



GLOBAL REFINISH
SYSTEM

Product Information

D820 Plastic Adhesion Promoter

Product Description

D820 is for use on the variety of plastic substrates found on motor vehicles. D820 provides adhesion for subsequent Global 2K primers and topcoats.

Preparation of Substrate



Wash all surfaces to be painted with soap and water. Degrease all surfaces with D846 Degreasing Agent for Plastics (See EU-134 Global Cleaners bulletin for usage instructions).



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



Wet flat with European P600 / U.S. 400 grade paper (use finer grit paper for softer plastics), and clean again with D846 Degreasing Agent for Plastics.

APPLICATION GUIDE:

Mix Ratio:



D820 is supplied ready-to-spray, no thinning is necessary.
Always shake well before using.



Potlife: None

Additives:



None

Spraygun set-up:



Fluid Tip 1.3 - 1.5 mm or equivalent

Spray pressure:

HVLP at air cap 7 - 10 PSI

Conventional at spray gun 55 PSI

Number of coats:



Apply 1 wet coat

Film build per wet coat 0.4 mils

Dried film build per coat 0.2 mils

Flash off at 68°F / 20°C:



Before Topcoat 30 Minutes

Drying times:



Dust-free
68°F / 20°C: 2 Minutes



Dry to handle
68°F / 20°C: 15 minutes



Through Dry
68°F / 20°C: 30 Minutes
140°F / 60°C: 15 minutes

Stoving times are quoted for metal temperature. Additional time should be allowed in the force-drying schedule to allow metal to reach recommended temperature.

APPLICATION GUIDE

Overcoat / Recoat:



Overcoat / Recoat
@ 68°F / 20°C:

30 Minutes Minimum
24 Hours Maximum

Grade wet

N/A

Grade dry

N/A



Overcoat with

Any Global 2K primer (Except D831) or Topcoat.

Technical Data:

Total dry film build

Minimum	0.2 mil
Maximum	0.2 mil
Recommended film build per wet coat	0.4 mils
Recommended dried film build per coat	0.2 mils

Theoretical coverage 249 sq.ft. per US gal.

Theoretical coverage in sq.ft./US gal. ready-to-spray (RTS), giving 0.2 mils dry film thickness

Percent solids by volume RTS 3.1

VOC

D820 7.0 lbs per U.S. gal.

Health and Safety:



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

- Before opening the package, be sure all the warning messages on the label and MSDS are understood.
- 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.

Plastics Adhesion Promoter

Mix Ratio:



D820 is supplied ready-to-spray, no thinning is necessary.
Always shake well before using.



Potlife: None

Additives:



None

Air Pressure:



<i>HVLP</i>	7 - 10 PSI at air cap
<i>Conventional</i>	55 PSI at spray gun
<i>Fluid Tip</i>	1.3 - 1.5 mm or equivalent

Application



<i>Apply</i>	1 wet coat
<i>Film build per wet coat</i>	0.4 mils
<i>Dried film build per coat</i>	0.2 mils

Drying times:



<i>Dust-free</i> 20° C / 68° F	2 Minutes
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<i>Dry to handle</i> 20° C / 68° F	15 minutes
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<i>Through Dry</i> 20° C / 68° F	30 Minutes
60° C / 140° F	15 minutes



<i>Overcoat / Recoat Time</i> <i>Minimum</i>	30 Minutes
<i>Maximum</i>	24 Hours

Overcoat with Topcoat. Any Global 2K primer (Except D831) or

Stoving times are quoted for metal temperature. Additional time should be allowed in the force-drying schedule to allow metal to reach recommended temperature.

Emergency Medical or Spill Control Information (304) 843-1300; In Canada (514) 645-1320

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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