



**AUTO REFINISH**

**GLOBAL  
REFINISH  
SYSTEM**



# Product information

## **Deltron D894**

*High Solids Clear*

### **PRODUCTS**

|                                 |                        |
|---------------------------------|------------------------|
| Deltron HS Clear                | D894                   |
| Deltron HS Hardener             | D884                   |
| Deltron Medium Solids Hardeners | D803, D841, D861, D864 |
| Deltron Thinners                | D808, D807, D812, D869 |
| Deltron DG Fadeout Thinner      | D868                   |
| Deltron Accelerator             | D818                   |

For matt, satin and textured finishes or painting of flexible substrates :

|                                |   |
|--------------------------------|---|
| Deltron Matting Base           | D759 to create a matt or satin appearance                           |
| Deltron Plasticiser            | D814 to plasticise finishes over a flexible substrate               |
| Deltron Matt Flexibiliser      | D819 to create a matt or satin appearance over a flexible substrate |
| Deltron Texture Additive       | D843 to create a fine textured 'suede' effect                       |
| Deltron Leather Grain Additive | D844 to create a coarser, more pronounced textured finish           |

### **PRODUCT DESCRIPTION**

Deltron High Solids Clear is a 2K acrylic urethane clearcoat. It is designed for the repair and respray of vehicles originally finished with clearcoat over a single or multistage colour basecoat system.

Deltron High Solids Clear is designed for use over Deltron BC colour (see data sheet ref. 02) or over Envirobase colour (see data sheet ref. 82).

The performance of Deltron High Solids Clear in a recommended PPG repair system meets or exceeds motor manufacturers' warranty requirements - the Deltron GRS system has many OEM approvals.

Deltron High Solids Clear offers the refinisher :

- savings in materials consumption and process time compared to conventional clearcoats;
- low ready-for-use VOC content.

When mixed as recommended with Deltron hardener and thinner, Deltron High Solids Clear has a maximum ready-for-use VOC content below 420g/l.

### **PREPARATION OF SUBSTRATE**

Deltron D894 Clear must be applied on top of a clean and dustfree Deltron Basecoat or Envirobase. The use of a tackrack is recommended to remove dust from the Basecoat or Envirobase film.

## PRODUCT SET-UP



Mixing ratio:

|              | <b>MS System</b> |              | <b>HS System</b> |  |
|--------------|------------------|--------------|------------------|--|
| D894         | 2 vol            | D894         | 3 vol            |  |
| MS Hardener* | 1 vol            | HS hardener* | 1 vol            |  |
| Thinner*     | 1 vol            | Thinner*     | 0.2 vol          |  |

\* Choose Hardener and Thinner according to application temperature and system:

| <b>Temperature</b> | <b>MS Hardener</b> | <b>Thinner</b> | <b>HS Hardener</b> | <b>Thinner</b> |
|--------------------|--------------------|----------------|--------------------|----------------|
| Up to 18°C         | D803 Fast          | D808           | D884               | D807           |
| 18°C - 25°C        | D841 Medium        | D807           | D884               | D812           |
| Over 25°C          | D861 Slow          | D812**         | D884               | D869           |

\*\* For exceptional conditions of temperature and humidity (> 35°C / >70%) the use of Very Slow Thinner D869 is recommended



Potlife at 20°C:

3.5 - 4 hours



Spray viscosity at 20°C:

16 - 20 seconds DIN4

## APPLICATION, FLASH-OFF AND DRYING



Spraygun set-up:

1.3 - 1.6 mm

| <b>MS System</b>       | <b>HS System</b>       |
|------------------------|------------------------|
| 1 medium coat          | 1 mist coat            |
| ↓                      | ↓                      |
| 10 min flash-off       | no flash-off           |
| ↓                      | ↓                      |
| 1 full coat            | 1 full coat            |
| ↓                      | ↓                      |
| 5 - 10 min flash-off   | no flash-off           |
| ↓                      | ↓                      |
| Low-bake / IR / airdry | Low-bake / IR / airdry |



Drying times: \*\*\*

|                            |  |
|----------------------------|--|
| - Dust free at 20 °C       | 30 - 40 minutes  |
| - Through dry at 20 °C     | Overnight  |
| - Through dry at 70°C      | 30 minutes   |
| - Through dry at IR Medium | 10 minutes<br>(dependent on colour of basecoat – darker colours require less time) |



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

Drying times may be reduced still further by adding 10ml or 10gms of D818 Accelerator per litre of ready to spray clear.

Total dry film build:

50 - 60 µm

Theoretical coverage:

assuming 100% transfer efficiency and dry film thickness as indicated:

7 m<sup>2</sup>/l

## REPAIR AND RECOATING



**Sanding:** Essential before recoating to ensure good adhesion  
P800 (wet)  
P400 - P500 (dry)



**Overcoat / recoat time:**

- Force dry 60°C , 70°C  
or IR After cooling
- Airdry at 20°C Minimum 12 hours

Overcoat with: PPG 2K Primers, Envirobase, Deltron GRS Topcoats

## MATT, SATIN AND TEXTURED FINISHES PAINTING OF FLEXIBLE SUBSTRATES

To obtain a matt, semi-matt (satin) or textured finish with Deltron D894 HS clear, it is necessary to include matt, flex or texture additives in the mix. Additives are also required when applying D894 over a flexible substrate (typically plastics). The additives required and the appropriate volume and weight mix ratios are indicated in microfiches if relevant or in the tables below.

Note : **RIGID** substrates include all metals, fibreglass and GRP  
**FLEXIBLE** substrates are all plastic types except GRP

| Substrate       | Appearance    | D894  | D759    | D843    | D844    | D814  | D819  | D884    | Deltron Thinner |
|-----------------|---------------|-------|---------|---------|---------|-------|-------|---------|-----------------|
| <b>RIGID</b>    | Gloss         | 3 vol | -       | -       | -       | -     | -     | 1 vol   | 0.5 vol         |
|                 | Satin         | 4 vol | 3 vol   | -       | -       | -     | -     | 1vol    | 2 vol           |
|                 | Matt          | 3 vol | 4.5 vol | -       | -       | -     | -     | 1.5 vol | 3 vol           |
|                 | Matt Textured | 3 vol | -       | 4.5 vol | -       | -     | -     | 1 vol   | 4 vol           |
|                 | Leather Grain | 4 vol | -       | -       | 3 vol   | -     | -     | 1vol    | 3 vol           |
| <b>FLEXIBLE</b> | Gloss         | 3 vol | -       | -       | -       | 1 vol | 1     | 1 vol   | 0.5vol          |
|                 | Satin         | 2 vol | 1.5 vol | -       | -       | -     | 1 vol | 1 vol   | 1.vol           |
|                 | Matt          | 2 vol | 3 vol   | -       | -       | -     | 1 vol | 1 vol   | 2 vol           |
|                 | Matt Textured | 2 vol | -       | 3 vol   | -       | -     | 1 vol | 1 vol   | 3 vol           |
|                 | Leather Grain | 2 vol | -       | -       | 1.5 vol | -     | 1 vol | 1 vol   | 1.5 vol         |

## SPOT REPAIR PROCEDURE

- Apply Deltron D894 HS Clear according to the 'Application, Flash-Off and Drying' section above.
- Leave to flash-off for 10 minutes/20°C after the 2<sup>nd</sup> coat.
- A suitable quantity of activated and thinned D894 HS Clear should then be reduced with Deltron DG Fade-Out Thinner D868 at a ratio of 1:3 (1 part activated and thinned Clear to 3 parts D868).
- Apply this 1:3 mix over the repair area, using a reduced gun pressure to minimize overspray. Spray from the outside of the repair inwards, covering an area that extends beyond the edge of the initial application.
- If necessary, repeat the previous step using D868 neat.
- After force dry or IR, buff the repair edges.

## POLISHING



**Low bake or IR force drying:**

Minimum 1 hour after cooling

**Air drying at 20°C:**

Minimum 24 hours after application

## PERFORMANCE AND LIMITATIONS



D894 can be mixed 3/1/1 with D884 in areas where VOC is not a concern. Then the application method is:

1 medium coat  
↓  
10 minutes flash-off  
↓  
1 full coat  
↓  
5 - 10 minutes flash-off  
↓  
Low-bake / IR / airdry

## 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 the 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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