



GLOBAL REFINISH  
SYSTEM

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# Product Information

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## D831 Chromate-Free Wash Primer

### Product Description

D831 is a beige two-component pigmented etch primer. The primer base is chromate-free and is mixed with a choice of acid-based Reactive Thinners. It is universal in application and promotes adhesion over a wide range of substrates.

D831 may be overcoated with all Global 2K primers.

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### Preparation of Substrate



Wash all surfaces to be painted with soap and water, then apply the appropriate Global cleaner. See EU-134 Global Cleaners bulletin for selection and usage instructions. Ensure that the substrate is thoroughly cleaned and dried both before and after application work.



Aluminum, Bare Steel and Galvanized Steel must be clean, rust-free and abraded thoroughly using U.S. 180 / European P180 to U.S. 240 / European P280 grit paper (wet).



D831 is not recommended for use on Fiberglass. In cases where D831 is being applied to bare metal that is adjacent to fiberglass, a slight overlap is acceptable only where the fiberglass substrate has been properly scuffed and cleaned.

Do not apply D831 directly over or under body filler. Slight overlaps of D831 onto body filler or painted surfaces is acceptable, but should be kept to a minimum.

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## APPLICATION GUIDE:

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### Mix Ratio:



**D831 Chromate-Free Wash Primer:** 1 vol

**\*D832 Reactive Thinner:** 1 vol

\* For exceptional conditions of temperature and humidity (>95°F (35°C) and >70% RH), use **D833 Slow Reactive Thinner**.



\* For extreme temperature conditions, over and above the use of D833, an additional 10% of D873 Slow Thinner may be added to the ready-to-spray product. Two coats may be required for proper film build if additional thinner is added.



Potlife @ 68°F / 20°C:

24 hours

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### Additives:



None

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### Spraygun set-up:

*Fluid Tip*

1.3 – 1.6 mm or equivalent

*Spray Viscosity*

20 seconds #2 ZAHN @ 68°F / 20°C

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### Spray pressure:



*HVLP at air cap*

10 PSI

*Conventional at spray gun*

40 – 50 PSI

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### Number of coats:



*Apply:*

1 – 2 wet coats

*Film build per wet coat*

2.0 – 2.5 mils

*Dried film build per coat*

0.5 – 0.6 mils

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### Flash off at 68°F / 20°C:

*Between Coats*

5 minutes

*Before Baking*

5 minutes

*Before Topcoating*

20 minutes for 1 coat

30 minutes for 2 coats

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## APPLICATION GUIDE

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### Drying times:



*Dust-free*

68°F / 20°C

5 minutes

*Dry to Handle*

68°F / 20°C

20 minutes



*Dry to Sand*

68°F / 20°C

30 – 45 minutes

140°F / 60°C

20 minutes\*



*Tape Time*

68°F / 20°C

15 – 30 minutes

140°F / 60°C

20 minutes\*

\* All force dry times are quoted for metal temperature. Additional time must be allowed during force dry to allow metal to reach recommended temperature.

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### Overcoat/Recoat:



*Overcoat/Recoat Time*

15 – 30 minutes minimum, 24 hours maximum.

After 24 hours, lightly scuff D831. Always maintain a film build of 0.5 mil at a minimum.

Recoat with additional D831 if necessary.



*Grade wet*

U.S. 500 / European P800

*Grade dry*

U.S. 400 / European P600



*Overcoat with*

Any 2K surfacer or sealer before topcoat application.

*BC or DG cannot be directly applied to D831.*

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### Technical Data:

#### Total dry film build

Minimum 0.5 mils

Maximum 1 mils

Recommended film build per wet coat 2.0 – 2.5 mils

Recommended dried film build per coat 0.5 – 0.6 mils

#### Theoretical coverage

305 sq.ft. per US gal.

*Theoretical coverage in sq.ft./US gal. Ready-to-spray (RTS), giving 0.6 mils dry film thickness.*

#### Percent solids by volume RTS

11.4%

#### VOC

D831 5.4 lbs. per US gal.

D831 : D832, 1 : 1 6.1 lbs. per US gal.

## Chromate-Free Wash Primer

### Mix Ratio:



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*\* For exceptional conditions of temperature and humidity (>95°F (35°C) and >70% RH), use **D833 Slow Reactive Thinner**.*

*\* For extreme temperature conditions, over and above the use of D833, an additional 10% of D873 Slow Thinner may be added to the ready-to-spray product. Two coats may be required for proper film build if additional thinner is added.*

Potlife @ 68°F / 20°F: 24 hours

### Additives:



None

### Spraygun set-up:



Fluid Tip	1.3 – 1.6 mm or equivalent
Spray Viscosity	20 seconds, #2 Zahn @ 68°F / 20°F
HVLP at air cap	10 PSI
Conventional at spray gun	40 – 50 PSI

### Application:



Apply:	1 – 2 wet coats
Between coats	5 minutes
Before baking	5 minutes
Film build per wet coat	2.0 – 2.5 mils
Dried film build per coat	0.5 – 0.6 mils

### Drying times:



Dust-free 68°F / 20°C	5 minutes
Dry to Handle 68°F / 20°C	30 minutes
Dry to Sand 68°F / 20°C 140°F / 60°C	30 – 45 minutes 20 minutes*
Tape Time 68°F / 20°C 140°F / 60°C	15 – 30 minutes 20 minutes*
Overcoat/Recoat Time	15 – 30 minutes minimum, 24 hours maximum. After 24 hours, lightly scuff D831. Always maintain a film build of 0.5 mil at a minimum. Recoat with additional D831 if necessary.
Overcoat with	Any 2K surfacer or sealer before topcoat application. <i>BC or DG cannot be directly applied to D831.</i>

*\* All force dry times are quoted for metal temperature. Additional time must be allowed during force dry to allow metal to reach recommended temperature.*

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## Health and Safety:



See Material Safety Data Sheet and Labels for additional safety information and handling instructions.



- The contents of this package may have to be blended with other components before the product can be used. Before opening the packages, be sure you understand the warning messages on the labels and MSDS's of all the components, since the mixture will have the hazards of all its parts.
- Improper handling and use, for example, poor spray technique, inadequate engineering controls and/or lack of proper Personal Protective Equipment (PPE), may result in hazardous conditions or injury.
- Follow spray equipment manufacturer's instructions to prevent personal injury or fire.
- Provide adequate ventilation for health and fire hazard control.
- Follow company policy, product MSDS and respirator manufacturer's recommendations for selection and proper use of respiratory protection. Be sure employees are adequately trained on the safe use of respirators per company and regulatory requirements.
- Wear appropriate PPE such as eye and skin protection. In the event of injury, see first aid procedures on MSDS.
- Always observe all applicable precautions and follow good safety and hygiene practices.

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### Emergency Medical or Spill Control Information (412) 434-4515; In Canada (514) 645-1320

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Materials described are designed for application by professional, trained personnel using proper equipment and are not intended for sale to the general public. Products mentioned may be hazardous and should only be used according to directions, while observing precautions and warning statements listed on label. Statements and methods described are based upon the best information and practices known to PPG Industries. Procedures for applications mentioned are suggestions only and are not to be construed as representations or warranties as to performance, results, or fitness for any intended use, nor does PPG Industries warrant freedom from patent infringement in the use of any formula or process set forth herein.

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