



DELTRON[®]



Product Information

PrimaGUARD

DP621 - DP625 - DP627

PRODUCTS

Deltron PrimaGUARD	DP621; DP625; DP627
Deltron Hardener	DH710, DH720
Deltron Thinners	DT860, DT830

PRODUCT DESCRIPTION

PrimaGUARD is designed on the latest primer technology and can be used to optimise the priming process when used in combination with DELTRON[®] Basecoat and DG Colours. It is designed to deliver a high quality final appearance through a non sand process that is equivalent to a sanded primer. Excellent application, very smooth flow and superb holdout properties are at the core of this product's performance.

Due to the excellent adhesion characteristics of PrimaGUARD, no sanding of sound OE electrocoat is required, providing a very fast new panel painting process.

PrimaGUARD can be coated with colour after flash off or left uncoated for up to 24 hours (at 20°C) with no sanding before topcoating with *Deltron* topcoats. This allows new parts to be primed in batches in advance with minimal preparation, ready for the topcoating process with the rest of the vehicle .

The strong adhesion and anti-corrosion characteristics mean that small rub throughs on electrocoated panels do not require the use of an etch primer before PrimaGUARD is applied.

PREPARATION OF SUBSTRATE

PrimaGUARD can be applied over a wide range of substrates including:

Well cleaned unsanded Electrocoat

Bare steel areas up to 10cm diameter without the need for an Epoxy Primer

Galvanised Steel up to 10cm diameter without the need for an Epoxy Primer

Aluminium up to 10cm diameter without the need for an Epoxy Primer

Aged painted and original surfaces sanded with P320 or finer

GRP, Fibreglass after final sanding with P320

Polyester body filler after final sanding with P320



Note: For areas of bare metal above 10cm in diameter DP616 EpoxyTHANE may be used in standard mode or Wet-On-Wet prior to the application of PrimeGUARD. **DO NOT** apply PrimaGUARD over DP612 or any acid etch. **DO NOT** apply over SUA 1K Epoxy Primers unless COMPLETELY dry.

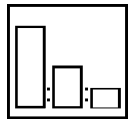
Make sure all surfaces are de-greased, clean and dry before priming

MIXING RATIO % TO ACHIEVE GREYMATIC SHADES

DP621 G1 (White) - DP625 G5 (Grey) and DP627 G7 (Dark Grey) can be mixed together to create G3 and G6 colours. Please follow the chart below to mix your choice of colour before adding hardener & thinner. DO NOT TINT WITH DG Tinters. This will cause adhesion issues.

% By Weight	G1	G3	G5	G6	G7	
DP621	100%	75%				
DP625		25%	100%	48%		
DP627				52%	100%	

MIXING RATIO BY VOLUME



PRODUCT

PrimaGUARD

Deltron Hardener

THINNER

DT860 Primer Accelerator Thinner

DT830 Slow Thinner when overnight or batch priming

PARTS

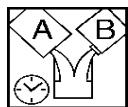
2 VOLUME

1 VOLUME

0.5 VOLUME Up to 30°C

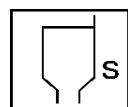
0.5 VOLUME Over 30°C

POTLIFE @ 20°C



20 - 30 minutes at 20°C

SPRAY VISCOSITY @ 20°C



16 - 18 Seconds (DIN4)

SPRAYGUN SETUP



1.3mm - 1.4mm

SPRAY PRESSURE

HVLP / RP

1.6 – 2 bar

CONVENTIONAL

45 – 55 PSI / 160-200 KPA

Wet-On-Wet APPLICATION GUIDE

PrimaGUARD should be filtered through a fine paint strainer and then applied in an even wet coat as if you were applying topcoat. Only one coat is required.

Note: PrimaGUARD can also be used for batch priming new parts. New parts pre primed with PrimaGUARD can be coated later without sanding for up to 24 hours (at 20°C). When spot priming, the use of SUA860 Blending Thinner will soften the blended edge of the primer.

If leaving overnight or batch priming, DO NOT USE DT860. Panels should be topcoated within 24 hours.

NUMBER OF COATS & FLASH OFF



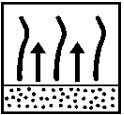
Flash off

Apply one even wet coat

15 minutes

Turn booth spray temperature up during flash off

Apply Deltron topcoat after flash off



If batch priming parts, leave to air dry overnight or bake at 65°C for 30 minutes

TOTAL DRY FILM BUILD

25 - 35 um

BATCH PRIMING ONLY

OVERCOAT / RECOAT PREP

Degrease (De-Nibb if required)



OVERCOAT / RECOAT TIME

Up to 24 hours without sanding (at 20°C)

PAINTING PLASTICS

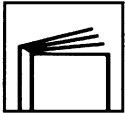
PrimaGuard can be applied directly over well prepared and cleaned ABS, PPO, PC, PC/PBT, PUR and SMC, as well as sanded and pre-primed bumpers.

Large bare plastic sections or rub through areas on bumpers, e.g. PP, TPO, PP/EPDM should be primed first with a light coat of D820 Plastic Primer, and flashed off 15 minutes before the application of PrimaGuard.

EQUIPMENT CLEANING

After use, clean all equipment thoroughly with cleaning solvent or thinner.

HEALTH AND SAFETY



Please refer to Safety Data Sheets for full Health and Safety details and product can labels.

Deltron Hardeners and activated PrimaGUARD contain isocyanate and therefore particular safety precautions must be taken.

Goggles must be worn when mixing and using to prevent accidental splashing into the eye. If contact occurs with eyes give prolonged irrigation with water and get medical attention immediately.

Good ventilation and extraction must be provided in the working environment.

Wear suitable protective equipment to prevent skin contact with this material.

When spraying this product the operator (and persons in vicinity) must wear suitable air-fed breathing apparatus.

Do not smoke whilst using this material.

This product is for professional use only.

The information given in this sheet is for guidance only. Any person using the product without first making further inquiries as to the suitability of the product for the intended purpose does so at his own risk and we can accept no liability for the performance of the product or for any loss or damage (other than death or personal injury resulting from our negligence) arising out of such use. The information contained in this sheet is liable to modification from time to time in the light of experience and our policy of continuous product development.

Drying times quoted are average times at 20°C/68°F. Film thickness, humidity and shop temperature can all affect drying times.



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