

2K AChromatic Surfacer (National Rule)

EU-137



D8001/D8005/D8007

GLOBAL REFINISH SYSTEM™

Product Description:

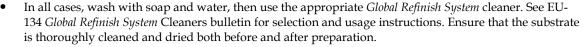
GLOBAL REFINISH SYSTEM™ 2K A-Chromatic Surfacers (D8001 White, D8005 Gray, D8007 Black) are premium quality primer surfacers suitable for the wide range of repair work done in today's refinish body shops.

2K A-Chromatic Surfacers offer excellent adhesion, film build, surface leveling and gloss holdout over a wide range of substrates. A variety of 2K A-Chromatic Surfacer grays can be achieved by intermixing the white, gray and black surfacers.

This versatile, quick drying, easy to apply and sand primer may be applied as a conventional spray filler or primer surfacer.

Preparation of Substrate:







Original Paintwork should be sanded using European P280 / US 240 grit discs (dry) or European P360 / US 320 grade paper (wet). Exposed bare metal should be spot-primed with a suitable bare metal primer (see below).

Electrodeposition Primer must be thoroughly cleaned as outline above. When using the 2K A-Chromatic



Surfacer as a spray filler or primer surfacer, abrade the electrodeposition primer as recommended in the "original paintwork" section.

• Aluminum, Bare Steel and Galvanized Steel must be clean, rust-free and abraded thoroughly using



- European P180-P280 / US 180-240 grit paper and primed with D831 Chromate-Free Wash Primer or D8099 Anti-Corrosion Etch Primer after sanding.
- <u>Polyester Body Fillers</u> should be dry sanded using European P180 / US 180 grit paper followed by European P280 / US 240 grit paper.
- Fibre Glass and SMC should be dry sanded using European P280 / US 240 grit paper.
- <u>Plastic</u> should be dry sanded with European P600 / US 400 grit paper (use a finer grit for softer plastics) and prime first with D820 Plastic Adhesion Promoter.

Required Products

Hardener	Thinner			
D8291 2K Chromatic Hardener	D870 Fast Thinner 60-65°F (15-18°C)			
	D871 Medium Thinner 65-77°F (18-25°C)			
	D872 Slow Thinner 77-95°F (25-35°C)			
	D873 Very Slow Thinner Over 95°F (35°C)			

Mix Ratios:



Spray Filler Optimum Film Build

D800x 2K Surfacer: 4 vols. D8291 2K Hardener: 1 vol. D Series Thinner:



Primer Surfacer* Optimum Drying Speed

D800x 2K Surfacer: 4 vols. D8291 2K Hardener: 1 vol. D-Series Thinner: 1 vol.

Pot Life:



30 minutes at 68°F (20°C) Spray Filler: Primer Surfacer: 1 hour at 68°F (20°C)

Additives:



SL84 Accelerator: may add up to 1 oz. to RTS quart of the Primer Surfacer if desired

D814 Plasticiser: 10% to RTS volume SL814 Universal Flexibilizer: 10% to RTS volume

Spraygun Setup:



Spray Filler Primer Surfacer Fluid Tip:

1.7-2.0 mm or equivalent 1.6-1.8 mm or equivalent

Spray Pressure:

HVLP: Compliant:

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

10 psi at the air cap

29-40 psi at the gun

Number of Coats:



Primer Surfacer Spray Filler Apply: up to a maximum of 4 wet coats 2-3 wet coats

Total wet film build per coat: 5.0 mils (127.0 μ) 4.0 mils (101.6 μ) Total dry film build per coat: 2.0 mils (50.8 µ) 1.5 mils (38.1 µ)

Drying Times:



Spray Filler Primer Surfacer

68°F (20°C) 5-10 minutes 5-10 minutes

Dust Free:

68°F (20°C) 15 minutes 15 minutes

Dry to Handle:

Between Coats:

68°F (20°C) 60 minutes 60 minutes

Air Dry to Sand:

68°F (20°C) 6 hours dry, preferably overnight 1½ hours

Force Dry*: N/A 10 minutes flash before stoving

140°F (60°C) Do not force dry 30 minutes*

IR:

Medium wave: Do not force dry 20 minutes Short wave: Do not force dry 10 minutes

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

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Overcoat/Recoat:







6 hours and after sanding $$1\frac{1}{2}$$ hours (or after sanding) N/A after bake and cool down cycle

(or after sanding)



Grade Wet: Grade Dry: European P600 / US 400 followed by European P1200 / US 600 European P360 / US 320 followed by European P1000 / US 500

Overcoat with: Global Refinish System BC, CONCEPT® DCC Acrylic Urethane or

ENVIROBASE® High Performance topcoat

Technical Data:

	<u>Spray Filler</u>	<u>Primer Surfacer</u>
Minimum after sanding:	2.0 mils (50.8 μ)	2.0 mils (50.8 μ)
Maximum after sanding:	10.0 mils (254.0 μ)	6.0 mils (152.4 μ)
Film build per wet coat:	4.0 mils (101.6 μ)	4.0 mils (101.6 μ)
Dried film build per coat:	1.5 mils (38.1 μ)	1.5 mils (38.1 μ)

RTS Combinations	D800x : D8291	D800x : D8291 : D870		
Volume Ratio	4:1	4:1:1		
VOC Actual g/L	504	564		
VOC Actual lbs./ US gal	4.20	4.69		
VOC Regulatory g/L	504	564		
VOC Regulatory lbs./ US Gal	4.20	4.69		
Solids wt. %	63.5	56.6		
Solids vol. %	42.4	35.3		
Theoretical Coverage - Sq. Ft. / US gal. RTS 1.0 mil dry film thickness	680	566		

Performance Guidelines:

The use of HVLP spray equipment can give an increase in transfer efficiency of about 25% depending on the make and model of equipment used.

When **Spot Priming** 2K A-Chromatic Surfacers adopt the following procedures:

- Thoroughly sand the surface to the edge of the panel or an inch or two beyond the damaged area whichever is smaller.
- After applying the material and allowing it to dry as normal, be careful to thoroughly level the repaired edge when sanding.
- Do not attempt a spot repair on original or refinish thermoplastic applications, lacquer or 1K finishes. Also, 2K A-Chromatic Surfacer and its ancillaries are sensitive to moisture so all equipment must be perfectly dry. Partially used cans of hardener must be carefully closed.

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AChromatic Gray Mixing Chart

2K AChromatic Surfacer

This chart can be used to mix the 2K A-Chromatic Surfacer.

The G1-G7 ratios will help to achieve better hiding when used as a guide for mixing the 2K A-Chromatic Surfacer.

Mix Ratio By Volume			Mix Ratio By Cumulative Weight							
				Gra	ams		Parts			
	Mix Ratio)	1/4 Pint	½ Pint	Pint	Quart	1/4 Pint	½ Pint	Pint	Quart
G1	D8001	4	120	240	483	974	136	271	546	1101
	D8291	1	139	278	560	1129	157	314	633	1276
	D870	1	156	311	627	1264	176	351	708	1428
G3	D8001	3	90	180	362	730	102	203	409	825
	D8005	1	119	238	480	969	134	269	542	1095
	D8291	1	138	276	557	1124	156	312	629	1270
	D870	1	155	310	624	1259	175	350	705	1423
G5	D8005	4	118	235	474	954	133	265	536	1078
	D8291	1	137	273	550	1109	155	308	621	1253
	D870	1	153	306	617	1244	173	346	697	1406
G6	D8005	- N/A	40	79	158	318	45	89	178	359
	D8007		114	227	457	921	129	257	516	1041
	D8291		133	265	533	1076	150	299	602	1216
	D870		149	298	601	1211	168	337	679	1368
G7	D8007	4	111	222	448	903	125	251	506	1020
	D8291	1	130	261	525	1058	147	295	593	1195
	D870	1	147	294	592	1193	166	332	669	1348

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Health and Safety:

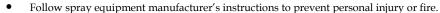
See Safety Data Sheet and Labels for additional safety information and handling instructions.



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.





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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2K A-Chromatic Surfacer

Mix:

Spray Filler Optimum Film Build

D800x Surfacer: 4 vols. D8291 Hardener: 1 vol.

Primer Surfacer* Optimum Drying Speed

D800x Surfacer: 4 vols.
D8291 Hardener: 1 vol.
D Series Thinner: 1 vol.

Hardener Thinner

D8291 2K Chromatic Hardener D870 Fast Thinner 60-65°F (15-18°C)

D871 Medium Thinner 65-77°F (18-25°C) D872 Slow Thinner 77-95°F (25-35°C) D873 Very Slow Thinner Over 95°F (35°C)

Additives:

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SL84 Accelerator: may add up to 1 oz. to RTS quart of the Primer Surfacer

D814 Plasticiser: 10% to RTS volume

SL814 Universal Flexibilizer: 10% to RTS volume

Pot Life:



Spray Filler: 30 minutes at 68°F (20°C)
Primer Surfacer: 1 hour at 68°F (20°C)

Gun Setup:



Spray FillerPrimer SurfacerHVLP:10 psi at the air cap10 psi at the air capCompliant:29 - 40 psi at the gun29 - 40 psi at the gunFluid Tip:1.7-2.0 mm or equivalent1.6-1.8 mm or equivalent

Application



Apply: up to a max of 4 wet coats 2-3 wet coats

Dry Times:



Flash Time: 5-10 minutes at 68°F (20°C) 5-10 minutes at 68°F (20°C)



Dust Free: 15 minutes at 68°F (20°C) 15 minutes at 68°F (20°C)

Dry to Handle: 60 minutes at 68°F (20°C) 60 minutes at 68°F (20°C)

Air Dry to Sand: 6 hours at 68°F (20°C) 1½ hours at 68°F (20°C)

(preferably overnight)



Force Dry:** N/A 10 minutes purge

Do not force dry 30 minutes at 140°F (60°C)

IR: Medium Wave Do not force dry 20 minutesShort Wave Do not force dry 10 minutes

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Air To Topcoat: 6 hours and after sanding 1½ hours at 68°F (20°C)

Force Dry Topcoat: N/A after bake and cool down cycle (or after sanding)

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