

## Plastic Adhesion Promoter

EU-99

# D820



GLOBAL REFINISH  
SYSTEM™

### Product Description:

GLOBAL REFINISH SYSTEM™ D820 Plastic Adhesion Promoter is for use on the variety of plastic substrates found on motor vehicles. D820 provides adhesion for subsequent *Global Refinish System* 2K primers and topcoats or CONCEPT® DCC Acrylic Urethane.

### Preparation of Substrate:



- Wash all surfaces to be painted with soap and water. Degrease all surfaces with D846 Degreasing Agent for Plastics (see EU-134 *Global Refinish System* Cleaners bulletin for usage instructions).
- Wash off residue and dry thoroughly before cleaning with appropriate *Global Refinish System* substrate cleaner. The use of a tack rag is recommended.
- Wet flat with European P600 / US 400 grade paper (use finer grit paper for softer plastics), and clean again with D846 Degreasing Agent for Plastics.

## D820

### Mix Ratios:



D820 Plastic Adhesion Promoter is ready-to-spray, no thinning is necessary.  
Always shake well before using.

### Pot Life:



None

### Additives:



None

### Spraygun Setup:



**Fluid Tip:** 1.3-1.5 mm or equivalent

### Spray Pressure:

**HVLP:** 7-10 psi at the air cap  
**Compliant:** 29-40 psi at the gun

*Note: For best overall results, refer to spraygun manufacturer's recommendations for inlet air pressures.*

### Number of Coats:



**Apply:** 1 wet coat

**Total wet film build per coat:** 0.4 mils

**Total dry film build per coat:** 0.2 mils

**NOTE:** Avoid high film builds

### Drying Times:



**Before Topcoat:** 30 minutes  
68°F (20°C)



**Dust Free:** 2 minutes  
68°F (20°C)

**Dry to Handle:** 15 minutes  
68°F (20°C)

**Through Dry Time:** 30 minutes  
68°F (20°C)



**Force Dry\*:** 15 minutes  
140°F (60°C)

*\*Force dry times are quoted for metal temperature. Additional time should be allowed in the force drying schedule to allow metal to reach recommended temperature.*

### Overcoat/Recoat:



**Overcoat/Recoat Time:** 30 minutes minimum at 68°F (20°C)  
24 hours maximum at 68°F (20°C)  
After force dry and cool down

**Grade Wet:** N/A

**Grade Dry:** N/A



**Overcoat with:** Global Refinish System 2K primer sealer (except D831) or Concept DCC Acrylic Urethane.

## D820

### Technical Data:

<b>Total dry film build:</b>	
Minimum:	0.2 mils
Maximum:	0.2 mils
Recommended film build per wet coat:	0.4 mils
Recommended dried film build per coat:	0.2 mils

RTS Combinations	D820
Volume Ratio	As Is
Applicable Use Category	Adhesion Promoter / Specialty Coating
VOC Actual g/L	835
VOC Actual lbs./ US gal.	6.97
VOC Regulatory (less water less exempts) g/L	835
VOC Regulatory (less water less exempts) lbs./ US gal	6.97
Density g/L	868
Density lbs./ US gal	7.24
Volatiles wt. %	96.2
Water wt. %	0.0
Exempt wt. %	0.0
Water vol. %	0.0
Exempt vol. %	0.0
Solids wt. %	3.8
Solids vol. %	3.1
Sq. Ft. Coverage / US gal. 0.2 mil dry film thickness	249

### Health and Safety:



- The contents of this package may have to be blended with other components before the product can be used. Before opening the packages, be sure you understand the warning messages on the labels and SDS's of all the components, since the mixture will have the hazards of all of its parts.
- Improper handling and use, for example, poor spray technique, inadequate engineering controls and/or lack of proper Personal Protective Equipment (PPE), may result in hazardous conditions or injury.
- Follow spray equipment manufacturer's instructions to prevent personal injury or fire.
- Provide adequate ventilation for health and fire hazard control.
- Follow company policy, product SDS and respirator manufacturer's recommendations for selection and proper use of respiratory protection. Be sure employees are adequately trained on the safe use of respirators per company and regulatory requirements.
- Wear appropriate PPE such as eye and skin protection. In the event of injury, see first aid procedures on SDS.
- Always observe all applicable precautions and follow good safety and hygiene practices.

**See Safety Data Sheet and Labels for additional safety information and handling instructions.**

**Important:** The contents of this package must be blended with other components before the product can be used. Before opening the packages, be sure you understand the warning messages on the labels of all components since the mixture will have the hazards of all its parts. Improper spray technique may result in a hazardous condition. Follow spray equipment manufacturer's instructions to prevent personal injury or fire. Follow directions for respirator use. Wear eye and skin protection. Observe all applicable precautions.

#### EMERGENCY MEDICAL OR SPILL CONTROL INFORMATION (412) 434-4515; IN CANADA (514) 645-1320

Materials described are designed for application by professional, trained personnel using proper equipment and are not intended for sale to the public. Products mentioned may be hazardous and should only be used according to direction, while observing precautions and warning statements listed on label. Statements and methods described are based upon the best information and practices known to PPG Industries. Procedures for applications mentioned are suggestions only and are not to be construed as representations or warranties as to performance, results, or fitness for any intended use, nor does PPG Industries warrant freedom from patent infringement in the use of any formula or process set forth herein.

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













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Product Information Effective 12/15

## Plastic Adhesion Promoter

<b>Mix:</b>	D820 is Ready-to-spray	
		
<b>Additives:</b>	None	
		
<b>Pot Life:</b>	None	
		
<b>Gun Setup:</b>	Fluid Tip: HVLP: Compliant:	
	1.3-1.5 mm or equivalent 7-10 psi at the air cap 29-40 psi at the gun	
<b>Application:</b>	Apply:	
	1 wet coat	
<b>Dry Times:</b>		
	Dust Free:	2 minutes at 68°F (20°C)
	Dry to Handle:	15 minutes at 68°F (20°C)
	Through Dry:	30 minutes at 68°F (20°C)
	Force Dry:**	15 minutes at 140°F (60°C)
	Dry to Topcoat:	30 minutes minimum at 68°F (20°C) 24 hours maximum After force dry and cool down
	Grade Wet: Grade Dry:	N/A N/A
	Overcoat With:	Global Refinish System 2K primer sealers (except D831) or Concept DCC Acrylic Urethane.

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