



AUTO REFINISH

**GLOBAL
REFINISH
SYSTEM**



Product information

DELTRON D821

High Solids Chip Resistant Primer

PRODUCT DESCRIPTION

D821 is a transparent-grey primer surfacer with excellent anti-chip and anti-corrosion properties. It is ideal for the repair and repainting of any panel surfaces, particularly those areas most susceptible to stonechip damage.

Tintable with Deltron DG colour, D821 may be applied directly to bare steel, suitably prepared aluminium and pretreated steel. It may be overcoated, with or without sanding, with any Deltron GRS topcoat and Envirobase. D821 may be air dried, IR cured or low baked .

When mixed as recommended with D884 or D897 Deltron High Solids Hardeners and a Deltron Thinner, D821's ready-for-use VOC content is below 540g/l.

D821 offers the bodyshop significant economies in stock and process time. A single stage application of D821 can replace a conventional two stage primer system. D821 gives the adhesion and anticorrosion performance of an epoxy or wash etch primer together with the film build and surface levelling of a 2K surfacer.

PREPARATION OF SUBSTRATE

Substrate

Bare steel
Galvanised steel
Zintec
Aluminium and alloys
Electropaint
Aged painted surfaces
GRP, fibre-glass
Polyester filler

Preparation

P80 - 120 (dry)
P400 (dry)
Fine sanding pad
P280 - 320 (dry)
P360 (dry) / P800 (wet)
P400 - 500 (dry) /P280 - 320 (wet)
P320 (dry)
P240 (dry)



Before and after any sanding operation, the substrate must be thoroughly degreased.

PRODUCT SET-UP

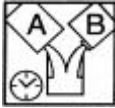


Mixing ratio:

<i>Untinted</i>				<i>Tinted</i>							
 VOC <540 g/l				 VOC <540 g/l				 VOC <540 g/l			
D821	5 vol	D821	3 vol	D821	3 vol	D821	3 vol				
D884/D897	1 vol	D841/D861	1 vol	DG	1 vol	DG	1 vol				
Thinner	1 vol	Thinner	1 vol	D884/D897	1 vol	D841/D861	1.5 vol				
				Thinner	1 vol	Thinner	1 vol				

Thinner selection:

<i>Temperature</i>	<i>MS Hardener</i>	<i>HS Hardener</i>	<i>Thinner</i>
Up to 18°C	D841	D884/D897	D808 Fast Thinner
18 - 25°C	D841	D884/D897	D866 2K Primer Thinner
25 - 35°C	D861	D884/D897	D812 Slow Thinner
Over 35°C	D861	D884/D897	D869 Very slow thinner



Potlife at 20°C:




3 - 4 hours




Spray Viscosity at 20°C:

18 - 25 seconds DIN4

APPLICATION, FLASH-OFF AND DRYING

	<i>Untinted</i>	<i>Tinted</i>
 <i>Spraygun set-up:</i>	1.4 - 1.6 mm	
<i>Number of coats:</i>	2 - 3	
 <i>Flash-off at 20°C:</i>	10 - 15 minutes	
- <i>Between coats</i>	10 - 15 minutes	
- <i>Before topcoating</i>	solventborne topcoat: 30 minutes waterborne topcoat: 45 minutes	
 <i>Drying times at 20°C:</i>		
- <i>Dustfree</i>	35 minutes	35 minutes
- <i>Touch dry</i>	1.5 - 2 hours	2 - 2.5 hours
- <i>Through dry</i>	Overnight	Overnight
<i>Through dry at 60°C:*</i>	20 -25 minutes	30 minutes
<i>Through dry IR medium</i>	10 -15 minutes	10 - 15 minutes
* <i>Stoving times are for quoted metal temperature. Additional time should be allowed in the stoving schedule to allow metal to reach recommended temperature</i>		
<i>Total dry film build:</i>	70 - 110 µm	60 - 90 µm
<i>Theoretical coverage:</i>	assuming 100% transfer efficiency and dry film thickness as indicated: 5 - 6 m ² /l	6 - 7 m ² /l

REPAIR AND RECOATING

 <i>Sanding:</i>	Essential before recoating to ensure good adhesion P800 (wet) P400 (dry)
<i>Overcoat with:</i>	Deltron GRS topcoats, Envirobase

PERFORMANCE AND LIMITATIONS



Use only the hardeners and thinners recommended on this data sheet. **Do NOT use** Hardeners D803, D864 or D8208, Accelerator D818, Enhancer D885.

Where humidity is in the range 70 - 80%, use of D869 Deltron Very Slow Thinner is recommended.

EQUIPMENT CLEANING

After use, clean all equipment thoroughly with cleaning solvent or thinner.



HEALTH AND SAFETY

For comprehensive Health, Safety and Environmental advice, please refer to relevant Material Safety Data Sheets and product can labels.

Use the recommended safety equipment.

THIS PRODUCT IS FOR PROFESSIONAL USE ONLY.

The information given in this sheet is for guidance only. Any person using the product without first making further enquiries as to the suitability of the product for the intended purpose does so at his own risk and we can accept no liability for the performance of the product or for any loss or damage (other than death or personal injury resulting from our negligence) arising out of such use. The information contained in this sheet is liable to modification from time to time in the light of experience and our policy of continuous product development.

Drying times quoted are average times at 20°C. Film thickness, humidity and shop temperature can all affect drying times.



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