



**AUTO REFINISH**

**GLOBAL  
REFINISH  
SYSTEM**



# Product information

## **DELTRON D828**

*Non-Isocyanate 2K Primer - D828  
D828 2K Primer Activator - D829*

### **PRODUCT INFORMATION**

NCT Non-Isocyanate 2K Primer is a two-pack primer surfacer for use under Deltron topcoat colours. It can be used either as a primer-filler or as a primer-surfacer. It must be activated with D829 NCT Non-Isocyanate 2K Primer Activator.

### **PREPARATION OF SUBSTRATE**



#### **Substrate**

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

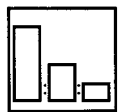
#### **Preparation**

Must be pre-primed  
Must be pre-primed  
Must be pre-primed  
Must be pre-primed  
P360 (dry) / P800 (wet)  
P280 - P360 (dry) / P400 - 500 (wet)  
P280 P320 (dry)



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

### **PRODUCT SET-UP**



	<i>Primer Filler</i>		<i>Primer Surfacer</i>	
<i>Mixing ratio:</i>	D828	4 vol	D828	4 vol
	D829	1 vol	D829	1 vol
			Thinner	1 vol

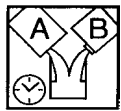
#### *Thinner selection:*

#### *Temperature*

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

#### *Thinner*

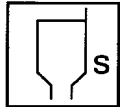
D808 Fast Thinner  
D866 2K Primer Thinner  
D812 Slow Thinner  
D869 Very slow thinner



#### *Potlife at 20°C:*

2 hours

3 hours



#### *Spray viscosity DIN4 at 20°C:*

20 - 22 seconds

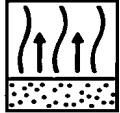
15 - 17 seconds

## APPLICATION, FLASH-OFF AND DRYING



	<i>Primer Filler</i>	<i>Primer Surfacer</i>
<i>Spraygun set-up:</i>		1.4 - 1.6 mm

<i>Number of coats:</i>	3 - 4	2 - 3
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<i>Flash-off at 20°C:</i>		
- <i>Between coats</i>		10 minutes
- <i>Before topcoating</i>		10 minutes



<i>Drying times:</i>		
- <i>Dustfree at 20°C</i>	15 minutes	10 minutes



- <i>Through dry at 20°C</i>	2.5 hours	2 hours
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- <i>Through dry at 60°C*</i>	30 minutes	20 minutes
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- <i>Through dry IR medium</i>	20 minutes	15 minutes
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\* Stoving times are for quoted metal temperature. Additional time should be allowed in the stoving schedule to allow metal to reach recommended temperature.

<i>Total dry film build:</i>	100 - 120 µm	50 - 75 µm
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<i>Theoretical coverage:</i>	Assuming 100% transfer efficiency and dry film thickness as indicated: 5 - 5.5 m <sup>2</sup> /l	? m <sup>2</sup> /l
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## REPAIR AND RECOATING



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



	<i>Primer Filler</i>	<i>Primer Surfacer</i>
<i>Overcoat / recoat time:</i>		
- <i>Force dry 60°C or IR</i>		After cooling
- <i>Air dry at 20°C</i>	Minimum 2.5 hours	2 hours

<i>Overcoat with:</i>	Deltron BC Deltron DG
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## PERFORMANCE AND LIMITATIONS

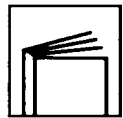


Use only the hardeners and thinners recommended on this data sheet.

Where humidity is in the range 70-80%, use of D869 Deltron Very Slow Thinner is recommended.

## **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.



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