



GLOBAL REFINISH
SYSTEM

Product Information

D8113 Matt Clearcoat

Product Description

D8113 is a premium two component acrylic urethane clearcoat designed specifically to deliver a matt appearance for the specialized repairs of vehicles originally finished with a matt clearcoat.

The **Matt Finishing Process** has been specifically optimized to repair large matt areas and is designed to ensure a completely even matt finish. D8113 may be used over rigid plastics without the need for special additives.

D8113 Matt Clearcoat may be used over PPG's Envirobase High Performance (EHP) or Global (BC) basecoat systems.

For detailed, OEM specific repair process recommendations, refer to Technical Bulletins from PPG Industries.

Preparation of Substrate



D8113 Clear must be applied on top of a clean and dust-free basecoat. The use of a tack cloth is recommended.



Wash all surfaces to be painted with soap and water and then apply the appropriate Global cleaner. See EU134 Global Cleaners for selection and usage instructions. Ensure that the substrate is thoroughly cleaned and dried, both before and after application work.



Wet sand with European U.S. 500-600 / P800-1200 grade paper or dry sand with U.S. 400-500 / European P600-800 grade paper.

Wash off residue and dry thoroughly before re-cleaning with the appropriate Global substrate cleaner. The use of a tack rag is recommended.

APPLICATION GUIDE:

Mix Ratio:

D8113 Matt Clear : 3 vols
D8239 Hardener : 1 vol
D871 / D872 Thinner : 1½ vols



Potlife @ 70°F (20°C) : 4 hours

Mixing by Weight:

Cumulative Weight		1 Pint		1 Quart		2 Quarts		1 Gallon	
		Parts	Grams	Parts	Grams	Parts	Grams	Parts	Grams
D8113	3	306.4	272.0	612.7	543.9	1225.4	1087.8	2450.9	2175.7
D8239	1	406.4	360.7	812.8	721.5	1625.6	1443.0	3251.1	2886.0
D871 / D872	1 ½	529.5	470.0	1058.9	940.0	2117.9	1880.0	4235.8	3760.1

Additives:

None

Spraygun Set-up:

Fluid Tip 1.2 - 1.4 mm or equivalent
Spray Viscosity 16 -19 seconds DIN4

Spray Pressure:

HVLP at air cap 10 PSI at the cap
Conventional at spray gun 45 - 55 PSI at the gun

Application Process:

The preparation of color test panels to check the color and number of coats of clearcoat to achieve the correct matt effect is strongly recommended. The original matt finish can sometimes become less matt over time due to weathering and cleaning processes used by car owners. D8113 can be used to achieve these gloss levels by applying an additional coat.

Notes: No Fade-out process is possible for matt colors.

*The clearcoat can be de-nibbed to remove minor dirt inclusions after the flash off time between coats listed below. Any de-nibbing must be completed before the final coat of matt clearcoat is applied. **Dirt removal from the final Matt Finish is not possible.***



Conventional Two Coat Process

Application: Apply 2 single coats to achieve 2.0 - 2.5 mils dry film build

Flash off between coats: 5 – 10 minutes – for best results, allow to dry matt

Flash off before bake or IR dry: 5 – 10 minutes – for best results, allow to dry matt

For optimum results on large horizontal surfaces, allow 10 minutes between the first and second coat. 1 minute after the second coat, apply a low pressure “drop coat” into the wet film

Flash off at 70°F (21°C)



5 – 10 minutes ensuring the clearcoat is **completely matt** before baking.

Drying Times:



Dust-free:
70°F (21°C) 45minutes

Dry to handle:
70°F (21°C) 12-16 hours
140°F (60°C) After cool down



Tape Time:
70°F (21°C) 12-16 hours
140°F (60°C) After cool down



Through Dry:*
70°F (21°C) 24 hours
140°F (60°C) 60 minutes



IR (infrared):*
Medium wave 15-20 minutes
Short wave 8-15 minutes

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

Overcoat/Recoat:

Sanding: Must be sanded before recoating to ensure proper adhesion

Grade wet P800

Grade Dry P400-P500

Overcoat/Recoat Time:
Air Dry at 70°F (21°C) 12 hours

*Force Dry at 140°F (60°C),
or IR* After cooling

Overcoat with: *Envirobase High Performance or Global BC Basecoat Color Systems*

Performance Guidelines:

The Gloss levels achieved with this clear may vary depending upon film thickness and application. Low film thickness and dry application will give a Low Gloss. High film thickness and wet application will give a higher gloss level.

It is recommended that D8113 clearcoat be used for complete panel repairs only.

Technical Data:

Total dry film build:

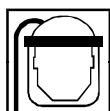
Minimum	2.0 mils
Maximum	2.5 mils
Recommended film build per wet coat	2.1 – 3.1 mils
Recommended dried film build per coat	1.0 – 1.25 mils

RTS Combinations:

Volume Ratio:	D8113 : D8239 : D871 / D872 3 : 1 : 1½
Coatings Category	Specialty Coating
VOC Regulatory (Less Water Less Exempts)	5.12 lbs/gal (614 g/L)
Solids vol. %	30.6
Sq Ft. Coverage / U.S.gal. (1 mil. @ 100% transfer efficiency)	491

Health and Safety

See **Material 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 MSDS's of all the components, since the mixture will have the hazards of all 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 MSDS 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 MSDS.
- Always observe all applicable precautions and follow good safety and hygiene practices.

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 general public. Products mentioned may be hazardous and should only be used according to directions, 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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