



AUTO REFINISH

GLOBAL  
REFINISH  
SYSTEM



# Product Information

## DP4000

D8501 - D8505 - D8507

### PRODUCTS

DP4000	D8501, D8505, D8507
D8238 Fast HS Hardener	D8238
D8711, D872, Thinners	D8711, D872

### PRODUCT DESCRIPTION

DP4000, designed on the latest primer technology, can be used to optimise the priming process when used in combination with Envirobase HP and GRS Basecoat. It is designed to deliver a high quality final appearance through a non sand process that is equivalent to a sanded primer. Excellent application, very smooth flow and superb holdout properties are at the core of this product's performance.

Due to the excellent adhesion characteristics of DP4000, no sanding of sound OE electrocoat is required, providing a very fast new panel painting process. DP4000 can be coated with colour after flash off or left uncoated for up to 5 days (at 20°C) with no sanding when topcoating with *Envirobase HP*, so new parts can be primed in batches in advance with minimal preparation, and can be held ready for the topcoating process with the rest of the vehicle.

The strong adhesion and anti-corrosion characteristics mean that small rub throughs on electrocoated panels do not require the use of an etch primer before DP4000 is applied.

### PREPARATION OF SUBSTRATE

#### DP4000 can be applied over a wide range of substrates including:

Well cleaned unsanded Electrocoat

Bare steel areas up to 10cm diameter without the need for an Epoxy Primer



Galvanised Steel up to 10cm diameter without the need for an Epoxy Primer

Aluminium up to 10cm diameter without the need for an Epoxy Primer

Aged painted and original surfaces sanded with P320 or finer

GRP, Fibreglass after final sanding with P320



Polyester body filler after final sanding with P320

**Note:** For areas of bare metal above 10cm in diameter 410-48248 EPOXY URETHANE PRIMER may be used in standard mode or Wet-On-Wet prior to the application of DP4000. **DO NOT** apply DP4000 over D831 or any acid etch. **DO NOT** apply over SUA 1K Epoxy Primers unless COMPLETELY dry.

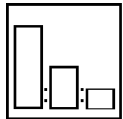
**Make sure all surfaces are de-greased, clean and dry before priming**

### MIXING RATIO % TO ACHIEVE GREYMATIC SHADES

D8501 White (G1) - D8505 Grey (G5) and D8507 Dark Grey (G7) can be mixed together to create G3 and G6 colours. Please follow the chart below to mix your choice of colour before adding hardener & thinner. DO NOT TINT WITH DG Tinters. This will cause adhesion issues.

% By Weight	G1	G3	G5	G6	G7	
D8501	100%	75%				
D8505		25%	100%	48%		
D8507				52%	100%	

### MIXING RATIO BY VOLUME



#### PRODUCT

DP4000  
D8238 Fast HS Hardener

#### THINNER

D8711 Accelerator Thinner

Mix D8711 & D872 Thinner together 50/50

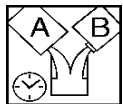
#### PARTS

2 VOLUME  
1 VOLUME

0.5 VOLUME Up to 30°C

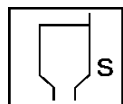
0.5 VOLUME Over 30°C

### POTLIFE @ 20°C



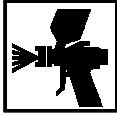
20 - 30 minutes at 20°C

### SPRAY VISCOSITY @ 20°C



16 - 18 Seconds (DIN4)

## SPRAYGUN SETUP



1.3mm - 1.4mm

## SPRAY PRESSURE

HVLP / RP

1.6 – 2 bar

CONVENTIONAL

45 – 55 PSI / 300-380 KPA

## Wet-On-Wet APPLICATION GUIDE

DP4000 should be filtered through a fine paint strainer and then applied in an even wet coat as if you were applying topcoat. Only one coat is required.

*Note: DP4000 can also be used for batch priming new parts. New parts pre primed with DP4000 can be coated later without sanding for up to 5 days (at 20°C) when using Envirobase HP as a topcoat. When spot priming, the use of SUA860 Blending Thinner will soften the blended edge of the primer.*

**If leaving overnight or batchpriming, DO NOT USE D8711. If using Deltron GRS as the topcoat, panels should be topcoated within 24 hours.**

## NUMBER OF COATS & FLASH OFF



Flash off

**Apply one even wet coat**

15 minutes

*Turn booth spray temperature up during flash off*

**Apply Envirobase HP or GRS basecoat after flash off**



*If batch priming parts, leave to air dry overnight or bake at 65°C for 30 minutes*

## TOTAL DRY FILM BUILD

25 - 35 um

## BATCH PRIMING ONLY

### OVERCOAT / RECOAT PREP

Degrease (De-Nibb if required)



### OVERCOAT / RECOAT TIME

Up to 5 days (at 20°C) without sanding for Envirobase HP only.  
(GRS Deltron within 24 hours)

## **PAINTING PLASTICS**

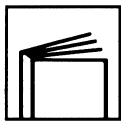
DP4000 can be applied directly over well prepared and cleaned ABS, PPO, PC, PC/PBT, PUR and SMC, as well as sanded and pre-primed bumpers.

Large bare plastic sections or rub through areas on bumpers, e.g. PP, TPO, PP/EPDM should be primed first with a light coat of D820 Plastic Primer, and flashed off 15 minutes before the application of DP4000.

## **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 DP4000 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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