Anti-Corrosion Etch Primer EU-133

D8099

GLOBAL REFINISH SYSTEM™

Product Description:

GLOBAL REFINISH SYSTEM™ D8099 is an Anti-Corrosion Etch Primer specifically designed to provide excellent adhesion and corrosion resistance to properly prepared steel and aluminum while offering fast drying characteristics.

D8099 also serves as a pretreatment coating in areas where VOC compliance is required.

D8099 must be mixed with D8299 Anti-Corrosion Etch Primer Catalyst.

Preparation of Substrate:

- Wash all surfaces to be painted with soap and water. Degrease all surfaces with appropriate *Global Refinish System* substrate cleaner. See GLG-152 *Global Refinish System* Cleaners bulletin for selection and usage instructions.
- Aluminum, Bare Steel, and Galvanized Steel must be clean, rust-free and abraded thoroughly using European P180-P280 / US 180-240 grit paper.
- D8099 is not recommended for use on fiberglass. In cases where D8099 is being applied to bare metal that is adjacent to fiberglass, a slight overlap is acceptable only where the fiberglass substrate has been properly scuffed and cleaned.

Required Products

Catalyst

D8299 Anti-Corrosion Etch Primer Catalyst

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Mix Ratios:

D8099 Anti-Corrosion Etch Primer: 1 vol.
D8299 Anti-Corrosion Etch Primer Catalyst: 1 vol.

To avoid poor adhesion and drying characteristics, do not apply excessive film builds.

Pot Life:

24 hour at 68°F (20°C)

Additives:

None

Spraygun Setup:

Fluid Tip: 1.3-1.5 mm or equivalent
Spray Viscosity: 17 seconds #2 ZAHN at 68°F (20°C)

Spray Pressure:

HVLP: 4 bar / 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 even coat

Total wet film build per coat: 2.0-5.0 mils
Total dry film build per coat: 0.2-0.3 mils

Drying Times:

Before Topcoating: 10 minutes
68°F (20°C)

Dust Free: 5 minutes
68°F (20°C)

Dry to Handle: 15 minutes
68°F (20°C)

Tape Time: 30 minutes
68°F (20°C)

Dry to Sand: 30 minutes
68°F (20°C)

Before Stoving: 5 minutes purge time before stoving
68°F (20°C)

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

Force Dry to Sand**: 10 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.*

Warning: *Chrome dust is hazardous. Be sure to wear adequate respiratory equipment while sanding or spraying. See the warnings on the label and SDS for additional information.*

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Overcoat/Recoat

Dry to topcoat: 10 minutes minimum, 24 hours maximum.
After 24 hours, lightly scuff D8099.
Always maintain a minimum film build of 0.2 mil.
Recoat with additional D8099 if necessary.

Grade Wet: European P800 / US 500
Grade Dry: European P600/ US 400

Overcoat with: D8099 must be overcoated with a recommended 2K surfacer or sealer before any topcoat application.

Technical Data:

Total dry film build:

Minimum:	5.0µ / 0.2 mils
Maximum:	10µ / 0.4 mils
Recommended film build per wet coat:	75.0µ / 3.0 mils
Recommended dried film build per coat:	5.0µ / 0.2 mils

RTS Combinations	**D8099 : D8299**
Volume Ratio	1 : 1
Coating Category	Pretreatment Coating
VOC Regulatory (less water less exempts) g/L	777
VOC Regulatory (less water less exempts) lbs./ US gal	6.48
Solids wt. %	10.9
Solids vol. %	5.8%
Sq. Ft. Coverage / US gal. 0.4 mils dry at 100% transfer efficiency	229
m^2 per litre coverage giving 10µm (0.4 mils) dry	5.7

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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Product Information Effective 12/15

D8099 AT A GLANCE EU-133

Anti-Corrosion Etch Primer

Mix:

D8099		D8299 Catalyst
1	:	1

Catalyst
D8299 Anti-Corrosion Etch Primer Catalyst

Additives:

None

Pot Life:

24 hours at 68°F (20°C)

Air Pressure:

HVLP:	4 bar / 10 psi at the air cap
Compliant:	29-40 psi at the gun
Fluid Tip:	1.3-1.5 mm or equivalent
Viscosity:	17 seconds #2 ZAHN at 68°F (20°C)

Application:

Apply:	1 even coats
Before Topcoating:	10 minutes at 68°F (20°C)

Dry Times:

Dust Free:	5 minutes at 68°F (20°C)
Dry to Handle:	15 minutes at 68°F (20°C)
Tape Time:	30 minutes at 68°F (20°C)
Air Dry to Sand:	30 minutes at 68°F (20°C)

*Force Dry:***	5 minutes purge before stoving 15 minutes at 140°F (60°C) to tape 10 minutes at 140°F (60°C) to sand

Warning: *Chrome dust is hazardous. Be sure to wear adequate respiratory equipment while sanding or spraying. See the warnings on the label and MSDS for additional information.*

Dry to Topcoat:	10 minutes minimum, 24 hours maximum. After 24 hours, lightly scuff D8099. Always maintain a minimum film build of 0.2 mil. Recoat with additional D8099 if necessary.

Grade Wet:	European P800 / US 500
Grade Dry:	European P600/ US 400

D8099 must be overcoated with a recommended *2K* surfacer or sealer before any topcoat applications.

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