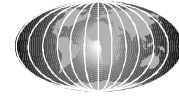




AUTO REFINISH

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SYSTEM



Product Information

D820

D820

Plastic Adhesion Promoter

Product Description

D820 is a transparent ready-for-use adhesion promoter for plastic substrates. It is suitable for use on a wide variety of plastic composites used on modern motor vehicles.

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).

Application Guide

Shaking: Shake the can gently for a few seconds before using D820.

Mixing Ratio: Supplied ready for use – No thinning necessary.

Spraygun Setup / Pressure



Gravity feed

Conventional
1.3–1.5 mm
3 bar / 45 PSI

HVLP/RP
1.3–1.5 mm
1.5 / 2.0 Bar

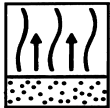
Suction feed

1.5–1.8 mm
3 bar / 45 PSI

Number of Coats

Number of coats: 1 thin coat

Flash off at 20°C



Between coats:

N/A

Before Topcoat:

30 min

Drying Times



Dust-free
20 °C dry to handle
Through-dry 20 °C

5 minutes
N/A
30 minutes

Technical Data

Total Dry Film Build *Approx 5µm*

Theoretical Coverage *6m² per Litre*

Sanding



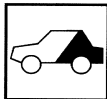
Grade wet

N/A

Grade dry

N/A

Overcoat/Recoat Time



Minimum

30 minutes

Maximum

1 hour

Overcoat with

Any PPG flexibilised 2K primer or Global topcoat.

Performance Guidelines

Allow D820 to flash for a full **20mins at 25°C**, before application of topcoat. Failure to comply to this timescale may result in subsequent adhesion failure.

When higher build is necessary, D839 flexibilised (see relevant individual technical datasheet for details) may be used on top of the plastic primers.

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

Part used cans should be resealed after use.

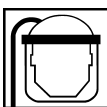


Health and Safety

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.
- 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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