

PPG Technical Service Bulletin

Date: February 2008

Subject: **D8122 CeramiClear™ Mar and Scratch Resistant Clearcoat**

D8122 CeramiClear™ is a mar and scratch resistant, high solid clearcoat. This clear is especially designed for the repair of Nissan Cars that have ASAP clearcoat. D8122 contains the CeramiClear™ technology that gives excellent scratch resistance. D8122's excellent surface properties minimize the visible marring caused by car washing and polishing.

D8122 CeramiClear™ is fully compatible for the use with Envirobase High Performance and GRS BC. The Ready-for-Use (RFU) VOC of D8122 is < 420 g/l (3.5 lbs. per US gal.). Please check your local VOC regulations.

For detailed information please refer to the product datasheet RLD195V.

Preparation of Substrate



Cleaning:

Wash all surfaces to be painted with soap and water, then apply the appropriate Global cleaner. See refinish bulletin RLD63V Deltron DX Cleaners for selection and usage instructions. Ensure that the substrate is thoroughly cleaned and dried both before and after application work.



Dry sand with U.S. 400-500 / European P600-800 grade paper.



Wet sand with U.S. 500-600 / European P800-1200 grade paper











Wash off residue and dry thoroughly before re-cleaning with appropriate Global substrate cleaner. The use of a tack rag is recommended.



Apply Global BC Color or Envirobase Color over original baked finishes or over recommended Global Primers. See Data Sheet RLD02 for Global Basecoat Color or RLD125V / RLD213V Envirobase High Performance Color for application details.

Deltron D8122 – CeramiClear™

	<p>Mixing Ratio</p> <p>D8122 HS Hardener* Thinner*</p>	<p>3 vols 1 vol 0.5 vols</p>	<p>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.</p> <p>Hardener and Thinner Selection</p> <p>Choose HS hardener and thinner according to application temperature:</p> <table border="1"> <thead> <tr> <th>Temperature</th> <th>HS Hardener</th> <th>Thinner</th> </tr> </thead> <tbody> <tr> <td>Up to 18°C</td> <td>D8208</td> <td>D808</td> </tr> <tr> <td>18°C - 25°C</td> <td>D897</td> <td>D807 / D8718</td> </tr> <tr> <td>Over 25°C</td> <td>D897</td> <td>D812 / D8719</td> </tr> </tbody> </table> <p>For exceptional conditions of temperature and humidity (over 35°C / over 70% RH) the use of D869 Very Slow thinner is recommended. Use HS Hardener D8208 / D808 for Spot Repairs.</p>	Temperature	HS Hardener	Thinner	Up to 18°C	D8208	D808	18°C - 25°C	D897	D807 / D8718	Over 25°C	D897	D812 / D8719
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	<p>Pot Life at 20°C</p>	<p>1 hour with D897 hardener</p>													
	<p>Application Viscosity</p>	<p>19 - 21 seconds / DIN4 / 20°C</p>													
	<p>Spraygun Setup</p>	<p>Fluid Tip: 1,3 – 1,6 mm Set pressure according to manufacturers recommendations</p>													
 	<p>Conventional Two Coat Process</p> <p>Apply 2 single coats to give 50 - 60 µm dry film build.</p> <p>Flash off between spray coats: 10 minutes</p> <p>Flash off before bake or IR dry: 5 – 10 minutes</p>	<p>Express Single Visit Process</p> <p>Apply 1 medium and 1 full coat to give 45 - 50 µm dry film build.</p> <p>The first coat should be applied to all repair panels before the second coat is applied.</p> <p>Flash off between spray coats: for less than 3 panels: 2 – 3 minutes; for more than 3 panels, no flash off is required.</p> <p>Flash off before bake or IR dry: 5 – 10 minutes</p>													
	<p>Drying times:</p> <ul style="list-style-type: none"> • Through dry at 60°C • Through dry with IR (Medium) • Through dry with IR (Short) 	<p>30 – 40 minutes* 15 minutes (IR drying is color dependant)* 8 – 15 minutes (IR drying is color dependant)*</p>	<p>* Stoving times are for quoted metal temperature. Additional time should be allowed in the stoving schedule to allow the metal to reach recommended temperature. Drying times may be reduced by using D885 Deltron Enhancer.</p>												
	<p>Deltron D8122 can be polished after drying for 30 minutes at 60°C and cooling down for a minimum of 1 hour. PPG recommends to polish D8122 within 1 to 2 hours after painting. Polishing after a longer time period leads to a strong increase of work and time.</p> <p>Note: for best results D8122 should be used for full panel repairs.</p> <p>See detailed process below.</p>														

Deltron D8122 – CeramiClear™ (cont.)

	Sanding:	Essential before recoating to ensure good adhesion
	<ul style="list-style-type: none"> • Grade wet P800 • Grade dry P400 	
	Overcoating / Re-Coat time	
	<ul style="list-style-type: none"> • After force drying / IR After Cooling • Air Drying at 20°C Minimum 12 hours 	
Overcoat with:	GRS Deltron 2K primers, Envirobase, GRS Deltron Topcoats	

CeramiClear™ – Removing of Dust and Dirt

	3M™ Trizact™ Finesse-it™ film discs are recommended to sand out dust or dirt
	Remove any sanding scratches with a 75-mm 3M™ Trizact™ Finesse-it™ fine sanding disc P3000 (wet) and an eccentric sander (sanding stroke 3 mm)
	Polish the repaired area with PPG Speciality Performance Products SPP1001 and the orange SPP compounding foam pad (SPN1902) on an adjustable buffing machine (approx. 1.500 rpm)
	To achieve a mirror gloss finish the repaired area with the black SPP final polishing pad (SPN1903)

PPG would like to recommend the following 3M products:

CeramiClear™ – Removing of Dust and Dirt (3M-Process)

	<ul style="list-style-type: none"> • DA Sand with 3M 1500 grit to remove small imperfections • DA Sand with interface pad and 3M P3000 Trizact with water lubricant
	<ul style="list-style-type: none"> • Compound with 06060 Extra Cut Compound • Followed by 06064 Swirl Mark Remover • Followed by 06068 UltraFina SE



VOC Information



2004/42/IB
(d)(420)420

The EU limit value for this product (product category:11B.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 upon 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.

VOC Information – R.O.W



The VOC content of this product in ready to use form is max. 420g/litre (3.5 lbs. per US gal.).

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, also available at:

http://corporateportal.ppg.com/Refinish/Europe/Scandinavia/1000_Collision/1300_TrainingandTechnical/EN/1330_MSDS.htm

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