



AUTO REFINISH

**GLOBAL
REFINISH
SYSTEM**



Product Information

Global DG

Direct Gloss 2-Pack Acrylic Colour

Tinter line number – 401

Mixed colour line number - 402

PRODUCTS

Deltron Direct Gloss Tinters	D7xx
Deltron Medium Solids Hardeners	D803, D841, D861
Deltron Standard Solids Hardener	D863
Deltron Thinners	D870, D807, D872, D873
Deltron DG Fade-out Thinner	D868
Deltron Accelerator	D818

For matt, satin and textured finishes or painting of flexible substrates:

Deltron Matting Base	D759 to create a matt or satin appearance
Deltron Plasticiser	D814 to plasticise finishes over a flexible substrate
Deltron Texture Additive	D843 to create a fine textured 'suede' effect
Deltron Leather Grain Additive	D844 to create a coarser, more pronounced textured finish

PRODUCT DESCRIPTION

Global DG is a high-performance two-pack acrylic urethane topcoat designed for the direct gloss repair and respray of all motor vehicles.

The performance of Global DG in a recommended PPG repair system meets or exceeds motor manufacturer warranty requirements and the Global system carries many OEM approvals.

PREPARATION OF SUBSTRATE



SUBSTRATE

PPG 2K primers
Electrocoat
Sound 2K finishes
TPA

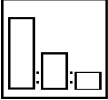
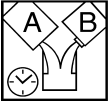
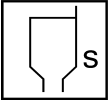


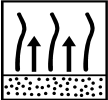
PREPARATION

P600 - wet / P400 - dry
Pre-prime - Do not topcoat direct
P600 - wet / P400 - dry
Must be sealed (e.g. D834)






Before and after any sanding operation, the substrate must be thoroughly degreased using D845 or D837. Use D837 only prior to any painting.

Application Guide

		MS System		Accelerated System	
Mixing Ratio					
		DG	3 vols	DG	2 vol
		MS Hardener**	1 vol	Hardener	1 vol
		Thinner**	1 vol*	Thinner	1 vol
** Choose MS Hardener and Thinner according to application temperature and the size of the area being painted (see section 3 of the product manual)					
		<i>MS Hardener</i>	<i>Thinner</i>	<i>Hardener</i>	<i>Thinner</i>
Up to 18°C		D803 Fast	D870	D863	D870
18°C – 25°C		D841 Medium	D807		D807
Over 25°C		D861 Slow	D872		D872
For exceptional conditions of temperature and humidity (>35°C and >70%) the use of Extra Slow Thinner D873 is recommended.					
** All mix ratios are available RFU on paint manager					
Potlife					
		6 hours at 20°C		3 hours at 20°C	
Spray Viscosity					
		17 – 18 secs DIN4 at 20°C		15 secs DIN4 at 20°C	
Spraygun Setup					
		1.3 – 1.4 mm or equivalent			
Spray Pressure		HVLP / RP	2 – 3 bar		
		Conventional	45 – 55 PSI / 300-380 KPA		
Number of Coats					
		1 normal, 1 – 2 full			
Flash Off at 20°C					
	<i>Between coats</i>	5-10 minutes		3-5 minutes	
	<i>Before stoving</i>	Bake immediately		Bake immediately	

Application Guide

	MS System	Accelerated System
Drying Times**		
 <p>Dust-free 20 °C dry to handle Through-dry 20 °C</p>	<p>30 minutes 4 hours minimum 20 hours</p>	<p>10 minutes 3 hours 5 hours</p>
 <p>Through-dry 60 °C</p>	<p>30 minutes*</p>	<p>20 minutes*</p>
 <p>IR medium</p>	<p>10 – 15 minutes depending on colour</p>	<p>10 – 15 minutes depending on colour</p>

* Bake times are for quoted metal temperature. Additional time should be allowed in the baking schedule to allow metal to reach recommended temperature.

** Using the Global Accelerated System may reduce drying times still further. See data sheet Accelerated systems for application details.

Technical Data

Total Dry Film Build

Minimum	50 µm
Maximum	60 µm
Theoretical Coverage*	6 – 7 m ² /L

Theoretical Coverage*

* Theoretical coverage in m²/L ready-to-spray, giving 50 µm dry film thickness.

Flash Points

DG Colour, D873, MS Hardeners	See PPG MSDS
D841, D807, D871, D872, D845, D837, D846	See PPG MSDS

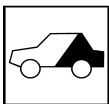
Sanding



Grade wet
Grade dry

Essential before recoating to ensure good adhesion.
P600
P400

Overcoat/Recoat Time



After surface has cooled if baked, or
after 8 hours minimum at 20 °C.
Recoat times will be extended at lower temperatures.

Overcoat with

Any PPG 2K primer or Global topcoat.

**MATT, SATIN AND TEXTURED FINISHES
PAINTING OF Rigid or FLEXIBLE SUBSTRATES**

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

To obtain a textured finish with Deltron Direct Gloss, it is necessary to include flex or texture additives in the mix.

Additives are also required when applying DG over a flexible substrate (typically plastics). The additives required and the appropriate volume and weight mix ratios are indicated in the tables below.

**** All mix ratios are available RFU on paint manager only.**

RIGID substrates include all metals, fibreglass and GRP

FLEXIBLE substrates are all plastic types except GRP

Note: Due to the addition of additives in the DG colour, coverage may be affected in some colours. A test panel is recommended to determine the number of coats that will be required.

Substrate	Appearance	DG	D843	D844	D814	D803 hardener	D871 Thinner
RIGID	Gloss	3 vol	-	-	-	1 vol	1 vol
	Matt Textured	3 vol	3 vol	-	-	1.5 vol	2 vol
	Leather Grain	3 vol	-	1.5 vol	-	1.5 vol	1 vol

FLEXIBLE	Gloss	3 vol	-	-	1 vol	2.0 vol	-
	Matt Textured	4 vol	4 vol	-	-	3.5 vol	1.5 vol
	Leather Grain	4 vol	-	1.5 vol	-	3.5 vol	0.5 vol



POLISHING

*Low bake or IR force
drying:*

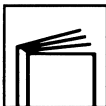
Air drying at 20 °C:

Minimum 1 hour after cooling

Minimum 20 hours after application

EQUIPMENT CLEANING

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



HEALTH AND SAFETY

Health and Safety

Please refer to Material Safety Data Sheets for full Health and Safety details and product can labels.

- Global Hardeners and activated DG Colour 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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