



GLOBAL REFINISH
SYSTEM

Product Information

2K *A*-Chromatic Surfacer (National Rule)

D8001 White

D8005 Gray

D8007 Black

Product Description

The 2K A-Chromatic Surfacers (D800x) are premium quality primer surfacers suitable for the wide range of repair work done in today's refinish bodyshops.

2K A-Chromatic Surfacers offer excellent adhesion, film build, surface leveling and gloss holdout over a wide range of substrates. A variety of 2K A-Chromatic Surfacer grays can be achieved by intermixing the white, gray and black surfacers. This versatile, quick drying, easy to apply and sand primer may be applied as a conventional spray filler or primer surfacer.

Preparation of Substrate

In all cases, 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.



Original Paintwork should be sanded using U.S. 240 / European P280 grit discs (dry) or U.S. 320 / European P360 grade paper (wet). Exposed bare metal should be spot-primed with a suitable bare metal primer (see below).



Electrodeposition Primer must be thoroughly cleaned as outlined above. When using the 2K A-Chromatic Surfacer as a spray filler or primer surfacer, abrade the electrodeposition primer as recommended in the "original paintwork" section.



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 and primed with D831 Chromate-Free Wash Primer or D8099 Anti-Corrosion Etch Primer after sanding.

Polyester Body Fillers should be dry sanded with U.S. 180 / European P180 followed by U.S. 240 / European P280 grit paper.

Fiber Glass and SMC should be dry sanded using U.S. 240 / European P280 grit paper.

Plastic should be dry sanded with U.S. 400 / European P600 (use a finer grit for softer plastics) and prime first with D820 Plastic Adhesion Promoter.

APPLICATION GUIDE:

Mix Ratios:

When Mixed as:



Spray Filler Optimum Film Build

D800x 2K Surfacers : 4 Vols

D8291 2K Hardener : 1 Vol

Thinner : —



Primer Surfacer* Optimum Drying Speed

D800x 2K Surfacers : 4 Vols

D8291 2K Hardener : 1 Vol

Thinner : 1 Vol



*D885 may be added up to 1 oz. per ready-to-spray quart in the 4:1:1 option if desired.

Pot life when sprayed as a **Spray Filler** 30 minutes @ 70°F / 21°C

Pot life when sprayed as a **Primer Surfacer** 1 hour @ 70°F / 21°C

Compliant Thinner Selection:

D870: Up to 65°F / 18°C

D872: 77° – 95°F / 25° – 35°C

D871: 65° – 77°F / 18° – 25°C

D872: Over 95°F / 35°C

D8700 Retarder may be mixed with thinners in temperatures over 95°F / 35°C. The retarder should be mixed up to 10% with the appropriate thinner. Do not use retarder alone as a reducer.

Additives:



D814 Plasticiser

Ready-to-spray D800x 2K Surfacers: 10 Vols

D814: 1 Vol

Spraygun Set-up:



When Sprayed as a:

Spray Filler

Primer Surfacer

1.7 - 2.0 mm or equivalent

1.6 - 1.8 mm or equivalent

Spray Pressure:

HVLP at air cap

10 PSI

Conventional at spray gun

45 PSI

Number of Coats:



When Sprayed as a:

Spray Filler

Primer Surfacer

Apply

Up to a maximum of 4 wet coats

2 to 3 wet coats

Film build per wet coat

5.0 mils

4.0 mils

Dried film build per coat

2.0 mils

1.5 mils

Flash Off at 68°F / 21°C:



Between Coats

Spray Filler

Primer Surfacer

5 – 10 minutes

5 – 10 minutes

Before Baking

N/A

10 minutes

Drying Times:



Dust-free

Spray Filler

Primer Surfacer

68°F / 20°C

15 minutes

15 minutes

Dry to Handle

68°F / 20°C

60 minutes

60 minutes



Dry to Sand

68°F / 20°C

6 hour dry, preferably overnight

1 1/2 hours

140°F / 60°C

Do not force dry

30 minutes*



Tape Time

68°F / 20°C

N/A

N/A

140°F / 60°C

N/A

N/A



IR (Infrared)

Medium Wave

Do not force dry

20 minutes

Short Wave

10 minutes

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

APPLICATION GUIDE

Overcoat / Recoat:



Dry to Topcoat
68°F / 20°C
140°F / 60°C
Grade wet



Grade dry
Overcoat with

Spray Filler

6 hours (after sanding)
N/A
U.S. 400 / European P600 followed by
U.S. 600 / European P1200
U.S. 320 / European P360 followed by
U.S. 500 / European P1000
Envirobase or any Global Topcoat

Primer Surfacer

1½ hours (or after sanding)
30 minutes (or after sanding)

Performance Guidelines:

The use of HVLP spray equipment can give an increase in transfer efficiency of around 25% depending upon the make and model of equipment used.

When **Spot Priming** 2K A-Chromatic Surfacers, adopt the following procedures:

- Thoroughly sand the surface to the edge of the panel or an inch or two beyond the damaged area, whichever is the smaller.
- After applying the material and allowing it to dry as normal, be careful to thoroughly level the repair edge when sanding.
- Do not attempt spot repair on original or refinish thermoplastic applications, lacquer or 1K finishes.

Also... 2K A-Chromatic Surfacer and its ancillaries are sensitive to moisture, so all equipment must be perfectly dry. Partially used cans of hardener must be carefully closed.

Technical Data:

	<u>Spray Filler</u>	<u>Primer Surfacer</u>
Total dry film build:		
Minimum after sanding	2.0 mils	2.0 mils
Maximum after sanding	10.0 mils	6.0 mils
Film build per wet coat	5.0 mils	4.0 mils
Dried film build per coat	2.0 mils	1.5 mils
% solids by volume RTS	42.0	35.0
Theoretical coverage	Approx. 674 sq.ft. / US Gal	Approx. 561 sq.ft. / US Gal
<i>Theoretical coverage in sq.ft./US gal. ready-to-spray (RTS), 1.0 mil dry film thickness.</i>		
VOC		
(D8001/D8005/D8007)	4.19 lbs. per US gal. / 504 gms per liter	
(D8001/D8005/D8007:D8291, 4:1)	4.20 lbs. per US gal. / 504 gms per liter	
(D8001/D8005/D8007:D8291:D870, 4:1:1)	4.69 lbs. per US gal. / 564 gms per liter	

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.

Global at a Glance

2K *A*Chromatic Surfacer

D8001 White
D8005 Gray
D8007 Black

Mix Ratio:

When Mixed as:

Spray Filler Optimum Film Build

Primer Surfacer * Optimum Drying Speed



D800x 2K Surfacer : 4 Vols

D8291 2K Hardener : 1 Vol

Thinner : —



D800x 2K Surfacer : 4 Vols

D8291 2K Hardener : 1 Vol

Thinner : 1 Vol

*D885 may be added up to 1 oz. per ready-to-spray quart in the 4:1:1 option, if desired.

Note: Spray filler and Primer Surfacer applications **must** be sanded.

Pot life when sprayed as a

Spray Filler: 30 minutes @ 70°F / 21°C

Primer Surfacer: 1 hour @ 70°F / 21°C

Thinner Selection

D870: Up to 65°F / 18°C

D872: 77° – 95°F / 25° – 35°C

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D872: Over 95°F / 35°C

D8700 Retarder may be mixed with thinners in temperatures over 95°F / 35°C.

The retarder should be mixed up to 10% with the appropriate thinner. Do not use retarder alone as a reducer.



Additives:



D814 Plasticiser

Ready-to-Spray

D800x 2K Surfacer: 10 vols

D814: 1 vol

Air Pressure:



HVLP

10 PSI at the cap

Conventional

45 PSI at the gun

When sprayed as a

Spray Filler: 1.7 – 2.0 mm or equivalent

Primer Surfacer: 1.6 – 1.8 mm or equivalent

Application:



Apply

Up to a maximum of 4 wet coats

Primer Surfacer

2 to 3 wet coats

Film build per wet coat

5.0 mils

4.0 mils

Dried film build per coat

2.0 mils

1.5 mils

Between Coats

5 – 10 minutes

5 – 10 minutes

Before Baking

N/A

10 minutes

Dry Times:



Dust-free

68°F / 20°C

15 minutes

15 minutes

Dry to Handle

68°F / 20°C

60 minutes

60 minutes



Dry to Sand

68°F / 20°C

6 hour dry, preferably overnight

1½ hours

140°F / 60°C

Do not force dry

30 minutes*



Tape Time

68°F / 20°C

N/A

N/A

140°F / 60°C

N/A

N/A



IR (Infrared)

Medium Wave

Do not force dry

20 minutes

Short Wave

10 minutes



Dry to Topcoat

68°F / 20°C

6 hours (after sanding) 1½ hours (or after sanding)

140°F / 60°C

N/A

30 minutes (or after sanding)

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

AChromatic Gray Mixing Chart

2K AChromatic Surfacers

This chart can be used to mix the 2K A-Chromatic Surfacers. The G1 – G7 ratios will help to achieve better hiding when used as a guide for mixing the 2K A-Chromatic Surfacers.

Mix Ratio By Volume			Mix Ratio By Cumulative Weight							
			Grams				Parts			
	Mix Ratio		¼ Pint	½ Pint	Pint	Quart	¼ Pint	½ Pint	Pint	Quart
	G1	D8001	4	120	240	483	974	136	271	546
D8291		1	139	278	560	1129	157	314	633	1276
D870		1	156	311	627	1264	176	351	708	1428
G2	D8001		114	228	460	927	129	258	520	1047
	D8005	N/A	119	240	483	973	134	271	546	1099
	D8291		138	278	560	1128	156	314	633	1275
	D870		155	311	627	1263	175	351	708	1427
G3	D8001	3	90	180	362	730	102	203	409	825
	D8005	1	119	238	480	969	134	269	542	1095
	D8291	1	138	276	557	1124	156	312	629	1270
	D870	1	155	310	624	1259	175	350	705	1423
G4	D8001		40	80	161	325	45	90	182	367
	D8005	N/A	118	237	477	961	133	268	539	1086
	D8291		138	275	553	1116	156	311	625	1261
	D870		154	308	621	1252	174	345	702	1415
G5	D8005	4	118	235	474	954	133	265	536	1078
	D8291	1	137	273	550	1109	155	308	621	1253
	D870	1	153	306	617	1244	173	346	697	1406
G6	D8005		40	79	158	318	45	89	178	359
	D8007	N/A	114	227	457	921	129	257	516	1041
	D8291		133	265	533	1076	150	299	602	1216
	D870		149	298	601	1211	168	337	679	1368
G7	D8007	4	111	222	448	903	125	251	506	1020
	D8291	1	130	261	525	1058	147	295	593	1195
	D870	1	147	294	592	1193	166	332	669	1348

Emergency Medical or Spill Control Information (412) 434-4515; 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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