



AUTO REFINISH

GLOBAL
REFINISH
SYSTEM



Product information

Deltron D8120

High-solids Clear

PRODUCTS

Deltron Clear	D8120
Deltron Medium Solids Hardeners	D803, D841, D861, D864
Deltron Thinners	D808, D807, D812, D869
Deltron DG Fade-out Thinner	D868
Deltron Accelerator	D818

For matt, satin and textured finishes or painting of flexible substrates:

Deltron Matting Base	D759	to create a matt or satin appearance
Deltron Plasticiser	D814	to plasticise finishes over a flexible substrate
Deltron Matt Flexibiliser	D819	to create a matt or satin appearance over a flexible substrate
Deltron Texture Additive	D843	to create a fine textured 'suede' effect
Deltron Leather Grain Additive	D844	to create a coarser, more pronounced textured finish

PRODUCT DESCRIPTION

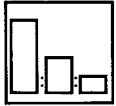
Deltron D8120 High Solids Clear is a premium quality high solids Acrylic clearcoat specifically formulated to give optimum gloss and durability when low-baked.

It is designed to be used over Deltron BC and Envirobase Colour.

PREPARATION OF SUBSTRATE

Deltron D8120 Clear must be applied on top of a clean and dust-free Deltron basecoat or Envirobase. The use of a tack rag is recommended.

PRODUCT SET-UP

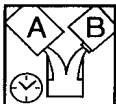


<i>Mixing ratio:</i>	D8120	3 vol
	MS Hardener	1 vol
	Thinner	0.5 vol

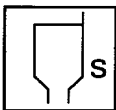
* Choose MS Hardener and Thinner according to application temperature:

<i>Temperature</i>	<i>MS Hardener</i>	<i>Thinner</i>
Up to 18°C	D803 Fast	D808
18°C - 25°C	D841 Medium	D807
Over 25°C	D861 Slow	D812

For exceptional conditions of temperature and humidity (> 35°C / >70%) the use of Very Slow Thinner D869 is recommended.



Potlife at 20°C: 2 hours



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

APPLICATION, FLASH-OFF AND DRYING



Spraygun set-up: 1.4 - 1.6 mm

Number of coats: 1 medium , 1 full



Flash-off at 20°C:

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



Drying times:*

- *Dust free at 20 °C* 40 minutes
- *Dry to handle at 20°C* 5-6 hours
- *Through dry at 20 °C* 18 hours
- *Through dry at 60°C* 30 minutes (D841)
- *Through dry at 70°C* 25 minutes



- *Through dry at IR Medium*

Dependent on colour of basecoat (darker colours require less time):

15 minutes

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

Drying times may be reduced still further by using the Deltron Accelerated System.

Total dry film build: 50 - 60 µm

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

7 - 7.5 m²/l

REPAIR AND RECOATING



- Sanding:** Essential before recoating to ensure good adhesion
- *Grade wet* P800
 - *Grade dry* P400



- Overcoat / recoat time:**
- *Force dry 60°C, 70°C or IR* after cooling
 - *Airdrying at 20°C* Minimum 14 hours

Overcoat with: Deltron primers
Envirobase
Deltron topcoats

MATT, SATIN AND TEXTURED FINISHES / PAINTING OF FLEXIBLE SUBSTRATES

To obtain a matt, semi-matt (satin) or textured finish with Deltron D8120 Clear, it is necessary to include suitable matt, flex or texture additives in the mix. Additives are also required when applying D8120 over a flexible substrate (typically plastics). The additives required and the appropriate volume and weight mix ratios are indicated in microfiches if relevant or in the tables below.

Note : **RIGID** substrates include all metals, fibreglass & GRP
FLEXIBLE substrates are all plastic types except GRP

Substrate	Appearance	D8120	D759	D843	D844	D814	D819	MS hardener	Deltron Thinner
RIGID	Gloss	3 vol	-	-	-	-	-	1 vol	0.5 vol
	Satin	3 vol	1,5 vol	-	-	-	-	1.5 vol	0.5 vol
	Matt	3 vol	3 vol	-	-	-	-	1.5 vol	1 vol
	Matt Textured	3 vol	-	3 vol	-	-	-	1.5 vol	1 vol
	Leather Grain	3 vol	-	-	1,5 vol	-	-	1.5 vol	0.5 vol
FLEXIBLE	Gloss	3 vol	-	-	-	1 vol	-	2 vol	0.5 vol
	Satin	4 vol	2 vol	-	-	-	2 vol	3.5 vol	0.5 vol
	Matt	4 vol	4 vol	-	-	-	2 vol	3.5 vol	1 vol
	Matt Textured	4 vol	-	4 vol	-	-	2 vol	3.5 vol	1 vol
	Leather Grain	4 vol	-	-	2 vol	-	2 vol	3.5 vol	0.5 vol

SPOT REPAIR PROCEDURE

- Apply Deltron D8120 HS Clear according to the 'Application, Flash-Off and Drying' section above.
- Leave to flash-off for 10 minutes / 20°C after the 2nd coat.
- A suitable quantity of activated and thinned D8120 HS Clear should then be reduced with Deltron DG Fade-Out Thinner D868 at a ratio of 1:3 (1 part activated and thinned clear to 3 parts D868).
- Apply this 1:3 mix over the repair area, using a reduced gun pressure to minimise overspray. Spray from the outside of the repair inwards, covering an area that extends beyond the edge of the initial application.
- After force-dry or IR, buff the repair edges.

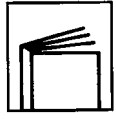
POLISHING



- Low-bake or IR force-drying:** Minimum 1 hour after cooling
- Airdrying at 20°C:** Minimum 24 hours after application

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 the 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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