



AUTO REFINISH

Product Information

D8046

*D8046
2K High Build Primer*

PRODUCTS

Deltron 2K primer	D8046
Deltron Thinners	D870, D807, D872, D873
Deltron MS Hardener	D803, D841, D861
For Flexibilising	D814 Deltron Plasticiser

Product Description

D8046 is a versatile, high build 2K primer, suitable for use under any PPG GRS Deltron 2K topcoat or GRS Deltron Basecoat.

It offers exceptional film build when used as a spray filler or primer surfacer.

D8046 may be applied over suitably prepared polyester putties, or over sound, fully cured, original paintwork, or adhesion primers. D8046 may also be flexibilised for use over plastic parts. Options are available for air drying, conventional baking and Infra Red drying.

PREPARATION OF SUBSTRATE

Substrate

Bare steel
Galvanised steel
Zintec
Aluminium and alloys
Electropaint
Aged painted surfaces
GRP , Fibre-Glass
Polyester filler
Featheredge of repair

Preparation

Must be pre-primed (eg D831, D834)
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Must be pre-primed (eg D831)
P320-P400 (dry)/P400 -600(wet)
P320-P400 (dry)/P400-600 (wet)
P320 (dry)
P120-180 (high-build version)
P240 - 320 (dry)

Cleaning

Before and after any sanding operation, the substrate must be thoroughly degreased with D845 or D837.

Application Guide

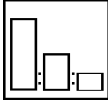
For use as a:

Spray Filler
(i) 6:1 MS option

Primer Surfacer
(ii) 6:1 MS option

Mixing Ratio

- RFU mixing available on Paint Manager



	By Volume	1 ltr by Weight	Cumulative		By Volume	1 ltr by Weight	Cumulative
D8046	6 vol	1211g		D8046	6 vol	1076g	
Hardener	1 vol	1341g		Hardener	1 vol	1191g	
Thinner	1 vol	1437g		Thinner	2 vol	1379g	

- D8046 2K High Build Primer may be tinted by addition of up to 5% by volume of Global DG tinter or mixed DG colour prior to addition of hardener and thinner.
- D8046 2K High Build Primer may be flexibilised by adding 10-20% D814 Plasticiser prior to addition of hardener and thinner.

Hardener and Thinner Selection

Temperature

Up to 18°C
18–25°C
25–35°C
Over 35°C

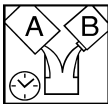
MS Hardener

D803 MS Fast
D803 MS Fast
D841 MS Medium
D861 MS Slow

Thinner

D870 Fast
D807 Medium
D807 Medium
D872 Slow

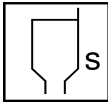
Potlife at 20°C



1.5-2 hours

4-5 hours

Spray Viscosity



30-40 secs DIN at 20°C

18-22 secs DIN at 20°C

Spraygun Setup



Gravity
Suction

1.8-2.2 mm
1.8-2.2 mm

1.6-1.8 mm
1.8-2.0 mm

Spray Pressure

2-2.5 bar / 30-35 PSI

2-3 bar / 30-45 PSI

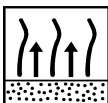
Number of Coats



2 coats
Up to a maximum of 3

2 coats
Up to a maximum of 3

Flash Off at 20°C



Between coats
Before stoving

5–10 mins
Bake immediately

5–10 mins
Bake immediately

	Spray Filler (i) 6:1 MS option	Primer Surfacer (ii) 6:1 MS option
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Drying Times



Dust-free at 20 °C

15 mins

15 mins

Through-dry at 20 °C

12 hours

5 hours



Through-dry at 60 °C

30 mins

30 mins



*Through-dry with IR
medium*

15-20 mins depending on IR unit

15-20 mins depending on IR unit

- *Note: Spray filler mode will require D872 Slow thinner if IR Curing*
- *Baking time required once metal reaches the quoted temperature. Baking schedule should allow additional time for metal to reach this temperature*

Technical Data

Total Dry Film Build

Minimum

140 µm

80 µm

Maximum

200 µm

120 µm

Theoretical Coverage

approx. 1.6-2.2 m² /L

approx. 2.5-4.0 m² /L

* *Theoretical coverage in m²/L ready-to-spray, with a dry film thickness between indicated minimum and maximum values.*

Flash Points

D8046, D803, D841, D861, DG tinter
and mixed colour

See PPG MSDS

D870, D807, D872, D845, D837

See PPG MSDS

Sanding



Grade dry

P240 followed by P400 - 500

P240 followed by P400 - 500

Grade wet

P400 followed by P600 - 800

P400 followed by P600 - 800

Overcoat with

Any PPG GRS topcoat.

PAINTING OF FLEXIBLE SUBSTRATES - FLEXIBLE substrates are all plastic types except GRP

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

Additives are also required when applying over a flexible substrate (typically plastics). The additives required and the appropriate volume and weight mix ratios are indicated in the tables below and are also available on paint manager. In a repair situation PPG recommends that flexibilised 2K primers and polyester filler, be applied over the appropriate PPG plastic primer. (See substrate preparation section in PPG product manual)

Note: Keep primer film build to a minimum on plastic substrates. Apply Maximum 2 coats over D820, D815 Plastic adhesion promoting primer

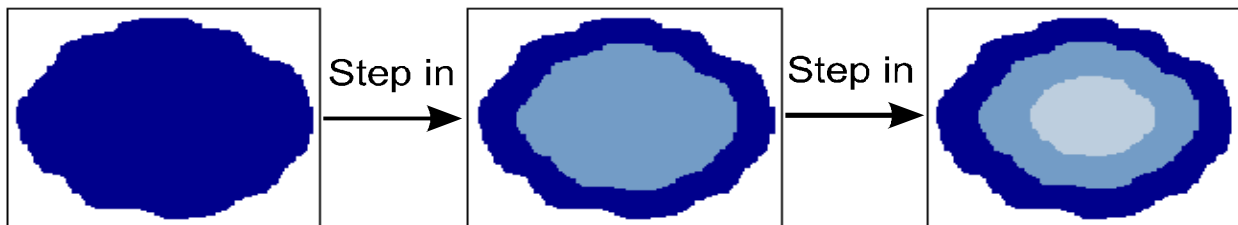
Substrate	D8046 2K High Build Primer	D8XX MS Hardener	D814 Plasticiser
Flexible	6 Parts	1 Part	1 Part

RFU Mix ratio available on Paint manager

Performance Guidelines

When **spot priming** with D8046 2K High Build Primer as a Spray Filler / Primer Surfacer, adopt the following procedure:

1. Ensure that the surface is thoroughly sanded to the panel edge, breakline or to a distance 15 centimetres beyond the feathered edge area, whichever is the smaller.
2. Apply the first coat to the entire area to be primed then apply subsequent coats inside the previous coat allowing the correct flash-off times between coats. (This avoids building up an edge and trapping dry spray.)



3. Allow to dry as normal, and then be careful to thoroughly level the repair edge when sanding. Do not attempt spot repair on original or refinish TPA, lacquer or 1K finishes.
4. Global Accelerated Hardener D863 should not be used with this product.
5. D8046 2K High Build Primer and its ancillaries are sensitive to moisture, so all equipment must be perfectly dry. Where humidity is in the range 70–80%, use of Very Slow Thinner D873 is recommended. Do not attempt to use D8046 2K High Build Primer at humidity levels exceeding 80%.
6. To ensure maximum adhesion and impact resistance, D8046 2K High Build Primer must be coated within 72 hours of application. After this time it should be sanded and recoated with itself.

EQUIPMENT CLEANING

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

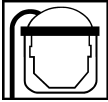


Health and Safety

Please refer to Material Safety Data Sheets for full Health and Safety details before use.



- 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.
- Do not smoke whilst using this material.
- Do not breathe vapours or overspray. In cases of insufficient ventilation, wear appropriate respiratory equipment.

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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