



GLOBAL REFINISH  
SYSTEM

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# Product Information

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## 2K *A*Chromatic Surfacer LV (2.1 VOC)

**DLV8001 White**

**DLV8005 Gray**

**DLV8007 Black**

### Product Description

The 2K A-Chromatic Surfacer LV's (DLV800x) are premium quality primer surfacers suitable for the wide range of repair work done in today's refinish bodyshops.

2K A-Chromatic Surfacer LV's offer excellent adhesion, film build, surface leveling and gloss holdout over a wide range of substrates. A variety of A-Chromatic 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.

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### 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 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

DLV800x 2K Surfacer : 4 Vols

DLV8291 Hardener : 1 Vol

Compliant Thinner : —



**Primer Surfacer** Optimum Drying Speed

DLV800x 2K Surfacer : 4 Vols

DLV8291 Hardener : 1 Vol

Compliant Thinner : 1 Vol



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:

**D8764:** Fast Compliant Thinner

**D8774:** Medium Compliant Thinner

**D8767:** Slow Compliant Thinner

### Additives:



*D814 Plasticiser*

**Ready-to-spray DLV800x 2K Surfacer:** 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 / 20°C:



*Between Coats*

**Spray Filler**

**Primer Surfacer**

5 – 10 minutes

5 – 10 minutes

*Before Baking*

N/A

10 minutes

### Drying Times:



*Dust-free*

68°F / 20°C

**Spray Filler**

**Primer Surfacer**

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

\* 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 Surfacer LV as a Primer Surfacer, 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 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 LV 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>
<b>Total dry film build:</b>		
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
<b>% solids by volume RTS</b>	40.55	33.79
<b>Theoretical coverage</b>	Approx. 650 sq.ft. / US Gal	Approx. 542 sq.ft. / US Gal
<i>Theoretical coverage in sq.ft./US gal. ready-to-spray (RTS), 1.0 mil dry film thickness.</i>		
<b>VOC</b>		
(DLV8001/DLV8005/DLV8007)	2.28 lbs. per US gal. / 274 gms per liter	
(DLV8001/DLV8005/DLV8007:DLV8291, 4:1)	2.06 lbs. per US gal. / 247 gms per liter	
(DLV8001/DLV8005/DLV8007:DLV8291:D8767, 4:1:1)	2.06 lbs. per US gal. / 247 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 LV

DLV8001 White  
DLV8005 Gray  
DLV8007 Black

## Mix Ratio:



When Mixed as:

**Spray Filler** Optimum Film Build



DLV800x 2K Surfacer : 4 Vols  
DLV8291 Hardener : 1 Vol  
Compliant Thinner : —

**Primer Surfacer** Optimum Drying Speed



DLV800x 2K Surfacer : 4 Vols  
DLV8291 Hardener : 1 Vol  
Compliant Thinner : 1 Vol

Pot life when sprayed as a

**Spray Filler:** 30 minutes @ 70°F / 21°C  
**Primer Surfacer:** 1 hour @ 70°F / 21°C

**Compliant Thinner Selection**  
D8764: Fast Compliant Thinner  
D8774: Medium Compliant Thinner  
D8767: Slow Compliant Thinner

## Additives:



D814 Plasticiser

**Ready-to-Spray**  
DLV800x 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:



	<b>Spray Filler</b>	<b>Primer Surfacer</b>
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
Between Coats	5 – 10 minutes	5 – 10 minutes
Before Baking	N/A	10 minutes

## Dry Times:



	<b>Spray Filler</b>	<b>Primer Surfacer</b>
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	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
Dry to Topcoat 68°F / 20°C	6 hours (after sanding)	1 1/2 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.

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

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	DLV8001	4	126	<b>252</b>	508	<b>1025</b>	142	<b>285</b>	574	<b>1158</b>
	DLV8291	1	151	<b>301</b>	607	<b>1224</b>	171	<b>340</b>	686	<b>1383</b>
	D8767	1	177	<b>354</b>	713	<b>1437</b>	200	<b>400</b>	806	<b>1624</b>
G2	DLV8001		120	<b>240</b>	484	<b>977</b>	136	<b>271</b>	547	<b>1104</b>
	DLV8005	N/A	126	<b>252</b>	509	<b>1026</b>	142	<b>285</b>	575	<b>1159</b>
	DLV8291		150	<b>301</b>	599	<b>1224</b>	169	<b>340</b>	677	<b>1383</b>
	D8767		177	<b>354</b>	705	<b>1438</b>	200	<b>400</b>	797	<b>1625</b>
G3	DLV8001	3	94	<b>189</b>	381	<b>769</b>	106	<b>213</b>	430	<b>869</b>
	DLV8005	1	126	<b>252</b>	509	<b>1026</b>	142	<b>285</b>	575	<b>1159</b>
	DLV8291	1	150	<b>301</b>	607	<b>1225</b>	169	<b>340</b>	686	<b>1384</b>
	D8767	1	177	<b>354</b>	713	<b>1439</b>	200	<b>400</b>	806	<b>1626</b>
G4	DLV8001		42	<b>84</b>	169	<b>342</b>	47	<b>95</b>	191	<b>386</b>
	DLV8005	N/A	126	<b>253</b>	510	<b>1029</b>	142	<b>286</b>	576	<b>1163</b>
	DLV8291		151	<b>302</b>	608	<b>1228</b>	171	<b>341</b>	687	<b>1388</b>
	D8767		177	<b>355</b>	714	<b>1441</b>	200	<b>401</b>	807	<b>1628</b>
G5	DLV8005	4	127	<b>253</b>	511	<b>1030</b>	143	<b>286</b>	577	<b>1164</b>
	DLV8291	1	151	<b>302</b>	609	<b>1229</b>	171	<b>341</b>	688	<b>1389</b>
	D8767	1	177	<b>355</b>	715	<b>1442</b>	200	<b>401</b>	808	<b>1629</b>
G6	DLV8005		81	<b>162</b>	327	<b>658</b>	91	<b>183</b>	369	<b>743</b>
	DLV8007	N/A	123	<b>247</b>	498	<b>1001</b>	139	<b>279</b>	563	<b>1131</b>
	DLV8291		148	<b>296</b>	597	<b>1199</b>	167	<b>334</b>	675	<b>1355</b>
	D8767		174	<b>348</b>	703	<b>1413</b>	197	<b>393</b>	794	<b>1597</b>
G7	DLV8007	4	122	<b>243</b>	498	<b>990</b>	138	<b>275</b>	555	<b>1119</b>
	DLV8291	1	146	<b>292</b>	590	<b>1189</b>	165	<b>330</b>	667	<b>1343</b>
	D8767	1	173	<b>345</b>	696	<b>1402</b>	195	<b>390</b>	786	<b>1584</b>

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

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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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