



AUTO REFINISH

**GLOBAL
REFINISH
SYSTEM**



Product Information

D800

D800 - 2-Pack Clearcoat

PRODUCTS

Deltron Clear	D800
Deltron Medium Solids Hardeners	D803, D841, D861
Deltron Accelerated Hardener	D863
Deltron Thinners	D870, D807, D872, D873
Deltron DG Fade-out Thinner	D868

For textured finishes or painting of flexible substrates:

Deltron Plasticiser	D814 to plasticise finishes over a flexible substrate
Deltron Texture Additive	D843 to create a fine textured 'suede' effect
Deltron Leather Grain Additive	D844 to create a coarser, more pronounced textured finish

Product Description

Deltron D800 is a high-performance two-pack acrylic urethane clearcoat designed for the repair and respray of motor vehicles as part of a basecoat/clearcoat repair process.

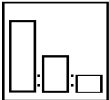
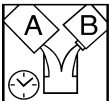
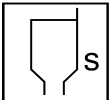


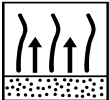
The performance of Deltron D800 in a recommended PPG repair system meets or exceeds motor manufacturer warranty requirements. The Deltron GRS system carries many OEM approvals.






Preparation of Substrate

- Deltron D800 Clear must be applied on top of a clean and dust-free Deltron GRS basecoat (the use of a clean tack rag is recommended to remove dust from the basecoat film).
- Fully cured PPG Refinish Clearcoats that have been degreased and sanded.
- Sound OEM Clearcoats that have been degreased and sanded.

Substrates other than those stated should be tested before use, to ensure that the performance of the product is suitable for its intended use.

Application Guide	MS System	Accelerated System																					
<p>Mixing Ratio</p> 	<p>- RFU mixing available on Paint Manager</p> <table border="1"> <tr> <td>D800</td> <td>3 vols</td> <td>D800</td> <td>2 vol</td> </tr> <tr> <td>MS Hardener**</td> <td>1 vol</td> <td>Hardener</td> <td>1 vol</td> </tr> <tr> <td>Thinner**</td> <td>1 vol*</td> <td>Thinner</td> <td>1 vol</td> </tr> </table>		D800	3 vols	D800	2 vol	MS Hardener**	1 vol	Hardener	1 vol	Thinner**	1 vol*	Thinner	1 vol									
D800	3 vols	D800	2 vol																				
MS Hardener**	1 vol	Hardener	1 vol																				
Thinner**	1 vol*	Thinner	1 vol																				
<p>** Choose MS Hardener and Thinner according to application temperature and the size of the area being painted (see section 3 of the product manual)</p>																							
<table border="1"> <tr> <td>Up to 18°C</td> <td>MS Hardener</td> <td>Thinner</td> <td>Hardener</td> <td>Thinner</td> </tr> <tr> <td>18°C – 25°C</td> <td>D803 Fast</td> <td>D870</td> <td>D863</td> <td>D870</td> </tr> <tr> <td>Over 25°C</td> <td>D841 Medium</td> <td>D807</td> <td></td> <td>D807</td> </tr> <tr> <td></td> <td>D861 Slow</td> <td>D872</td> <td></td> <td>D872</td> </tr> </table>	Up to 18°C	MS Hardener	Thinner	Hardener	Thinner	18°C – 25°C	D803 Fast	D870	D863	D870	Over 25°C	D841 Medium	D807		D807		D861 Slow	D872		D872			
Up to 18°C	MS Hardener	Thinner	Hardener	Thinner																			
18°C – 25°C	D803 Fast	D870	D863	D870																			
Over 25°C	D841 Medium	D807		D807																			
	D861 Slow	D872		D872																			
<p>For exceptional conditions of temperature and humidity (>35°C and >70%) the use of Extra Slow Thinner D873 is recommended.</p>																							
<p>Potlife</p> 	<p>6 hours at 20°C</p>		<p>3 hours at 20°C</p>																				
<p>Spray Viscosity</p> 	<p>17 – 18 secs DIN4 at 20°C</p>		<p>15 secs DIN4 at 20°C</p>																				
<p>Spraygun Setup</p> 	<p>1.3 – 1.4 mm</p>																						
<p>Spray Pressure</p>	<p>HVLP / RP 2 – 3 bar</p> <p>Conventional 45 – 55 PSI / 300-380 KPA</p>																						
<p>Number of Coats</p> 	<p>1 normal, 1 – 2 full</p>																						
<p>Flash Off at 20°C</p> 	<p><i>Between coats</i> 5-10 minutes</p> <p><i>Before Baking</i> Bake immediately</p>	<p>3-5 minutes Bake immediately</p>																					

Application Guide

		MS System	Accelerated System
Drying Times**			
	Dust-free 20 °C dry to handle Through-dry 20 °C	30 minutes 4 hours minimum 20 hours	10 minutes 3 hours 5 hours
	Through-dry 60 °C	30 minutes*	20 minutes*
	IR Short wave	10–15 minutes depending on colour	10–15 minutes depending on colour

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

Technical Data

Total Dry Film Build

Minimum	50 µm
Maximum	60 µm
Theoretical Coverage*	6–7 m ² /L

Theoretical Coverage*

* Theoretical coverage in m²/L ready-to-spray, giving 50 µm dry film thickness.

Flash Points

D800, D873, MS Hardeners	See PPG MSDS
D841, D870, D807, D872, D845, D837, D846	See PPG MSDS

Overcoat/Recoat Time



Sanding: Essential before recoating to ensure good adhesion
P500 (dry)
P800 (wet)

Overcoat / recoat time:

- Force dry 60 °C or IR
 - Air dry at 20 °C
- After cooling
Minimum 8 hours

Overcoat/Repair with

Any PPG 2K primer or Global topcoat.

**TEXTURED FINISHES and
PAINTING OF Rigid or FLEXIBLE SUBSTRATES**

Please note: The positioning of plastic components on motor vehicles, e.g. bumpers, means they are more likely to be subjected to, bumps and knocks from outside sources, such as other motor vehicles, gutters, curbs, etc. PPG recommends flexibilising D800, for all plastics, particularly bumper bars, to improve impact resistance.

To obtain matt finishes it is recommended that D8115 and D8117 are used.

To achieve a textured finish with D800, it is necessary to include texture additives in the mix. Additives are also required when applying D800 over a flexible substrate (typically plastics). The additives required and the appropriate volume and weight mix ratios are indicated in the tables below.

Note : **RIGID** substrates include all metals, fibreglass and GRP
FLEXIBLE substrates are all plastic types except GRP

Substrate	Appearance	D800	D843	D844	D814	D803	D871 Thinner
RIGID	Gloss	3.0 vol	-	-	-	1 vol	1.0 vol
	Textured	3.0 vol	3.0 vol	-	-	1.5 vol	2.0 vol
	Leather Grain	3.0 vol	-	1.5 vol	-	1.5 vol	1.0 vol

FLEXIBLE	Gloss	3.0 vol	-	-	1 vol	2.0 vol	-
-----------------	-------	---------	---	---	-------	---------	---



POLISHING

*Low bake or IR force
drying:*

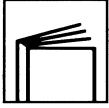
Air drying at 20 °C:

Minimum 1 hour after cooling

Minimum 20 hours after application

EQUIPMENT CLEANING

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



HEALTH AND SAFETY

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

- Global Hardeners and activated D800 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.



**PPG INDUSTRIES AUSTRALIA
PTY LIMITED**

**McNaughton Road
Clayton VIC Australia 3168**

Tel: 13 2424

Fax: 1800 800 819

**PPG INDUSTRIES NEW ZEALAND
PTY LIMITED**

**5 Vestey Drive Mt. Wellington
Auckland New Zealand**

Tel: 0800 320 320

Fax: 0800 320 322