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:

- In all cases, wash with soap and water, then use the appropriate *Global Refinish System* cleaner. See EU-134 *Global Refinish System* Cleaners bulletin for selection and usage instructions. Ensure that the substrate is thoroughly cleaned and dried both before and after preparation.
- **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.
- **Polyester Body Fillers** 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.
- **Plastic** 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
D8291 2K Chromatic Hardener

Thinner
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)

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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:

Spray Filler:	30 minutes at 68°F (20°C)
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:	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:

	Spray Filler	***Primer Surfacer***
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***
Between Coats: 68°F (20°C)	5-10 minutes	5-10 minutes
Dust Free: 68°F (20°C)	15 minutes	15 minutes
Dry to Handle: 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*: 140°F (60°C)	N/A Do not force dry	10 minutes flash before stoving 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:

	Spray Filler	*Primer Surfacer*
Dry to Topcoat:		
68°F (20°C)	6 hours and after sanding	1½ hours (or after sanding)
140°F (60°C)	N/A	after bake and cool down cycle (or after sanding)
Grade Wet:	European P600 / US 400 followed by European P1200 / US 600	
Grade Dry:	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:

	Spray Filler	*Primer Surfacer*
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							
			Grams				Parts			
	Mix Ratio		¼ Pint	½ Pint	Pint	Quart	¼ 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.
- 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.

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

PPG Automotive Refinish
19699 Progress Drive
Strongsville, OH 44149
800.647.6050

PPG Canada Inc.
2301 Royal Windsor Drive, Unit #6
Mississauga, Ontario L5J 1K5
888.310.4762

Follow us online:
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Spray Filler Optimum Film Build

D800x Surfacer:	4 vols.
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Hardener

D8291 2K Chromatic Hardener

Thinner

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Primer Surfacer:	1 hour at 68°F (20°C)

		Spray Filler	***Primer Surfacer***
Gun Setup:			
	HVLP:	10 psi at the air cap	10 psi at the air cap
	Compliant:	29 - 40 psi at the gun	29 - 40 psi at the gun
	Fluid Tip:	1.7-2.0 mm or equivalent	1.6-1.8 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) (preferably overnight)	1½ hours at 68°F (20°C)
	*Force Dry:***	N/A Do not force dry	10 minutes purge 30 minutes at 140°F (60°C)
	IR: *Medium Wave*	Do not force dry	20 minutes
	Short Wave	Do not force dry	10 minutes
	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.*