



GLOBAL REFINISH
SYSTEM



June 2007

Product Information



D8077 / D8078 HS Wet on Wet Primers

*D8077 White 2K HS Wet on Wet primer
D8078 Grey 2K HS Wet on Wet primer
D8237 HS Express Hardener
D8238 HS Fast Hardener
D8239 HS Slow Hardener
D8427 HS Tinter for primers*

PRODUCT DESCRIPTION

D8077 and D8078 are fast drying 2-pack acrylic wet on wet primers, designed for use under Envirobase and Deltron Progress UHS to give excellent appearance and adhesion over a wide range of substrates. As Wet-on-wet primers, they provide a very fast repair process, particularly for new panel work.

The full range of GreyMatic shades can be achieved using D8077 / D8078 / D8427, to ensure that topcoat usage is optimised and opacity is reached in the minimum number of coats.

PREPARATION OF SUBSTRATE



In all cases, select the appropriate PPG cleaner(s).
See Technical Data Sheet: **Deltron Cleaners RLD63V**.
Ensure that the substrate is thoroughly cleaned and dried both before and after preparation work.



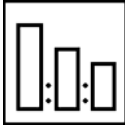
OE or existing paintwork should be sanded back to sound substrate layers using P320-360 grit discs (dry) or P600-800 grade paper (wet).
Any exposed bare metal should be spot primed with D831 Universel Chromate-free Wash Primer.
Primed surfaces should be sanded with P320 grit discs (dry) or P600 grade paper (wet).



MIXING RATIOS

Mixing Ratios with HS Hardener – Wet on Wet primer:

Mixing by Volume



D8077/8078 Primer	5 vols
HS Hardener	1 vol
Thinner*	2 vols

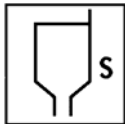
*See Hardener & thinner selection below.

MIXED PRODUCT DETAILS



Potlife at 20°C: 45 minutes.

Note: It is recommended to use the material immediately after mixing.



Spray Viscosity 16-18 seconds DIN4 @ 20°C

HARDENER AND THINNER SELECTION

<u>Temperature</u>	<u>HS Hardener</u>	<u>Thinner</u>
Up to 18°C	D8237	D8718 Fast Thinner
18°C - 25°C	D8238	D8719 Slow Thinner
Over 25°C	D8239	D8719 Slow Thinner

Note: These are recommendations only, as the size of repair will also affect choice of hardener and thinner.

APPLICATION AND FLASH OFF

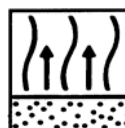


Spraygun set-up: 1.4 -1.6mm

Spray pressure: See spraygun manufacturers information



Number of coats: Apply 1 full single coat or 1 double coat to give a film thickness of 25-35 microns (1.0 - 1.4 thou.)



Flash-off at 20°C:

Before topcoat 15 - 20 minutes



SANDING TIMES

Normally D8077/D8078 primers do not require flattening and can be directly topcoated.
If some dirt inclusion occurs, light wet flattening/denibbing can be carried out after 15-20 minutes using P1200 or finer flattening paper.

OVERCOATING

D8077 / D8078 can be directly topcoated with Envirobase basecoat or Deltron Progress UHS Topcoat.

PERFORMANCE AND LIMITATIONS

Deltron Accelerators D818, D885 or D886, or D864 Accelerated Hardener, **must not** be used with D8077/ D8078. Part used cans of hardener must be carefully closed.

EQUIPMENT CLEANING

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

PAINTING PLASTICS

D8077/8078 may be applied over prepared painted or primed plastic.
If D8077/8078 is applied over a flexible plastic, e.g. PP/EPBM, PBT (Pocan), or PUR it must be mixed as follows:-

D8077/8078	5 parts
D814 Flexible additive for plastics	1 part

Then activate and thin in the normal manner.

Addition of D814 may lead to longer drying properties.

GREYMATICS

GreyMatic shades are selected according to topcoat colour. The recommended GreyMatic shade for any colour can be referenced in the PPG colour information systems.
If no GreyMatic shade is shown, then use GreyMatic 5 (D8078).

Addition of higher than recommended levels of D8427 HS Tinter for Primers should be avoided as this may lead to longer drying properties and potential recoat problems.

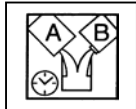
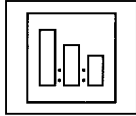
For each of the GreyMatic primer variants specified, the following mixing ratios apply:

	G1	G3	G5	G6	G7
D8077	100	80	0	0	0
D8078	0	20	100	97.5	87.5
D8427	0	0	0	2.5	12.5

These mixtures should then be activated and thinned in the normal way before spraying.



HS WET ON WET PRIMERS



Mixing ratio by volume

Wet on Wet 5 : 1 : 2

Pot Life at 20°C. 45 minutes

Hardener / Thinner Selection

<u>Temperature</u>	<u>HS Hardener</u>	<u>Thinner</u>
Up to 18°C	D8237	D8718 Medium Thinner
18°C - 25°C	D8238	D8719 Slow Thinner
Over 25°C	D8239	D8719 Slow Thinner

Note: These are recommendations only, as the size of repair will also affect hardener and thinner choice.

Application Parameters

DIN 4 @ 20°C 16 – 18 Seconds

Spraygun Sizes 1.4 – 1.6 mm fluid tip
Gravity gun recommended

Number of Coats 1 Full single coat or 1 Double coat

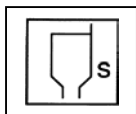
Drying Times

Dry to De-nib 15 - 20 minutes
Dry to topcoat 15 - 20 minutes

Topcoats

These primers may be overcoated with Deltron Progress UHS direct gloss or Envirobase basecoat.

(See the relevant topcoat TDS)



MIXING BY WEIGHT

Where a specific volume of primer is required, this may be best achieved by weight mixing using the guidelines below. The tables show weights for 5/1/2 mixing ratios.

WEIGHT ACTIVATION: Weights are in grams & cumulative. Do not tare the balance between additions.		5/1/2 MIXING RATIO			
Target Paint Volume (L)	0.20 L	0.40 L	0.60 L	0.80 L	1.00 L
Primer	190	380	570	760	950
HS Hardeners	215	430	645	860	1075
Thinner	256	512	768	1024	1280

VOC INFORMATION

The EU limit value for this product (product category: IIB.c) in ready to use form is max. 540g/litre of VOC. The VOC content of this product in ready to use form is max. 540g/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.

Note:

Combinations of this product with D814 will produce a paint film with special properties as defined by the EU Directive Code.

In these specific combinations: 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.

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

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