



AUTO REFINISH

**GLOBAL
REFINISH
SYSTEM**



Product information

PRIME-FILL D824

*Low-VOC 2K Surfacer D824
Hardener D852*

PRODUCT DESCRIPTION

Prime-Fill is a grey solvent-borne 2K acrylic primer surfacer. Easy to mix, apply and sand, Prime-Fill offers excellent film build, surface levelling and gloss hold-out over a wide range of substrates.

With a ready-to-spray VOC content of 250g/l, Prime-Fill is particularly suitable for bodyshops operating in areas where VOC emissions or product VOC content is restricted.

Prime-Fill may be applied directly to sound original paintwork, polyester bodyfillers and adhesion promoters. It may be directly overcoated with any Deltron GRS topcoat material and Envirobase.

PREPARATION OF SUBSTRATE



Substrate

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

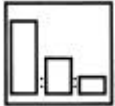
Sand

Must be pre-primed
Must be pre-primed
Must be pre-primed
Must be pre-primed
P360 (dry) / P800 (wet)
P280 / P360 (dry) / P400 - P500 (wet)
P280 / P320 (dry)



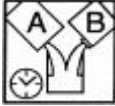
Before and after any sanding operation, the substrate must be thoroughly degreased.

PRODUCT SET-UP



Mixing ratio:

D824	1 vol
D852	1 vol



Potlife at 20°C: 1 - 1.5 hours



Spray viscosity at 20 °C: 16 -18 seconds DIN4

APPLICATION, FLASH-OFF AND DRYING



Spraygun set-up: 1.4 - 1.8 mm

Number of coats: 2 - 3 light coats



Flash-off at 20°C:

- Between coats 5 - 10 minutes
- Before stoving 10 minutes



Drying times at 20°C:

- Dust free 10 minutes
- Through dry 2 hours



Through dry at 60°C:* 30 minutes



Through dry IR medium 20 minutes

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

Total dry film build: 50 - 150 µm

Theoretical coverage: assuming 100% transfer efficiency and dry film thickness as indicated:

7 m²/l

REPAIR AND RECOATING



Sanding:

Essential before recoating to ensure good adhesion

P600 - P800 (wet)

P360 - P400 (dry)



Overcoat / recoat time:

- Force dry 60°C or IR

After cooling

- Air drying at 20°C

Minimum 2 hours

Overcoat with:

Deltron GRS topcoats, Envirobase

PERFORMANCE AND LIMITATIONS



Use only the hardener recommended on this data sheet.

Do not attempt spot repair on original or refinish TPA, lacquer, synthetic or 1K finishes.

EQUIPMENT CLEANING

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



HEALTH AND SAFETY

For comprehensive Health, Safety and Environmental advice, please refer to relevant Material Safety Data Sheets and product can labels.

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 experience and our policy of continuous product development.

Drying times quoted are average times at 20°C. Film thickness, humidity and shop 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 771547**

**International Sales
PPG Industries
Auto Refinish International,
Priory Road,
Warwick ,
CV34 4NA,
England.
Tel: +44 1926 403 255
Fax: +44 1926 410 249**