



GLOBAL REFINISH
SYSTEM



April 2016

Product Information



GRS DELTRON® UHS Clearcoat D8140

D8140 UHS Clearcoat

PRODUCTS

<i>Deltron</i> UHS Clearcoat	D8140
<i>Deltron</i> Express UHS Hardener	D8236
<i>Deltron</i> UHS Hardeners	D8242, D8243, D8244

For textured finishes or painting of flexible substrates:

<i>Deltron</i> Plasticiser	D814 to plasticise finishes over a flexible substrate
<i>Deltron</i> Matt Flexibiliser	D819 for textured appearance over a flexible substrate
<i>Deltron</i> Texture Additive	D843 to create a fine textured 'suede' effect
<i>Deltron</i> Leather Grain Additive	D844 to create a coarser, more pronounced textured finish

PRODUCT DESCRIPTION

Deltron UHS Clearcoat D8140 is a 2K acrylic urethane clearcoat for the repair and repainting of panels originally finished with clearcoat over a single or multistage colour basecoat system.

D8140 is designed for use over ENVIROBASE® High Performance basecoat colour. It may be used in 2 different modes, standard 2 coat application, or a "One Visit" application, where 1 medium / continuous coat is followed by a full coat with no flash off between coats. This Product is designed to be mixed with Hardener only. No thinners are required.

PREPARATION OF SUBSTRATE

Deltron D8140 Clear must be applied on top of clean and dust-free Envirobase basecoat. The use of a tack rag is recommended.

MIXING RATIO

Mixing ratios with HS Hardener:

	<u>By Volume</u>	<u>By Weight</u>
D8140	2 vol	See page 5
D8236/8242/8243/8244	1 vol	

- As with all ultra high solids products, cold ready for use paint temperatures can lead to more difficult application and overspray absorption. It is strongly recommended that ready for use product is applied at a temperature greater than 15°C
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HARDENER SELECTION

<u>UHS Hardener</u>	<u>Application Temperature</u>
D8236	Up to 22°C
D8242	22°C to 25°C
D8243	25°C to 30°C
D8244	Above 30°C

D8243 is the recommended Hardener choice in a Low Bake environment for optimum performance of D8130 up to 30°C application temperature. D8236/42 can be used but will not provide drying benefits over D8243 in these situations, and is best suited to an air dry process.

MIXED PRODUCT DETAILS

Potlife at 20°C: 1 hour with D8236 hardener
1.5 hours with D8242/8243/8244 hardeners

Spray viscosity at 20°C 17-19 seconds DIN4.

APPLICATION AND FLASHOFF



Spraygun set-up: 1.3 - 1.4 mm

Express Single Visit Process - Recommended

Application Apply 1 medium & 1 full coat to give 50-60 microns dry film build.

The first coat should be applied to all repair panels before the second coat is applied.

Flash off between spray coats For less than 3 panels, 2-3 minutes flash off.

For more than 3 panels, no flash off is required.

Flash off before bake or IR dry 0 – 5 minutes

Conventional Two Coat Process

Application Apply 2 single coats to give ~60 microns dry film build.

Flash off between spray coats 5 – 7 minutes

Flash off before bake or IR dry 0 – 5 minutes



DRYING TIMES

- Through dry at 60°C* 25 minutes with D8236

30 minutes with D8243

30 minutes with D8242

35 minutes with D8244

- Through dry at 20°C 16-20 hours with D8236/D8242

- Through dry at IR (medium wave) 8 - 15 minutes (depending upon colour)



Bake times are for quoted metal temperature. Additional time should be allowed in the bake schedule to allow metal to reach recommended temperature.

Total dry film build: 50 – 60 µm

Theoretical coverage: Assuming 100% transfer efficiency and dry film thickness as indicated: 8 m²/l

REPAIR AND RECOATING

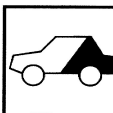


Sanding: Essential before recoating to ensure good adhesion

- grade wet P800

- grade dry P400 - P500

Overcoat / Re-coat time:



- Force dry at 60°C, 70°C or IR After cooling

- Air drying at 20°C 16-20 hours

Overcoat with: PPG 2K Primers, *Envirobase* High Performance, *Deltron* GRS Topcoats



PAINTING OF PLASTIC SUBSTRATES - TEXTURED FINISHES

To obtain a textured finish with *Deltron* D8140 UHS Clearcoat, it is necessary to include flex or texture additives in the mix. Additives are also required when applying D8140 over a flexible substrate. The additives required and the appropriate volume and/or 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.

Cumulative Mixing by Weight

Do not tare the balance between additions

<i>Substrate</i>	<i>Appearance</i>	<i>D8140</i>	<i>D843</i>	<i>D844</i>	<i>D814</i>	<i>D819</i>	UHS Hardeners	<i>Thinner GRS Deltron</i>
RIGID	Gloss	648g	-	-	-	-	978g	-
	Matt Textured	299g	672g	-	-	-	824g	959g
	Leather Grain	417g	-	756g	-	-	968g	-
FLEXIBLE	Gloss	616g	-	-	740g	-	977g	-
	Matt Textured	208g	520g	-	-	632g	897g	975g
	Leather Grain	271g	-	492g	-	638g	983g	-

POLISHING



If polishing is required, i.e. to remove dirt nibs, it is recommended that it is carried out between 1 hour and 24 hours after the quoted drying time.
Use PPG Specialty Polishing system SPP1001.



FADE - OUT REPAIR PROCEDURE

- Apply D8140 UHS Clearcoat according to the information above
- Take care to minimise the clearcoat edge in the fade-out area
- Melt overspray edge using D8731 Aerosol Spot Blender or D8430 Spot Blender.
- Refer to datasheet No: RLD 299V for successful repair.

WEIGHT MIX TABLE FOR D8140

GUIDELINES FOR WEIGHT MIXING

Where a specific volume of clearcoat mix is required, this may be best achieved by weight mixing, using the guidelines below.

The weights are cumulative - please do **NOT** tare the balance between additions.

Target Volume of RFU Paint required (Litres)	Weight UHS Clearcoat D8140	Weight UHS Hardeners
0.10 L	64 g	97 g
0.20 L	128 g	194 g
0.25 L	160 g	243 g
0.33 L	211 g	320 g
0.50 L	324 g	489 g
0.75 L	480 g	728 g
1.00 L	640 g	970 g
1.50 L	960 g	1455 g
2.00 L	1280 g	1940 g
2.50 L	1600 g	2425 g



EQUIPMENT CLEANING

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

VOC INFORMATION

The EU limit value for this product (product category: IIB.d) in ready to use form is max. 420g/litre of VOC. The VOC content of this product in ready to use form is max. 420g/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 D814, D819, D843 or D844 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: www.ppgrefinish.com

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