



AUTO REFINISH



# Product Information

## D8112

*D8112 – HP*

*High Performance  
Clearcoat*

### PRODUCTS

Deltron Clear	D8112
Deltron Accelerated Hardener	D863
Deltron Thinners	D870, D807, D872, D873
Deltron DG Fade-out Thinner	D868

### Product Description

Deltron D8112 - HP (High Performance) Clearcoat is a premium quality High Solids polyurethane clearcoat specifically formulated to give an optimum cure while retaining excellent gloss and durability when low-baked for 15 minutes. D8112 – HP can be used in a single visit or a conventional 2 coat mode. By utilising the single visit mode and 15 minute low bake makes this clearcoat the perfect solution for highly productive body shops.

D8112 - HP clearcoat can be easily polished after suitable baking or air drying conditions.



### Preparation of Substrate

- Deltron D8112 - HP 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.

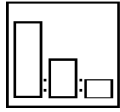
Substrates other than those stated should be tested before use, to ensure that the performance of the product is suitable for its intended use.

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## Application Guide

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### Mixing Ratio



D8112 - HP	2 vols
D863	1 vol
Thinner - single visit mode*	0 – 0.25 vol
Thinner – 2 coat mode*	0.5 vol

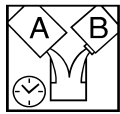
- Choose Thinner according to application temperature and the size of the area being painted (see section 3 of the product manual)

<b>Temperature range</b>	<b>Number of panels</b>	<b>Hardener</b>	<b>Thinner</b>
Up to 18°C	1 panel	D863	D870
18°C – 25°C	2-3 panels		D807
Over 25°C	Over 3 panels		D872

For exceptional conditions of temperature and humidity (>35°C and >70%) the use of Extra Slow Thinner D873 is recommended.

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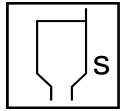
### Potlife



1 - 2 hours at 20°C

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### Spray Viscosity



13 – 15 secs DIN4 at 20°C

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### Spraygun Setup



1.3 – 1.4 mm

<b>Spray Pressure</b>	<b>HVLP / RP</b>	2–3 bar
	<b>Conventional</b>	30 – 45 PSI / 200-300 KPA

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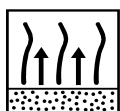
### Number of Coats



<i>Single visit mode</i>	1 light coat followed directly by 1 full coat
<i>2 coat mode</i>	1 medium coat (Flash off) 1 full wet coat

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### Flash Off at 20°C



<i>Between coats</i>	3 -5 minutes
<i>Before Baking</i>	Bake immediately

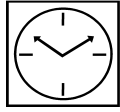
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## Application Guide

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### Drying Times



<b>Dust-free</b>	15 minutes
<b>Air Dry to handle 20°C</b>	6 hours minimum
<b>Air Through-dry 20°C</b>	20 hours



<b>Bake Through-dry 65°C</b>	15 minutes
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<b>IR Short wave</b>	10–15 minutes depending on colour
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\* Bake times are for quoted metal temperature. Additional time should be allowed in the baking schedule to allow metal to reach recommended temperature.

\* Use slow thinner (D872) when curing with IR equipment.

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### Technical Data

#### Total Dry Film Build

<b>Minimum</b>	50 µm
<b>Maximum</b>	60 µm

**Theoretical Coverage\*** 7–7.5 m<sup>2</sup>/L

\* Theoretical coverage in m<sup>2</sup>/L ready-to-spray, giving 50 µm dry film thickness.

#### Flash Points

D863,	See PPG MSDS
D870, D807, D872,	See PPG MSDS

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### Overcoat/Recoat Time



<b>Sanding:</b>	Essential before recoating to ensure good adhesion P500 (dry) P800 (wet)
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#### **Overcoat / recoat time:**

- |                        |                  |
|------------------------|------------------|
| - Force dry 60°C or IR | After cooling    |
| - Air dry at 20°C      | Minimum 12 hours |

**Overcoat/Repair with:** Any PPG 2K primer or Global topcoat.

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### **POLISHING**

*Low bake or IR force  
drying:*

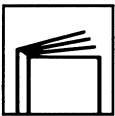
*Air drying at 20°C:*

Minimum 30 minutes after cooling

Minimum 10 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 D8112 - HP 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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