



GLOBAL REFINISH
SYSTEM

Product Information

D8150 Performance Clearcoat

Product Description

D8150 Performance Clearcoat is a premium quality high solid clear specifically formulated for today's high production shops. The exceptionally short bake cycle and reduced baking temperatures provide increased productivity along with reduced operating costs.

D8150 provides users with industry leading speed, efficiency, application and gloss. It is designed for use over Global BC (see data sheet EU-02) and Envirobase (see data sheet EU-130).

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.



Wet sand with U.S. 500 – 600 / European P800 – 1200 grade paper or dry sanding with U.S. 400 – 500 / European P600 – 800 grade paper.



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

Apply D8150 Performance Clear over Global BC and Envirobase. See the product data sheet for details on Global BC & Envirobase system applications.

APPLICATION GUIDE:

Mix Ratio:



D8150 Performance Clear : 3 vols

D82xx Hardener : 1 vol

“D” Series Thinner : 1 vol



Potlife @ 68°F / 20°C: 4 hours

Hardener Selection:

D8270 : 55° – 75°F / 13° – 24°C

D8280 : 75° – 95°F / 24° – 35°C

D8290 : 95°F / 35°C & above

* Use only D8280 and D8290 over Envirobase.

“D” Series Thinner Selection:

D870 : Up to 65°F / 18°C – 65°F

D871 : 65° – 77°F / 18° – 25°C

D872 : 77° – 95°F / 25° – 35°C

D873 : Over 95°F / 35°C

D8700: May replace up to 25% of recommended thinner levels in very warm conditions

Note: Smaller areas may require faster thinner

Additives:



Use **D759 Matting base** to *flatten* D8150 Clear.

Matte Finish

D8150 : D82XX : D87X : D759

3 : 1 : 2 : 3

Satin Finish

D8150 : D82XX : D87X : D759

3 : 1 : 2 : 2

Use **D814 Plasticiser** to *flexibilize* D8150 Clear.

D8150 : D82XX : D87X : D814

2 : 1 : 1 : 1

Spraygun set-up:



Fluid Tip

1.3 – 1.5 mm or equivalent

Spray Viscosity

17 – 18 secs #2 ZAHN (Signature type) @ 68°F / 20°C

Spray pressure:

HVLP at air cap

8 – 10 PSI

Conventional at spray gun

45 – 55 PSI

Number of coats:



Apply:

2 coats

Film build per wet coat

3.0 – 3.5 mils

Dried film build per coat

1.2 – 1.4 mils

Flash off at 68°F / 20°C:



Between coats

5 – 10 minutes

Before stoving

0 – 5 minutes

Drying times:



Dust-free

68°F / 20°C

20 – 40 minutes

Dry to handle

68°F / 20°C

3 – 4 hours minimum



120°F / 50°C

15 – 20 minutes







APPLICATION GUIDE

Drying times continued:

	<i>Tape Time</i>	
	68°F / 20°C	6 – 8 hours
	120°F / 50°C	1 hour after cool down
	<i>Through Dry</i>	
	68°F / 20°C	8 hours
	120°F / 50°C	D8270 – 10 minutes
	140°F / 60°C	D8280 – 10 minutes
		D8290 – 10 minutes
	<i>IR (Infrared)</i>	
	Medium Wave	15 minutes
	Short Wave	8 minutes

Note: All force dry times are quoted for metal temperature. Additional time must be allowed during force dry to allow metal to reach recommended temperature.

Overcoat/Recoat:

	<i>Overcoat/Recoat Time</i>	16 hours at 68°F / 20°C or after force dry/cool down. D8150 must be sanded before recoating with primer, color or clear.
	<i>Grade wet</i>	U.S. 500 – 600 / European P800 – 1200
	<i>Grade dry</i>	U.S. 400 – 500 / European P600 – 800
	<i>Overcoat with</i>	Any Global topcoat system
	<i>Polishing</i>	After bake cycle and 1 hr cool down. Use a foam pad with a minor cutting compound to remove any minor imperfections.

Performance Guidelines:

Allow the Global BC Color to flash off for 15 minutes (but no longer than 24 hours) before applying D8150 Clear. The timing will depend on thickness and temperature. Recoating times will be extended at lower temperatures. Global D8150 may be sanded with 1200 grit paper or finer and polished when hard, to rectify minor imperfections.

Fading Out - D8150 Clear

After spot repairing, clean the gun and then spray D8753 Blending Solvent 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.

Technical Data:

Total dry film build

Minimum	2.0 mils
Maximum	3.0 mils
Recommended film build per wet coat	3.0 – 3.5 mils
Recommended dried film build per coat	1.2 – 1.4 mils

Theoretical coverage

657 sq.ft. per US gal.

Theoretical coverage in sq.ft./US gal. Ready-to-spray (RTS), giving 1 mils dry film thickness.

Percent solids by volume RTS

40.93

VOC (D8150)

VOC	3.80 lbs. per US gal
VOC less exempts	3.32 lbs. per US gal

VOC (D8150 : D8290 : D871, 3 : 1 : 1)

VOC	4.18 lbs. per US gal.
VOC less exempts	3.89 lbs. per US gal.

Performance Clearcoat

Mix Ratio:



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D82xx Hardeners: 1 vol
“D” Series Thinners: 1 vol

Potlife @ 68°F / 20°F: 4 hours

Hardener Selection:

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 D8290 : 95°F / 35°C – above)

* Use only D8280 and D8290 over Envirobase.

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Additives:



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Matte Finish				Satin Finish			
<u>D8150</u>	<u>: D82XX</u>	<u>: D87X</u>	<u>: D759</u>	<u>D8150</u>	<u>: D82XX</u>	<u>: D87X</u>	<u>: D759</u>
3	:	1	:	2	:	3	
				3	:	1	:
						2	:
							2

Use **D814 Plasticiser** to *flexibilize* D8150 Clear.

<u>D8150</u>	<u>: D82XX</u>	<u>: D87X</u>	<u>: D814</u>
2	:	1	:
		1	:
			1

Spraygun set-up:



Fluid Tip	1.3 – 1.5 mm or equivalent
Spray Viscosity	17 – 18 secs #2 ZAHN (Signature type) @ 68°F / 20°C
HVLP at air cap	8 – 10 PSI
Conventional at spray gun	45 – 55 PSI

Application:



Apply:	2 coats
Between coats	5 – 10 minutes
Before stoving	0 – 5 minutes
Film build per wet coat	3.0 – 3.5 mils
Dried film build per coat	1.2 – 1.4 mils

Drying times:



Dust-free 68°F / 20°C 20 – 40 minutes

Dry to handle
 68°F / 20°C 3 - 4 hours minimum
 120°F / 50°C 15 – 20 minutes



Through Dry
 68°F / 20°C 8 hours
 120°F / 50°C D8270 – 10 minutes
 140°F / 60°C D8280 – 10 minutes
 D8290 – 10 minutes



IR (Infrared)
 Medium Wave 15 minutes
 Short Wave 8 minutes



Dry to Topcoat
 68°F / 20°C 16 hours @ 68°F / 20°C or after force dry/cool down
 120°F / 50°C D8150 must be sanded before recoating with primer, color or clear.



Note: All force dry 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.

- Before opening the package, be sure all the warning messages on the label and MSDS are understood.
- 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 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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