



AUTO REFINISH

**GLOBAL
REFINISH
SYSTEM**



Product Information

Deltron DG

Direct Gloss 2-Pack acrylic colour

PRODUCTS

Deltron Direct Gloss Tinters	D7xx
Deltron Medium Solids Hardeners	D803, D841, D861, D864
Deltron Standard Solids Hardener	D802, D863
Deltron Thinners	D808, D807, D812, D869
Deltron DG Fade-out 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 DG is a high-performance two-pack acrylic urethane topcoat designed for the direct gloss repair and re-spray of cars and commercial vehicles.

The performance of Deltron DG in a recommended PPG repair system meets or exceeds motor manufacturer warranty requirements and the Deltron GRS system carries many OEM approvals.

PREPARATION OF SUBSTRATE

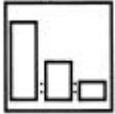


Apply over original stoved finishes or over recommended PPG primers (e.g. Prima, Koba, Universel, DP40).

Degrease all surfaces to be painted with appropriate PPG substrate cleaner before wet sanding with P600-800 grade paper or dry sanding with P400-500 grade paper.

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

PRODUCT SET-UP



Mixing ratio:

Standard System

MS System

DG	2 vol	DG	3 vol
D802	1 vol	MS Hardener**	1 vol
Thinner**	*1 vol	Thinner**	0.2 vol

* For high build, use 0.5 vol.

** Choose MS Hardener and Thinner according to application temperature:

Temperature	MS Hardener	Thinner
Up to 18°C	D803 Fast	D808
18°C - 25°C	D841 Medium	D807
Over 25°C	D861 Slow	D812

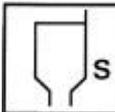
For exceptional conditions of temperature and humidity (> 35°C / >70%) the use of Very Slow Thinner D869 is recommended.



Potlife at 20°C:

6 - 8 hours

6 hours

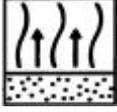


Spray viscosity at 20°C:

15 seconds DIN4

17 - 18 seconds DIN4

APPLICATION, FLASH-OFF AND DRYING

	<i>Standard System</i>	<i>MS System</i>
 <i>Spraygun set-up:</i>	1.4 - 1.8 mm	1.4 - 1.8 mm
<i>Number of coats:</i>	1 light , 2 full	1 medium, 1 full
 <i>Flash off at 20°C:</i>		
- <i>Between coats</i>	5 minutes	10 minutes
- <i>Before stoving</i>	10 minutes	10 - 15 minutes
 <i>Drying times:**</i>		
- <i>Dust free at 20°C</i>	20 minutes	30 minutes
- <i>Through dry at 20°C</i>	20 hours	20 hours
- <i>Through dry at 60°C*</i>	30 minutes	30 minutes
- <i>IR medium</i>	10 - 15 minutes	10 - 15 minutes
<p>* Stoving times are for quoted metal temperature. Additional time should be allowed in the stoving schedule to allow metal to reach recommended temperature.</p> <p>** Drying times may be reduced still further by using the Deltron Accelerated System. Substitute D863 Accelerated Hardener for D802 and dust-free time reduces to 10 minutes. Stoving at 60°C takes 20 minutes. Potlife is 3 – 4 hours. Adding 10gms or 10 mls of D818 Accelerator per litre of ready to spray paint mixture improves dust-free times to 15 mins (with D802) or 5 mins (with D803). Using D863 and D818 together reduces dust-free time to 5 mins and through drying at 60°C to 15 minutes. Potlife is 3 – 4 hours.</p> <p>*** Dependent on colour of basecoat; darker colours require less time.</p>		

REPAIR AND RECOATING

 <i>Sanding:</i>	Essential before recoating to ensure good adhesion P800 (wet) P400 (dry)
 <i>Overcoat / recoat time:</i>	
- <i>Force dry 60°C or IR</i>	After cooling
- <i>Air dry at 20°C</i>	Minimum 8 hours
<i>Overcoat with:</i>	PPG 2K primers Deltron GRS topcoats Envirobase

MATT, SATIN AND TEXTURED FINISHES PAINTING OF FLEXIBLE SUBSTRATES

To obtain a matt, semi-matt (satin) or textured finish with Deltron Direct Gloss, it is necessary to include matt, flex or texture additives in the mix. Additives are also required when applying DG 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	DG	D759	D843	D844	D814	D819	MS hardener	Deltron Thinner
RIGID	Gloss	3 vol	-	-	-	-	-	1 vol	1 vol
	Satin	3 vol	1.5 vol	-	-	-	-	1.5 vol	1 vol
	Matt	3 vol	3 vol	-	-	-	-	1.5 vol	2 vol
	Matt Textured	3 vol	-	3 vol	-	-	-	1.5 vol	2 vol
	Leather Grain	3 vol	-	-	1.5 vol	-	-	1.5 vol	1 vol
FLEXIBLE	Gloss	3 vol	-	-	-	1 vol		2 vol	
	Satin	4 vol	2 vol	-	-	-	2 vol	3.5 vol	0.5 vol
	Matt	4 vol	4 vol	-	-	-	2 vol	3.5 vol	1.5 vol
	Matt Textured	4 vol	-	4 vol	-	-	2 vol	3.5 vol	1.5 vol
	Leather Grain	4 vol	-	-	2 vol	-	2 vol	3.5 vol	0.5 vol

SPOT REPAIR PROCEDURE

- Apply Deltron DG 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 DG 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.
- 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 20 hours after application

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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