



AUTO REFINISH

**GLOBAL
REFINISH
SYSTEM**



Product Information

DELTRON D893

*Low VOC Performance
Clear*

PRODUCT

Deltron Low-VOC Performance Clear	D893
Deltron High Solids Hardener	D884
Deltron Thinners	D808, D807, D812, D869
Deltron DG Fade Out Thinner	D868
Deltron Potlife Extender	D886
Deltron Enhancer	D885

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 Low VOC Performance Clear is a 2K acrylic urethane clearcoat for the repair and respray of vehicles originally finished with clearcoat over a single or multistage colour basecoat system.

D893 is designed for use over Deltron BC or Envirobase colour.

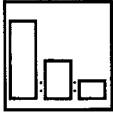
Deltron Low VOC Performance Clear has an organic solvent content lower than conventional clearcoats. This makes it particularly suitable for bodyshops operating in areas where VOC emissions or product VOC content is restricted and productivity is an issue.

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

PREPARATION OF SUBSTRATE

Deltron D893 Clear must be applied on top of a clean and dust-free Deltron basecoat or Envirobase. The use of a tack rag is recommended.

PRODUCT SET-UP

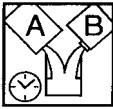


<i>Mixing ratio:</i>	D893	3 vol
	HS Hardener*	1 vol
	Thinner*	0.5 vol

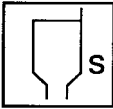
* Choose HS Hardener and Thinner according to application temperature:

<i>Temperature</i>	<i>MS Hardener</i>	<i>Thinner</i>
Up to 18°C	D884	D808
18°C - 25°C	D884	D807
Over 25°C	D884	D812

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



Potlife at 20°C: 1 hour



Spray viscosity at 20°C: 14 - 20 seconds DIN4

APPLICATION, FLASH-OFF AND DRYING



Spraygun set-up: 1.3 - 1.6 mm

<i>Coventional System</i>	<i>Express System</i>
1 medium coat	1 mist coat
↓	↓
10 minutes flash-off	no flash-off
↓	↓
1 full coat	1 full coat
↓	↓
5 - 10 minutes flash-off	no flash-off
↓	↓
Low-bake / IR / airdry	Low-bake / IR / airdry



<i>Drying times:</i>	
- Dust free at 20°C	20 - 25 minutes
- Dry to handle at 20°C	4 hours
- Through dry at 20°	8 hours
- Through dry at 70°C*	15 minutes
- Through dry at IR medium	15 minutes



APPLICATION, FLASH-OFF AND DRYING

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 using the Deltron Enhancer D885. See 'Performance and Limitations'.

Total dry film build: 50 - 60 µm

Theoretical coverage: Assuming 100% transfer efficiency and dry film thickness as indicated:
8 m²/l

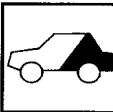
REPAIR AND RECOATING



Sanding: Essential before recoating to ensure good adhesion

- *grade wet* P800
- *grade dry* P400 - P500

Overcoat / Re-coat time:



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

Overcoat with: Deltron primers
Envirobase
Deltron topcoats

MATT, SATIN AND TEXTURED FINISHES PAINTING OF FLEXIBLE SUBSTRATES

To obtain a matt, semi-matt (satin) or textured finish with Deltron D893 Clear, it is necessary to include matt, flex or texture additives in the mix. Additives are also required when applying D893 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

<i>Substrate</i>	<i>Appearance</i>	<i>D893</i>	<i>D759</i>	<i>D843</i>	<i>D844</i>	<i>D814</i>	<i>D819</i>	<i>D884</i>	<i>Deltron Thinner</i>
RIGID	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

MATT, SATIN AND TEXTURED FINISHES PAINTING OF FLEXIBLE SUBSTRATES

Substrate	Appearance	D893	D759	D843	D844	D814	D819	D884	Deltron Thinner
FLEXIBLE	Gloss	3 vol	-	-	-	1 vol		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 D893 HS Clear according to the 'Application, Flash-Off and Drying' section above.
- Leave to flash-off for 10 minutes/20°C after the 2nd coat.
- A suitable quantity of activated and thinned D893 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 minimise overspray. Spray from the outside of the repair inwards, covering an area that extends beyond the edge of the initial application.

POLISHING



*Low bake or IR force
drying:*

Minimum 1 hour after cooling

Air drying at 20°C:

Minimum 8 hours after application

PERFORMANCE AND LIMITATIONS



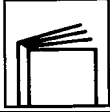
D893 can be mixed 3/1/1 with D884 in areas where VOC is not a concern. Then the application method is:

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

D893 may be accelerated using D885 Deltron Enhancer. Please refer to the appropriate data sheet.

EQUIPMENT CLEANING

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



HEALTH AND SAFETY

PRODUCT FOR PROFESSIONAL USE ONLY. See Manufacturer's Safety Data Sheet relating to this product at: http://www.ppg.com/PPG_MSDS
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 our experience and our policy of continuous product development.

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



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