



GLOBAL REFINISH
SYSTEM

Product Information

D8099 Anti-Corrosion Etch Primer

Product Description

D8099 is an Anti-Corrosion Etch Primer specifically designed to provide excellent adhesion and corrosion resistance to properly prepared steel and aluminum while offering fast drying characteristics.

D8099 also serves as a pretreatment coating in areas where VOC compliance is required.

D8099 must be mixed with D8299 Anti Corrosion Etch Primer Catalyst.

Preparation of Substrate



Wash all surfaces to be painted with soap and water. Degrease all surfaces with appropriate Global substrate cleaner. (See GLG-142 Global Cleaners bulletin for selection and usage instructions.)



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.

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



D8099 is not recommended for use on Fiberglass. In cases where D8099 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.

APPLICATION GUIDE:

Mix Ratio:



D8099 Anti-Corrosion Etch Primer 1 Vol.
D8299 Anti-Corrosion Etch Primer Catalyst 1 Vol.

To avoid poor adhesion and drying characteristics, do not apply excessive film builds.



Pot Life: 24 hours at 70°F (21°C)

Additives:



None

Spraygun set-up:



Fluid Tip 1.3 – 1.5mm or equivalent
Spray Viscosity 17 seconds, #2 Zahn Cup

Spray pressure:

HVLP at air cap 4 bar / 10 PSI at the cap
Conventional at spray gun 2.5 – 3.0 bar / 35 – 40 PSI at the gun

Number of coats:



Apply 1 even coat
Film build per wet coat 3.0 – 5.0 mils
Dried film build per coat 0.2 – 0.3 mils

Flash off at 20°C / 68°F:



Between stoving 5 minutes
Before topcoat 10 minutes

Drying times:



Dust-free 20°C / 68°F 5 minutes

Dry to Handle
20°C / 68°F 15 minutes



Dry to Sand
20°C / 68°F 30 minutes
60°C / 140°F 10 minutes*



Tape Time
20°C / 68°F 30 minutes
60°C / 140°F 15 minute*

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

Warning: Chrome dust is hazardous. Be sure to wear adequate respiratory equipment while sanding or spraying. See the warnings on the label and MSDS for additional information.

APPLICATION GUIDE

Overcoat/Recoat:



Dry to topcoat

10 minutes minimum, 24 hours maximum.
After 24 hours, lightly scuff D8099.
Always maintain a minimum film build of 0.2 mil.
Recoat with additional D8099 if necessary.



Overcoat with

D8099 must be overcoated with a recommended 2K surfacer or sealer before any topcoat application.

Technical Data:

Total dry film build:

Minimum	5.0 μ / 0.2 mils
Maximum	10.0 μ / 0.4 mils
Recommended film build per wet coat	75.0 μ / 3.0 mils
Recommended dried film build per coat	5.0 μ / 0.2 mils

Theoretical coverage 5.7 m² per litre / 233 sq. ft. per U.S. gal.

Theoretical coverage in m² per litre and sq.ft. /US gal. Ready-to-spray (RTS), giving 10 μ m (0.4 mils) dry film thickness

Percent solids by volume RTS 5.8%

VOC

D8099	732 gram per litre / 6.1 lbs. per U.S. gal.
D8099: D8299, 1:1	781 gram per litre / 6.5 lbs. per U.S. gal.

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.



Anti-Corrosion Etch Primer

Mix Ratio:



D8099 Anti-Corrosion Etch Primer: 1 vol.

D8299 Anti-Corrosion Etch Primer Catalyst: 1 vol.



Pot life @ 20°C / 68°F 24 hours

Additives:



None

Air Pressure:



HVLP 4 bar / 10 PSI at the cap
Conventional 2.5 – 3.0 bar / 35 – 40 PSI at the gun
Fluid tip 1.3 – 1.5 mm or equivalent
Spray Viscosity: 17 seconds, #2 Zahn Cup

Application:



Apply 1 even coat
Film Build Per Wet Coat 3.0 – 5.0 mils
Dried Film Build Per Coat 0.2 – 0.3 mils

Dry Times:



Dust-free
 20°C / 68°F 5 minutes



Dry to Handle
 20°C / 68°F 15 minutes



Dry to Sand
 20°C / 68°F 30 minutes
 60°C / 140°F 10 minutes*



Tape Time
 20°C / 68°F 30 minutes
 60°C / 140°F 15 minutes*



Dry to topcoat 10 minutes minimum, 24 hours maximum.
 After 24 hours, lightly scuff D8099.
 Always maintain a minimum film build of 0.2 mil.
 Recoat with additional D8099 if necessary.

Overcoat with D8099 must be overcoated with a recommended 2K surfacer or sealer before any topcoat application.

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

Warning: Chrome dust is hazardous. Be sure to wear adequate respiratory equipment while sanding or spraying. See the warnings on the label and MSDS for additional information.

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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