



**DELTRON<sup>®</sup>**



# Product Information

## D8173

D8173

*Premium UHS Clearcoat*

### PRODUCTS

Deltron Premium UHS Clearcoat	D8173
Deltron UHS Hardener	D8302
Deltron Thinners	DT810, DT820, DT830, DT840
Deltron Accelerated Thinner	D8714

For textured finishes or painting of flexible substrates:

Deltron Flexibilser	DA210 to plasticise finishes over a flexible substrate
Deltron Texture Additive	D843 to create a fine textured 'suede' effect

### Product Description

Deltron D8173 Premium UHS Clearcoat is a premium quality Ultra High Solids polyurethane clearcoat specifically formulated for use over ENVIROBASE<sup>®</sup> High Performance basecoat. D8173 – UHS can be used in a single visit or a conventional 2 coat mode. By utilising the single visit mode and 15 minute bake time, this clearcoat is the perfect solution for highly productive body shops.



### Preparation of Substrate

- Deltron D8173 Premium UHS Clearcoat must be applied on top of a clean and dust-free ENVIROBASE<sup>®</sup> 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.

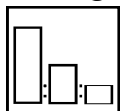
Substrates other than those stated should be tested before use, to ensure that the performance of the product is suitable for its intended use.

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## Application Guide

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### Mixing Ratio



D8173	3 vols
D8302	1 vol
Thinner*	0.6 -1 vols

(see table below for weights)

- Choose Thinner according to application temperature and the size of the area being painted (see below) **NOTE:** DT840 must be used at temperatures above 35°C
- As with all ultra high solids products, cold ready for use paint temperatures can lead to more difficult application and overspray absorption. It is strongly recommended that ready for use product is applied at a temperature greater than 15°C.

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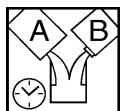
### HARDENER AND THINNER SELECTION

<u>System</u>	<u>UHS Hardener</u>	<u>Thinner</u>	<u>Bake Schedule</u>
Express	D8302	D8714	15 mins at 60°C
Standard	D8302	DT810/DT820	25 mins at 60°C
Up to 35°C	D8302	DT820/DT830	25 mins at 60°C
Express (above 35°C)	D8302	DT840/8714 50/50	25 mins at 60°C
Standard(above 35°C)	D8302	DT840	25 mins at 60°C

The choice of thinner should be made according to application temperature, air movement and size of job.

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### Potlife at 20°C

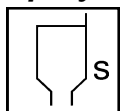


40 minutes with D8302/D8714

75 minutes with D8302/DT8XX

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### Spray Viscosity



18 – 20 seconds DIN4 at 20°C

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### Spraygun Setup



1.2 – 1.3 mm  
(1.2 RP suggested)

<b>Spray Pressure</b>	<b>HVLP / RP</b>	2 – 3 bar
	<b>Conventional</b>	45 – 55 PSI / 300-380 KPA

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## Number of Coats



### Express Single Visit Process

Apply 1 medium & 1 full coat to give 50-60 microns dry film build.

The first coat should be applied to all repair panels before the second coat is applied.

### Flash off between spray coats

For less than 3 panels, 2-3 minutes flash off.

For more than 3 panels, no flash off is required.

### Flash off before bake or IR dry

0 – 5 minutes

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## Application Guide

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|--------------------------------------|--|
| - Through dry at 60°C*               | 15 minutes with D8302 + D8714  |
|                                      | 25 minutes with D8302 + DT8XX  |
| - Through dry at IR<br>(medium wave) | 8 - 15 minutes (depending upon colour)<br>metal temperature 90°C-100°C |



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

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### Important Curing Notes:

UHS products cure in a different way than conventional MS or HS products, this is usually noticed directly after bake. UHS products can feel soft to the touch and may finger print up to 1 hour after bake, this is normal, finger prints or even masking tape marks will disappear within minutes of being marked. Vehicles should be assembled and polished as if using conventional MS or HS products as this does not effect the in service times in any way.

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## Technical Data

### Total Dry Film Build

Minimum	50 µm
Maximum	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

D8302,	See PPG MSDS
DT8XX	See PPG MSDS

## Overcoat/Recoat Time



### Sanding:

Essential before recoating to ensure good adhesion  
P500 (dry)

### Overcoat / recoat time:

- Force dry 60°C or IR
- Air dry at 20°C

After cooling  
Minimum 12 hours



## POLISHING

If polishing is required, i.e. to remove dirt nibs, it is recommended that it is carried out between 1 hour and 24 hours after the quoted drying time.

Denib with P1200, followed by P1500 dry disc.

Lightly damp an Abralon 3000 disc or similar with clean water ensuring that the P1500 scratches are eliminated.

It is important to polish at minimum speed, to avoid the surface becoming too hot. If necessary, allow the panel to cool down before continuing to polish.

## WEIGHT MIX TABLE FOR D8173 PREMIUM UHS CLEARCOAT

The weights are cumulative - please do **NOT** tare the balance between additions.

Target Volume of RFU Paint required (Litres)	Weight Clearcoat D8173 PREMIUM UHS CLEARCOAT	Weight UHS Hardener D8302	Weight Thinner <b>3:1:0.6</b> Single visit mode
100	65	88	99
250	163	220	248
330	215	291	327
600	391	529	595
750	488	661	743
1000	651	882	991

Target Volume of RFU Paint required (Litres)	Weight Clearcoat D8173 PREMIUM UHS CLEARCOAT	Weight UHS Hardener D8302	Weight Thinner <b>3:1:1</b> 2 coat mode
100	60	81	98
250	150	203	245
330	198	268	323
600	359	487	588
750	449	608	734
1000	599	811	979

To obtain a textured finish with D8713 Premium UHS Clearcoat, it is necessary to include flex or texture additives in the mix. Additives are also required when applying D8713 over a flexible substrate. The additives required and the appropriate volume and/or weight mix ratios are indicated in the tables below.

**Note:** The majority of plastics used on cars are considered **Rigid**. These plastics may have some flexibility when painted off the car, but are rigid once mounted. UHS Clearcoats only require the addition of the Plasticiser Additive (See **Flexible** chart below) when painting very flexible plastics, mostly found on older vehicles, e.g. foam type.

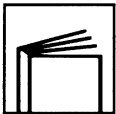
**Cumulative Mixing by Weight**

Do not tare the balance between additions

<b>Substrate</b>	<b>Appearance</b>	<b>D8173</b>	<b>D843</b>	<b>D814</b>	<b>UHS Hardener</b>	<b>Deltron Thinner</b>
<b>RIGID</b>	Gloss	652g	-	-	883g	990g
	Textured	267g	590g	-	732g	949g
<b>FLEXIBLE</b>	Gloss	545g	-	646g	877g	984g

**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 D8173 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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