GLOBAL REFINISH SYSTEM

Product Information

DGLV Direct Gloss LV Color

Product Description

Global Refinish System DGLV is a high-performance two-pack acrylic urethane topcoat designed for the direct gloss repair and respray of cars and commercial vehicles, where local regulations require a maximum VOC of 3.5 lb./gal.

The performance of Global Refinish System DGLV in a recommended Global repair system meets or exceeds motor manufacturer warranty requirements and the Global Refinish System carries many OEM approvals.

Preparation of Substrate:

Apply over original baked finishes or over recommended Global primers.

In all cases, wash all surfaces to be painted with soap and water, then apply the appropriate Global cleaner. See GLG-142 Global Cleaners bulletin for selection and usage instructions. Ensure that the substrate is thoroughly cleaned and dried both before and after application work.

Apply DGLV Color after (WET) sanding with European P600-800 / U.S. 400 – 500 grade paper or dry sanding with European P400 – 600 / U.S. 360 – 400 grade paper.

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

APPLICATION GUIDE:

Mix Ratio:

DGLV	**2 vols**
D884 Hardener	**1 vol**
Add Thinner	**5 – 10% by volume**
Add D885/D886	**1 oz. per ready-to-spray quart**

Potlife @ 20°C / 68°F 1 - 2 hours @ 20°C / 68 °F temperature:

Use the below chart to choose the appropriate thinner and additive according to the application

Thinner:

Temperature	Thinner	Dry Method	Additive
Up to 18°C / 65°F	D8764	Air Dry	1 oz. D885
18° – 25°C / 65° – 77°F	D8774	Air Dry	1 oz. D885
Over 25°C / 95°F	D8767	Air Dry/Stoving	$^1/_2$ oz. D885 + $^1/_2$ oz. D886

Additives:

D885 Accelerator and/or D886 Extender are required to properly mix DGLV. Use the ratios found in the mixing section.

D814 Plasticiser: Mix at **2 : 2 : 1 : 1 (DG : Hardener : D Thinner : D814)**
See EU47 for further information on D814 Plasticiser.

Spraygun set-up:

Fluid Tip	1.3 – 1.5 mm or equivalent
Spray Viscosity	20 – 30 secs ZAHN 2 @ 20°C / 68°F

Spray pressure:

HVLP	0.7 bar / 10 PSI (*at air cap)*
Conventional	3 – 4 bar / 45 – 55 PSI (*at spray gun)*

Number of coats:

Apply	2 – 3 coats or until hiding
Film build per wet coat	2.0 mils
Dried film build per coat	1.0 mils

Flash off at 20°C / 68°F:

Between coats	3 – 7 minutes
Before stoving	0 – 10 minutes

Drying times:

Dust-free 20°C / 68°F	50 – 70 minutes
Dry to handle 20°C / 68°F	6 – 8 hours

Tape Time

20°C / 68°F	6 – 8 hours
60°C / 140°F	3 hours

Through dry

20°C / 68°F	24 hours
60°C / 140°F	30 minutes

IR (Infrared

Medium Wave	10 – 15 minutes, depending on color
Short Wave	8 minutes, depending on color.

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

APPLICATION GUIDE

Overcoat/Recoat:

Recoat

After surface has cooled if stoved, or
after 8 hours minimum @ 20°C /68°F

For best adhesion, sanding is essential before recoating

Grade wet European P800 / U.S. 500
Grade dry European P400 / U.S. 360

Overcoat with

With any Global primers, topcoats or clearcoats.
Clearcoats can be applied after a minimum of 2 hours dry.

Performance Guidelines:

Recoating times will be extended at lower temperatures. Global Refinish System DGLV may be sanded with 1200 grit paper or finer and polished when hard, to rectify minor imperfections.

Fading Out:

After spot repairing, mix equal parts of RTS CLV and D853, Global Refinish System Fade-Out Thinner. Spray this mixture around the repaired area to lose the edge and blend the repair into the surrounding panel. Spray starting from the outside of the repair, moving to the center.

Product Compatibility

DGLV may be applied over:

Cured Air Dry Finishes
OEM Basecoat/Clearcoat *(must be sanded)*
OEM Enamels *(must be sanded)*
OEM & Refinish Lacquers *(must be sanded & sealed)*
D820 Plastic Adhesion Promoter
D822 Corrosion Resistant Primer *(not in Rule 1151 area)*
D831 Chromate Free Wash Primer (must be sealed or primed afterwards)
D891 Sealer *(not in Rule 1151 area)*
D8002 UHS Surfacer
D8006 UHS Sealer
D8080 UV Cured Primer Surfacer
SX/SXA1050 Plastic Adhesion Promoter *(Specialty Performance Products)*

Technical Data:

Total dry film build:

Minimum	50µ/2.0 mils
Maximum	100µ/4 mils

Theoretical coverage 10.3 m^2 per liter / 417 sq.ft. per US gal.

Theoretical coverage in m^2/litre and sq.ft./US gal. Ready-to-spray (RTS), giving 50µm (2 mils) dry film thickness.

Percent solids by volume RTS 52%

VOC

DGLV Color	479 - 515 gms per liter / 4.0 – 4.3 lbs. per U.S. gallon
DGLV: D884 + D872 + D885/D886, 2:1+5% by vol.+1 oz./RTS qt.	419 gms per liter / 3.5 lbs. per U.S. gallon

Global at a Glance

DGLV

Direct Gloss LV Color

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Additives:

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D814 Plasticiser	Mix at **2 : 2 : 1 : 1 (DG : Hardener : D Thinner : D814)** See EU47 for further information on D814 Plasticiser.

Air Pressure:

HVLP	0.7 bar / 10 PSI at the cap
Conventional	3 – 4 bar / 45 – 55 PSI at the gun

Application:

Apply	2 – 3 coats or until hiding
Between coats	3 – 7 minutes
Before stoving	0 – 10 minutes
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Dry Times:

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Tape Time	
20°C / 68°F	6 – 8 hours
60°C / 140°F	3 hours*
Through Dry	
20°C / 68°F	24 hours
60°C / 140°F	30 minutes*
IR (infrared)	
Medium wave	10 – 15 minutes, depending on color
Short wave	8 minutes, depending on color

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

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.

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

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