



AUTO REFINISH

GLOBAL  
REFINISH  
SYSTEM



# Product information

## **Deltron D800**

*Clear*

### **PRODUCTS**

Deltron Clear	D800
Deltron Medium Solids Hardeners	D803, D841, D861
Deltron Standard Solids Hardener	D802
Deltron Thinners	D808, D807, D812, D869
Deltron DG Fade-out Thinner	D868

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 Matt Flexibiliser	D819	to create a matt or satin appearance 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**

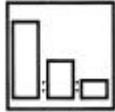
Deltron D800 is a high-performance two-pack acrylic urethane clearcoat designed for the repair and respray of cars and commercial vehicles as part of a basecoat/clearcoat repair process.

The performance of Deltron D800 in a recommended PPG repair system meets or exceeds motor manufacturer warranty requirements and the Deltron GRS system carries many OEM approval.

### **PREPARATION OF SUBSTRATE**

Deltron D800 Clear must be applied on top of a clean and dust-free Deltron GRS basecoat (the use of tack rag is recommended to remove dust from the basecoat film).

## PRODUCT SET-UP



Mixing ratio:

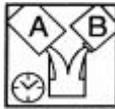
	<b>Standard System</b>		<b>MS System</b>	
D800	2 vol	D800	3 vol	
D802	1 vol	MS Hardener*	1 vol	
Thinner**	*1 vol	Thinner**	1 vol	

\* For high build, use 0.5 vol Thinner

\*\* Choose MS Hardener and Thinner according to application temperature:

Temperature	MS Hardener	Thinner
Up to 18°C	D803 Fast	D808
18°C - 25°C	D841 Medium	D807
Over 25°C	D861 Slow	D812

For exceptional conditions of temperature and humidity (> 35°C / >70%) the use of Very Slow Thinner D869 is recommended.



Potlife at 20°C:

6 - 8 hours

6 hours



Spray viscosity at 20°C:

15 seconds DIN4

17 - 18 seconds DIN4

## APPLICATION, FLASH-OFF AND DRYING



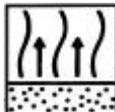
Spraygun set-up:

**Standard System**

1.4 - 1.8 mm

**MS System**

1.4 - 1.8 mm



Number of coats:

1 light , 1 medium, 1 full

1 medium, 1 full

Flash off at 20°C:

- Between coats
- Before stoving

10 minutes  
15 minutes

10 minutes  
10 - 15 minutes



Drying times:\*

- Dust free at 20°C
- Dry to handle at 20°C
- Through dry at 20°C
- Through dry at 60°C\*\*
- IR medium \*\*\*

20 minutes  
4 hours  
20 hours  
30 minutes  
10 -15 minutes

30 minutes  
4 hours  
20 hours  
30 minutes  
10 - 15 minutes

\* Drying times may be reduced still further by using the Deltron Accelerated System. Substitute D863 Accelerated Hardener for D802 and dust-free time reduces to 10 minutes. Stoving at 60°C takes 20 minutes. Potlife is 3 - 4 hours. Adding 10gms or 10 mls of D818 Accelerator per litre of ready-to-spray paint mixture improves dust-free times to 15 minutes (with D802) or 5 minutes (with D803). Using D863 and D818 together reduces dust-free time to 5 minutes and through drying at 60°C to 15 minutes. Potlife is 3 - 4 hours.

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

\*\*\* Dependent on colour of basecoat; darker colours require less time.

## APPLICATION, FLASH-OFF AND DRYING

	<b>Standard System</b>	<b>MS System</b>
<i>Total dry film build:</i>		
- <i>Minimum</i>	Minimum 45 µm	Minimum 50 µm
- <i>Maximum</i>	Maximum 55 µm	Maximum 60 µm
<i>Theoretical coverage:</i>	assuming 100% transfer efficiency and dry film thickness as indicated:	
	5 - 6 m <sup>2</sup> /l	6 - 7 m <sup>2</sup> /l

## REPAIR AND RECOATING



*Sanding:* Essential before recoating to ensure good adhesion  
P800 (wet)  
P400 (dry)



*Overcoat / recoat time:*  
- *Force dry 60°C or IR* After cooling  
- *Air dry at 20°C* Minimum 8 hours

*Overcoat/Repair with:* PPG 2K primers  
Deltron GRS topcoats  
Envirobase

## MATT, SATIN AND TEXTURED FINISHES PAINTING OF FLEXIBLE SUBSTRATES

To obtain a matt, semi-matt (satin) or textured finish with Deltron 800 Clear, it is necessary to include a suitable or matt, flex or texture additives in the mix. Additives are also required when applying D800 over a flexible substrate (typically plastics). The additives required and the appropriate volume and weight mix ratios are indicated in microfiches if relevant or in the tables below.

Note : **RIGID** substrates include all metals, fibreglass & GRP  
**FLEXIBLE** substrates are all plastic types except GRP

Substrate	Appearance	D800	D759	D843	D844	D814	D819	MS hardener	Deltron thinner
<b>RIGID</b>	Gloss	3 vol	-	-	-	-	-	1 vol	1 vol
	Satin	3 vol	1.5 vol	-	-	-	-	1.5 vol	1 vol
	Matt	3 vol	3 vol	-	-	-	-	1.5 vol	2 vol
	Matt Textured	3 vol	-	3 vol	-	-	-	1.5 vol	2 vol
	Leather Grain	3 vol	-	-	1.5 vol	-	-	1.5 vol	1 vol
<b>FLEXIBLE</b>	Gloss	3 vol	-	-	-	1 vol	-	2 vol	-
	Satin	4 vol	2 vol	-	-	-	2 vol	3.5 vol	0.5 vol
	Matt	4 vol	4 vol	-	-	-	2 vol	3.5 vol	1.5 vol
	Matt Textured	4 vol	-	4 vol	-	-	2 vol	3.5 vol	1.5 vol
	Leather Grain	4 vol	-	-	2 vol	-	2 vol	3.5 vol	0.5 vol

## SPOT REPAIR PROCEDURE

- Apply Deltron D800 Clear according to the 'Application, Flash-Off and Drying' section above.
- Leave to flash-off for 10 minutes/20°C after the 2<sup>nd</sup> coat.
- A suitable quantity of activated and thinned D800 Clear should then be reduced with Deltron DG Fade-Out Thinner D868 at a ratio of 1:3 (1 part activated and thinned Clear to 3 parts D868).
- Apply this 1:3 mix over the repair area, using a reduced gun pressure to minimise overspray. Spray from the outside of the repair inwards, covering an area that extends beyond the edge of the initial application.
- After force dry or IR, buff the repair edges.



## 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

For comprehensive Health, Safety and Environmental advice, please refer to the relevant Material Safety Data Sheets and product can labels.  
Use the recommended safety equipment.

### 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 enquiries 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. Film thickness, humidity and shop temperature can all affect drying times.



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