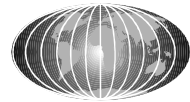




AUTO REFINISH

GLOBAL  
REFINISH  
SYSTEM



# Product Information

## D8080

UV Cured Primer  
499-D8080/CARTON (6X300M)

### PRODUCT DESCRIPTION

D8080 UV Cured Primer is a unique UV cured primer suitable for A4 size repairs. Repair process times using D8080 are extremely rapid, with easy application from ready-to-spray aerosol packaging and just a 3 minute through-cure time using an approved UV lamp.

### PREPARATION OF SUBSTRATE - DEGREASING

Before any preparation work, wash all surfaces to be painted with a suitable PPG substrate cleaner:



SWX250 Metho-Water cleaner  
D837 DX330 Spirit Wipe  
D846 DX103 Degreasing Agent for Plastics

Ensure all substrates are thoroughly cleaned and dried before and after each stage of the preparation work. Always wipe substrate cleaner off the panel surface immediately, using a clean, dry cloth.

### PREPARATION OF SUBSTRATE - PRIMING & SANDING



Ensure the surface to be repaired is thoroughly sanded either to the panel edge or to a distance several centimetres beyond the area to be primed. **Do not** pre-prime with 1K primers or wash etch primers such as D831 Universel



**Original Paintwork or OE Electrocoat** should be sanded using minimum P240 grit discs dry. Preparation using just an abrasive pad will not ensure adequate surface adhesion.

**Bare Steel and Aluminium** must be clean, rust-free and abraded thoroughly using P180 to P240 grit paper before application.

**Galvanized Steel** must be thoroughly abraded.

**Polyester Body Fillers** should be final dry sanded using P180- P240 dry.

**Fibre Glass and SMC** should be dry sanded using P240- P320.

Proper preparation of **Plastic substrates** is essential. Pre-Clean the surface using a mixture of 1 part Bodykleen 920-35609 to 4 parts water, rinse, dry and then re-clean with D846, use a fine brush to clean grained surfaces. Dry sand rigid plastics with P240 grit (Autonet or Abranet recommended), flexible plastics with a medium grade abrasive pad. **Do not use D8080 directly over PE or polystyrene.**

## MIXING



Mixing Ratio: The product is packaged in an aerosol, no mixing is needed. Simply shake the can to dislodge the internal metal ball, and then shake vigorously for a further 3 minutes.

## APPLICATION GUIDE

### **Number of coats**



For minor dents and scratches, apply a single coat in 3-4 continuous passes of the spray fan.

Spraying distance: 15-20 cm

For deeper dents and scratches, then a second application is necessary: apply 3-4 single passes as above, then cure with the UV lamp 30 sec / 20 cm then apply a second application of 2-3 coats then cure with the UV lamp 3 min / 15-20 cm.

D8080 contains fluorescent dyes and will glow when exposed to the UV lamp for curing.

Use a suitable application technique to achieve a graduated film thickness across the repair area and a featheredge.

## DRYING TIME AT 20°C

*UV Cure* Direct light from the UV curing lamp at the repair area for 3 minutes at a minimum distance of 15 cm maximum 20 cm.



*Dry to sand* After a 3-minute UV cure, the entire surface should be thoroughly cleaned with D8404 Cleaner to remove any uncured surface residue and overspray before sanding.

If colder than 20 preheat the panel.

## UV LAMP INFORMATION & CAUTIONS



*UV*  
(Ultraviolet)



- The entire surface area of the primer must be fully illuminated by the UV lamp for 3 minutes. \*Material will not cure unless it is directly exposed at a 90° angle to an approved UV light source at a distance of 15-20cm.
- Refer to UV lamp manufacturers instructions, as not all UV lamps operate the same.
- Solvent wipe with D8404 Cleaner
- A 2-minute cure time at a distance of 20 cm max will cure an area the size of an A4 sheet of paper. Reducing the lamp to panel distance will decrease the area exposed to UV light and thus restrict the size of the area cured.
- At greater distances, cure time will be significantly extended.
- Do not expose eyes or skin to direct UV light. Use UV safety glasses, available from safety equipment suppliers.
- UV lamps get very hot and should be kept away from solvent fumes. Be careful to avoid burns to skin.
- If the filter glass is damaged in any way or not securely in place, DO NOT USE

\* When the repair area is not a flat, even surface (e.g. over a contour line of the vehicle) it will not be possible to do the repair in one go.

The following steps should then be taken:

1. Partially cure the whole repair area by moving the lamp around the repair, ensuring that all of the applied D8080 film has been exposed to UV light for at least 30 seconds.
2. Fully cure all areas of the repair area sections by sections for 3 minutes at a time. It is NOT a problem to over-expose an area to the UV light.
3. Clean and sand as recommended earlier in this datasheet.

## TOPCOAT



*Dry to topcoat* Immediately after sanding. After 72 hours, D8080 must be re-sanded before applying topcoat.



*Final Sand* *Mirka P400 DG Colour*  
*Mirka P500 BC/Clearcoat*



*Overcoat with* Overcoat with PPG Deltron Global Refinish System topcoat or a compatible 2K surfacer or sealer. Compatible 2K surfacers include D839, D847 or D825.

## FILM BUILDS

### Total dry film build per application:

Minimum after sanding - 50 µm

Maximum after sanding - 150 µm

## PERFORMANCE GUIDELINES

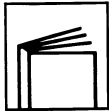
**Do not** apply this product to hiding. This product is pigmented solely to show the applicator where the primer has been applied, so that the entire area is cured by the UV lamp. If this product is applied to hiding, the product won't cure properly, and will result in adhesion failures.

**Do not** attempt to apply over acid catalysed etches (i.e. D831), 1K primers, OEM or refinish thermoplastic (acrylic lacquer) topcoats.

## CAN DISPOSAL

When aerosol is empty, turn it upside down and press the nozzle until all propellant is exhausted. Place empty can or cans that will no longer be used into properly labelled metal containers. The waste containers should be managed as a hazardous waste according to legislation.

## HEALTH AND SAFETY



For comprehensive Health, Safety and Environmental advice, please refer to the relevant Material Safety Data Sheets and Product can labels.  
Use the recommended safety 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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