



GLOBAL REFINISH  
SYSTEM

December 2021

# Product Information

## D8131 UHS Clearcoat

### PRODUCTS

UHS Clearcoat	D8131
UHS Hardener	D8254
UHS Hardener Slow	D8255
High Temperature Accelerated Thinner	D8746

For textured finishes or painting of flexible substrates:

DELTRON® Plasticiser	D814 to plasticise finishes over a flexible substrate
<i>Deltron</i> Matt Flexibiliser	D819 for textured appearance over a flexible substrate
<i>Deltron</i> Texture Additive	D843 to create a fine textured 'suede' effect
<i>Deltron</i> Leather Grain Additive	D844 to create a coarser, more pronounced textured finish

### PRODUCT DESCRIPTION

D8131 UHS Clearcoat has been developed using the latest PPG clearcoat technology to enhance the innovative PPG paint system.

D8131 provides bodyshops with an easy to use clearcoat which combines the high speed drying, easy polish for all repairs. It comes with a smart and simple package with hardeners dedicated for standard & high temperature application.

- Application in 2 coats. 5 min flash off between coats and 5 min flash before bake.
- 1 Visit application; 1 light and 1 full coat.
- Fast drying; 15 minutes @ 60°C
- Very good gloss and flow;
- Easy to polish.

## PREPARATION OF SUBSTRATE

Apply on top of a clean and dust free GRS Deltron BC or Envirobase High Performance (the use of a tack rag is recommended to remove dust from the basecoat film).

## MIXING RATIO

Mixing ratios with UHS Hardener:

	<u>By Volume</u>	<u>By Volume</u>
D8131	2 vol	2 vol
D8254/D8255*	1 vol	1 vol
<b>D8746</b>		<b>0,1 vol</b>

\* See paragraph below for hardener and thinner selection

- As with all ultra-high solids products, cold ready for use paint temperatures can lead to more difficult application and overspray absorption. It is strongly recommended that ready for use product is applied at a temperature greater than 15°C.

## MIXING BY WEIGHT:

The weights are cumulative - please do **NOT** tare the balance between additions.

### Mixing Ratio 2:1 Vol.

Volume of RFU paint required (Litres)	Clearcoat D8131	Hardener D8254/D8255
0,1 L	66,4g	101,0g
0,2 L	132,8g	202,0g
0,25 L	166,0g	252,5g
0,5 L	332,0g	505,0g
0,75 L	498,0g	757,5g
1,0 L	664,0g	1010,0g

### Mixing Ratio 2:1:0,1

Volume of RFU paint required (Litres)	Clearcoat D8131	Hardener D8254/D8255	<b>Thinner D8746</b>
0,1 L	64,0 g	97,5 g	100,4 g
0,2 L	128,0 g	195,0 g	200,9 g
0,25 L	160,0 g	243,7 g	251,1 g
0,5 L	320,0 g	487,4 g	502,1 g
0,75 L	480,0 g	731,1 g	753,2 g
1,0 L	640,0 g	974,8 g	1004,3 g

## HARDENER AND THINNER SELECTION

<u>UHS Hardener</u>	<u>Application Temperature</u>
D8254	20-30°C, with low humidity
D8255	Above 30°C, with low humidity
D8746	For applications above 30°C, or large surfaces. Recommended for applications in high humidity.

## RFU MIXED PRODUCT DETAILS

<b>Pot-life at 20°C</b>	60 min at 20°C.
	90 minutes double viscosity

Viscosity RFU 15-17 seconds DIN4 cup at 20°C.

## SPRAYGUN SET UP

Spray Nozzle:	1.2-1,3 mm Fluid Tip
Spray Pressure:	2.0 - 2.2 Bar

## APPLICATION AND FLASH OFF



<i>Application</i>	<b>2 full coats</b>
<i>Flash off between coats</i>	<b>5 minutes flash off.</b>
	<b>OR</b>
	<b>1 Visit application. 1 light/medium &amp; 1 full coat. The first coat should be applied as a <u>light closed</u> coat. Second coat is applied as a full coat.</b>
<i>Flash off between coats</i>	<b>If only 1-2 panels, 1½-2 minutes flash off between coats.</b>
<i>Flash off before bake or IR</i>	<b>5 minutes</b>

Recommended film thickness: 50-60 µm dry film thickness

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## DRYING TIMES

- |                        |                                   |
|------------------------|-----------------------------------|
| - Through dry at 60°C* | 15 minutes at 60°C                |
| - Through dry at 40°C* | 40 minutes at 40°C                |
| - Air-dry at 20°C*     | 8 Hours at 20°C                   |
| - Through dry at IR    | 8 minutes (depending upon colour) |
| - Dry to handle        | After cooling down                |



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

*Total dry film build:* 50 – 60 µm

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## OVERCOATING/RECOATING

Overcoat / Recoat time - If Force dried, after cooling, or after Air drying.

It is essential to sand before recoating to ensure good adhesion.

Sand with P800 (wet) or P400 (Dry).

Overcoat with - Any PPG 2K primer, or GRS Deltron BC or Envirobase High Performance.

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## POLISHING

After the indicated baking time it is ready to polish after cooling down.

When air dry, ready to polish after 8 Hours @ 20°C.

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## FADE - OUT REPAIR PROCEDURE

- Prepare the fade out area with a 3000 grade soft pad on a DA sander.
- Take care to minimise the clearcoat edge in the fade-out area.
- Immediately melt the overspray edge using Spot Blender(Can version), applied by spray-gun (Mini-jet 1,0-1,2mm)
- After a thorough bake and cool down, polish process can be done.

## PAINTING OF PLASTIC SUBSTRATES - TEXTURED FINISHES

To obtain a textured finish with D8131 Rapid Performance Clearcoat, it is necessary to include flex or texture additives in the mix. Additives are also required when applying D8131 over a flexible substrate.

The additives required and the appropriate volume and/or weight mix ratios are indicated in the tables below.

**Note:** The majority of plastics used on cars are considered **Rigid**. These plastics may have some flexibility when painted off the car, but are rigid once mounted. UHS Clearcoats only require the addition of the Plasticiser Additive (See **Flexible** chart below) when painting very flexible plastics, mostly found on older vehicles, e.g. foam type.

### Cumulative Mixing by Weight

Do not tare the balance between additions

<u>Substrate</u>	<i>Appearance</i>	<i>D8131</i>	<i>D843</i>	<i>D844</i>	<i>D814</i>	<i>D819</i>	<i>D8254 or D8255</i>	<b>D8746</b>
<b>RIGID</b>	Gloss	659,3	-	-	-	-	1005,3	-
	Matt Textured	292,3	650,7	-	-	-	814,3	959,7
	Leather Grain	380,4	-	684,9	-	-	884,5	968,6
<b>FLEXIBLE</b>	Gloss	554,6	-	-	685,2	-	995,7	-
	Matt Textured	221,4	547,2	-	-	665,0	843,2	971,7
	Leather Grain	264,9	-	477,0	-	618,0	812,6	966,4

## EQUIPMENT CLEANING

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

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## HEALTH AND SAFETY

**These products are for professional use only**, and are not to be used for purposes other than those specified. The information on this TDS is based on present scientific and technical knowledge, and it is the responsibility of the user to take all necessary steps in order to ensure the suitability of the product for the intended purpose. For Health and Safety information please refer to the material Safety Data Sheet.

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## VOC INFORMATION

The EU limit value for this product (product category: IIB.d) in ready to use form is max. 420g/litre of VOC. The VOC content of this product in ready to use form is max. 420g/litre. Depending on the chosen mode of use, the actual ready to use VOC of this product may be lower than that specified by the EU Directive code.

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