.

EQUIPMENT CLEANING

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

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.

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)

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



Copyright © 2008 PPG Industries, all rights reserved.

