



AUTO REFINISH

GLOBAL
REFINISH
SYSTEM



Product Information

D8120

*D8120 – High Solids
2-Pack Clearcoat*

PRODUCTS

Deltron Clear	D8120
Deltron Hardeners	D803, D841, D861
Deltron Accelerated Hardener	D863
Deltron Thinners	D870, D807, D872, D873
Deltron DG Fade-out Thinner	D868

For matt, satin and 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 D8120 High Solids Clear is a premium quality high solids polyurethane clearcoat specifically formulated to give optimum gloss and durability when low-baked. It is designed for the repair and respray of motor vehicles as part of a basecoat/clearcoat repair process.

The performance of Deltron D8120 in a recommended PPG repair system meets or exceeds motor manufacturer warranty requirements and the Deltron GRS system carries many OEM approvals.

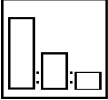
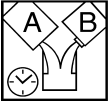
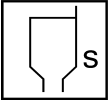


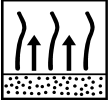


Preparation of Substrate




- Deltron D8120 Clear must be applied on top of a clean and dust-free Deltron GRS basecoat or Envirobase High Performance 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

		HS System	Accelerated System
Mixing Ratio			
		D8120 MS Hardener Thinner	3 vols 1 vol 0.5-1.0 vol
			D8120 Hardener Thinner
			2 vol 1 vol 1 vol
** Choose Hardener and Thinner according to application temperature and the size of the area being painted (see section 3 of the product manual) RFU mixing available on Paint Manager			
		<i>Hardener</i>	<i>Thinner</i>
Up to 18°C		D803 Fast	D870
18°C – 25°C		D841 Medium	D871
Over 25°C		D861 Slow	D872
			<i>Hardener</i>
			<i>D863</i>
			<i>Thinner</i>
			D870
			D807
			D872
For exceptional conditions of temperature and humidity (>35°C and >70%) the use of Extra Slow Thinner D873 is recommended.			
Potlife			
		4 hours at 20°C	2 hours at 20°C
Spray Viscosity			
		17 – 18 secs DIN4 at 20°C	15 secs DIN4 at 20°C
Spraygun Setup			
		1.3 – 1.4 mm	
Spray Pressure	HVLP / RP	2 – 3 bar	
	Conventional	45 – 55 PSI / 300-380 KPA	
Number of Coats			
		1 medium, 1 full wet coat	
Flash Off at 20°C			
	<i>Between coats</i>	5-10 minutes	3-5 minutes
	<i>Before Baking</i>	Bake immediately	Bake immediately

Application Guide

	HS System	Accelerated System
Drying Times		
 <i>Dust-free 20 °C dry to handle Through-dry 20 °C</i>	40 minutes 6 hours minimum 20 hours	15 minutes 3 hours 5 hours
 <i>Through-dry 65 °C</i>	30-40 minutes	20 minutes
 <i>IR Short wave</i>	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*	7–7.5 m ² /L

Theoretical Coverage*

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

Flash Points

D800, D873, 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 12 hours

Overcoat/Repair with

Any PPG 2K primer or Global topcoat.

**MATT, SATIN AND TEXTURED FINISHES
PAINTING OF Rigid or FLEXIBLE SUBSTRATES**

Please note: The positioning of some 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 D8120, for all plastics, particularly bumper bars, to improve impact resistance.

To obtain a textured finish with D8120, it is necessary to include texture additives in the mix. Additives are also required when applying D8120 over a flexible substrate (typically plastics). The additives required and the appropriate volume and weight mix ratios are indicated in the tables below and **also available on Paint manager.**

Note : **RIGID** substrates include all metals, fibreglass and GRP

FLEXIBLE substrates are all plastic types except GRP

Substrate	Appearance	D8120	D843	D844	D814	D803	807 Thinner
RIGID	Gloss	3 vol	-	-	-	1.0 vol	0.5 vol
	Matt Textured	3 vol	3 vol	-	-	1.5 vol	1.0 vol
	Leather Grain	3 vol	-	1.5 vol	-	1.5 vol	0.5 vol

FLEXIBLE	Gloss	3 vol	-	-	1 vol	2.0 vol	0.5 vol
	Matt Textured	4 vol	4 vol	-	-	3.5 vol	1.0 vol
	Leather Grain	4 vol	-	2.0 vol	-	3.5 vol	0.5 vol



POLISHING

Low bake or IR force drying:

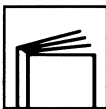
Air drying at 20 °C:

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 D8120 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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