



GLOBAL REFINISH
SYSTEM



May 2012

Product Information

GRS Deltron D800

Clear

PRODUCTS

Deltron Clear	D800
Deltron Medium Solids Hardeners	D803, D841, D861
Deltron Accelerated Medium Solids Hardener	D864
Deltron Standard Solids Hardener	D802,
Deltron Accelerated Standard Solids Hardener	D863
Deltron Thinners	D808, D807, D812
Deltron DG Fade-out Thinner	D868

For textured finishes or painting of flexible substrates:

Deltron Plasticiser	D814 to plasticise finishes over a flexible substrate
Deltron Matt Flexibiliser	D819 for textured 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 D800 is a high-performance two-pack acrylic urethane clearcoat designed for repair and re-spraying as part of a basecoat/clearcoat process.

The performance of Deltron D800 in a recommended PPG repair system meets or exceeds warranty requirements and the Deltron GRS system carries many OEM approvals.

Deltron D800 can be accelerated to maintain fast curing at low temperature, or to speed up process time for small to medium repairs in normal temperature conditions.

In order to accelerate the curing, Accelerated hardeners (D863 - D864)

D863 / D864 hardeners are used as replacements for Standard or MS hardeners in the Clear mix.

PREPARATION OF SUBSTRATE

Apply on top of a clean and dust free GRS Deltron basecoat (the use of a tack rag is recommended to remove dust from the basecoat film).

MIXING RATIOS

1. Mixing ratios with Standard System

	<u>By Volume</u>
D800	2 vol
D802	1 vol
Thinner**	1 vol*

2. Mixing ratios with MS System

	<u>By Volume</u>
D800	3 vol
MS Hardener**	1 vol
Thinner**	1 vol*

* For high build, use 0.5 vol.

** Choose MS Hardener and Thinner according to application temperature:

HARDENER AND THINNER SELECTION

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

MIXED PRODUCT DETAILS

	<i>Standard System</i>	<i>MS System</i>
Potlife at 20°C:	6 - 8 hours	6 hours
Spray viscosity at 20°C:	15 seconds DIN4	17 - 18 seconds DIN4

SPRAYGUN SET UP

1.4 - 1.8 mm Fluid Tip - Pressure as per manufacturers recommendations

NUMBER OF COATS

With NS Hardener, apply 1 light coat, followed by 2 full coats, to give a dry film thickness of 45 - 50 microns.

With MS Hardener, apply 1 medium coat followed by 1 full coat, to give a dry film thickness of 55 - 60 microns.

FLASH OFF AT 20°C

5 minutes between each coat. 10 minutes before stoving / baking.

DRYING TIMES**

Dust Free at 20°C	20 minutes with NS Hardener, 30 minutes with MS Hardener
Through dry at 20°C	20 hours with either NS or MS Hardener.
Through dry at 60°C*	30 minutes with either NS or MS Hardener
Infra Red Drying	10 - 15 minutes, depending upon colour.

* 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 further reduced by using the GRS Deltron accelerated systems.

Substitute D863 for D802 and dust free time is 10 minutes, Stoving at 60°C takes 20 minutes.

OVERCOATING/RECOATING

Overcoat / Recoat time - If Force dried, after cooling, or after Air drying at 20°C for 8 hours.

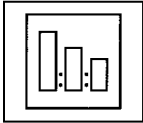
It is essential to sand before recoating to ensure good adhesion.

Sand with P800 (wet) or P400 (Dry).

Overcoat with - Any PPG 2K primer, GRS Deltron topcoats, or Envirobase.

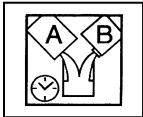
SPOT REPAIR PROCEDURE

- Apply GRS Deltron D800 according to the details given above.
- Leave to flash off for 10 minutes at 20°C after the second full coat.
- A suitable quantity of activated and thinned D800 should be further reduced with GRS Deltron DG Fade Out Thinner D868 at a ratio of 1:3 (1 part activated DG 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 drying or IR buff the repair edges.



Mixing by volume

With NS Hardener - 2:1:0.5 or 2:1:1
With MS Hardener - 3:1:0.5 or 3:1:1



Pot Life at 20°C 6 - 8 hours with D802, D803 or D841
Pot Life at 20°C 3 - 4 hours with D864, or D863

Hardener / Thinner Selection

Up to 18°C

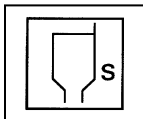
D803 MS Accelerated Hardener
D808 - Fast thinner

18 - 25°C

D841 MS Hardener
D807 Thinner

Over 25°C

D861 MS Hardener
D812 Slow thinner



Application viscosity

15 seconds DIN4 with NS hardeners
17 - 18 seconds DIN4 with MS hardeners



Spraygun Size

1.4 - 1.8 mm fluid tip



Number of Coats

1 light coat followed by 2 full coats with NS hardeners
1 medium coat followed by 1 full coat with MS hardeners



Drying Times

Dust Free - 20 minutes with NS hardeners,
30 minutes with MS hardeners

Through dry at 20°C - 20 hours

Through dry at 60°C - 30 minutes

(Can be reduced by using Accelerated System)

Deltron D800 Clearcoat – Accelerated Systems

MIXING RATIOS

1. Mixing Ratios with Standard System Hardener:

	<u>By Volume</u>
D800	2 vol
Standard Hardener	1 vol
Thinner*	1 vol*

2. Mixing Ratios with MS System:

	<u>By Volume</u>
D800	3 vol
MS hardener	1 vol
Thinner*	1 vol*

*For higher build,
use 0.5 vol thinner.

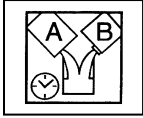
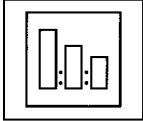
HARDENER AND THINNER SELECTION

Choose Thinner according to application temperature:

<u>Temperature</u>	<u>Thinner</u>
5°C - 18°C	D808
18°C - 25°C	D807

DRYING TIMES

	POTLIFE	DUST FREE time	TAPE FREE time			Stoving	
			10°C	15°C	20°C	50°C	60°C
D863	3 - 4 hours	10 min	7 hours	6 hours	5 hours	30 min	20 min
D864	5 hours	15 min			8 hours		25 min



Mixing by volume

With NS Hardener - 2:1:0.5 or 2:1:1
With MS Hardener - 3:1:0.5 or 3:1:1

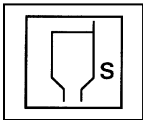
Pot Life at 20°C 3 - 4 hours with D863
Pot Life at 20°C 5 hours with D864

Hardener / Thinner Selection

Up to 18°C D803 MS Accelerated Hardener
D808 - Fast thinner

18 - 25°C D841 MS Hardener
D807 Thinner

Over 25°C D861 MS Hardener
D812 Slow thinner

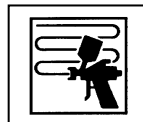


Application viscosity

15 seconds DIN4 with NS hardeners
17 - 18 seconds DIN4 with MS hardeners



Spraygun Size 1.4 - 1.8 mm fluid tip



Number of Coats

1 light coat followed by 2 full coats with NS hardeners
1 medium coat followed by 1 full coat with MS hardeners



Drying Times

Dust Free - 12 minutes with NS hardeners
15 minutes with MS hardeners

Through dry at 20°C - 5 hours
Through dry at 60°C - 15 - 25 minutes

PAINTING OF PLASTIC SUBSTRATES - TEXTURED FINISHES

To obtain a textured finish with Deltron D800 Clear, it is necessary to include flex or texture additives in the mix. Additives are also required when applying D800 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: The majority of plastics used on cars are considered **Rigid**. These plastics may have some flexibility when painted off the car, but are rigid once mounted. UHS Clearcoats only require the addition of the Plasticiser Additive (See **Flexible** chart below) when painting very flexible plastics, mostly found on older vehicles, e.g. foam type.

<u>Substrate</u>	<u>Appearance</u>	<u>D800</u>	<u>D843</u>	<u>D844</u>	<u>D814</u>	<u>D819</u>	<u>MS hardener</u>	<u>Deltron Thinner</u>
RIGID	Gloss	3 vol	-	-	-	-	1 vol	1 vol
	Matt Textured	3 vol	3 vol	-	-	-	1.5 vol	2 vol
	Leather Grain	3 vol	-	1.5 vol	-	-	1.5 vol	1 vol
FLEXIBLE	Gloss	3 vol	-	-	1 vol	-	2 vol	-
	Matt Textured	4 vol	4 vol	-	-	2 vol	3.5 vol	1.5 vol
	Leather Grain	4 vol	-	2 vol	-	2 vol	3.5 vol	0.5 vol

POLISHING



Low bake or IR force drying:

Minimum 1 hour after cooling

Air drying at 20°C

Minimum 20 hours after application

EQUIPMENT CLEANING

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

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: www.ppgrefinish.com

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 © 2012 PPG Industries, all rights reserved