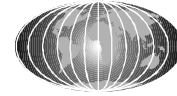




AUTO REFINISH

GLOBAL  
REFINISH  
SYSTEM



# Product Information

## D816

*D816- Plastics Primer*

### Product Description

**D816 is a plastics primer for use on all PUR and PUR/RIM.**

For full details on whether this is the correct primer for the selected plastic substrate please refer to "Painting Plastic Components" section in the PPG product manual.

### Preparation of Substrate



Thoroughly clean and abrade all surfaces to be painted with a mixture 1 part Bodykleen and 4 parts water using and medium grade abrasive pad. Rinse with clean water and dry.



Re-clean the surface using D846 Degreasing Agent For Plastics using a clean damp cloth to apply and a clean dry cloth to remove.

For minor defects or pinholes where filling is required **A652 Iviplast 66** Flexible 2 component polyester filler or **A655 Single Pack Pinhole Filler** is recommended (please refer to individual data sheets).

With PUR and PUR/RIM, wet sand with P320 – P400 Dry or P400 – P600 grade paper wet and clean again with D846 Degreasing Agent for Plastics.

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## Application Guide - D816

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### Mixing Ratio

Supplied ready to spray — no thinning necessary.

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### Spraygun Setup



1.6–1.8 mm

### Spray Pressure

3 bar/45 PSI Conventional  
2 bar/ 30 PSI HVLP/RP

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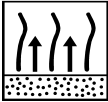
### Number of Coats



2 medium wet coats

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### Flash Off at 20 °C



<i>Between coats</i>	5 minutes
<i>Before topcoat application</i>	40 minutes

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### Drying Times



<i>Dust-free</i>	5 minutes
<i>Through dry at 20 °C</i>	40 minutes

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### Technical Data

#### Total dry film build

<i>Minimum</i>	15 µm
<i>Maximum</i>	25 µm

*Theoretical coverage* 3.5–4 m<sup>2</sup>/L (25 µm)

<i>Flash Points</i>	D816	See PPG MSDS
	D846	See PPG MSDS

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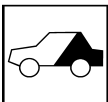
### Sanding



<i>Grade wet</i>	n/a - P800 if required
<i>Grade dry</i>	n/a – P500 if required

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### Overcoat/Recoat Time



40 minutes minimum  
2 hours maximum

### Overcoat with

Any PPG flexibilised 2K primer or Global topcoat

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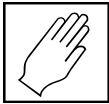
## Performance Guidelines

A higher film build on polypropylene/EPDM or PEP can be achieved by applying D816 (2 coats) over D820 wet-on-wet. Wait 40 minutes before topcoating.

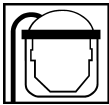


## Health and Safety

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



- 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.



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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