



AUTOMOTIVE REFINISH

GLOBAL
REFINISH
SYSTEM



Product Information

Precoats

D839 2K Precoat

A Precoat is any coating which is applied to bare metal primarily to deactivate the metal surface prior to application of a subsequent primer surfacer.

**BAAQMD
Precoat
Application:**

When used as a Precoat, this product must be followed by a Primer Surfacer of 2.1 Lbs/Gal or less. Precoat usage may be only 25% of total undercoat volume usage.

Preparation of Substrate



In all cases, wash with soap and water, then use 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 preparation work.



Aluminum, Bare Steel and Galvanized Steel must be clean, rust-free and abraded thoroughly using European P180 / U.S. 180 to European P280 / U.S. 240 grit paper and primed with D831 Chromate-Free Wash Primer after sanding.



Ensure that the substrate is thoroughly cleaned and dried after preparation work.

D839 2K Precoat

D839 has been specifically designed as a premium quality Precoat for today's advanced technology finishes. D839 can be used over properly prepared and treated bare steel and aluminum.

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APPLICATION GUIDE

Mixing Ratio:



D839	4 parts
D802 Hardener	1 part
Global D Series Thinner*	½ part

*Do not use D8767 in D839 Precoat

Thinner Selection:

Temperature

Thinner

	Up to 18°C / 65°F	D870
	18° - 25°C / 65° - 77°F	D871
	25° - 35° C / 77° - 95°F	D872
	Over 35°C / 95°F	D873
Retarder (Up to 25%)	Very Warm	D8700
Compliant	Cool	D8764
Compliant	Med	D8774
Compliant	Warm	D8767

Potlife:



1 hours @ 21°C / 70°F.

Additives:



D885 - 1oz to RTS qt

Spraygun set-up:



1.6 - 1.8 mm or equivalent

Spray pressure:

HVLP at air cap	0.7 bar / 10 PSI
Conventional at spray gun	4 bar / 55 PSI

Number of coats:



1 – 2 coats

APPLICATION GUIDE (continued)

Drying times:



Dry time between coats	5 – 10 minutes
Before stoving 20°C / 68°F:	10 minutes
Dry to sand 20°C / 68°F	2 hours
60°C / 140°F	30 minutes*
Dry to sand IR medium	20 minutes

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

Technical Data:

Total dry film build

minimum	50µm / 1.5 mils
maximum	100µm / 3.0 mils

Theoretical coverage @ 1mil 100 %

transfer efficiency 573 sq. ft. per US/gal/14.0 M² per litre

Percent solids by volume RTS

35.7

VOC

D839 package	503 gms per litre / 4.2 lbs per US gal
D839 package less exempt solvents	503 gms per litre / 4.2 lbs per US gal
D839:D802:D800 Series thinner (4:1:½)	551 gms per litre / 4.6 lbs per US gal
D839:D802:Compliant thinner (4:1:½)	575 gms per litre / 4.8 lbs per US gal
D839:D802:Compliant thinner (4:1:½) less exempt solvents	527 gms per litre / 4.4 lbs per US gal

Overcoats:



D824 Prime-Fill
D848 Waterborne 2K Primer Surfacer
D860 Low VOC Primer Surfacer
D8002 Ultra High Solids Surfacer

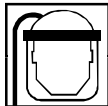
Performance Guidelines:

The use of HVLP spray equipment can increase transfer efficiency by a minimum of 10% depending on the make and model of equipment used.

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

Materials described are designed for application by professional, trained personnel using proper equipment and are not intended for sale to the 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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