



GLOBAL REFINISH
SYSTEM

Product Information

2K Chromatic Sealer NR (National Rule)

D8081 White D8088 Red
D8085 Gray D8089 Yellow
D8087 Black D8090 Blue

Product Description

The 2K Chromatic Sealer NR (D80xx) is a premium quality primer sealer suitable for the advanced technology finishes used in today's refinish bodyshops.

The fast drying 2K Chromatic Sealer NR has superior flow properties and excellent gloss holdout. A variety of Chromatic colors and grays can be achieved by intermixing the six sealer color choices. The sealer can be used over sanded original finishes and/or properly prepared and treated bare steel, aluminum, fiberglass and plastic.

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.
- Original Paintwork should be sanded using U.S. 360 / European P400 grit discs (dry) or U.S. 400 / European P600 grit paper (wet). Exposed metal should be spot-primed with a suitable bare metal primer (see below).
- Aluminum, Bare Steel and Galvanized Steel must be clean, rust-free and abraded thoroughly using U.S. 180 / European P180 to U.S. 240 / European P280 grit paper (wet). These substrates **must be primed with a Global Etch Primer**. Additional film build over etch primers is strongly recommended, a minimum of 1.5 mils of the 2K Chromatic Sealer NR must be applied in two coats. With the higher film build of 2K Chromatic Sealer NR, additional flash time for the sealer may be necessary.
- Electrodeposition Primer must be thoroughly cleaned and may then be directly overcoated with the 2K Chromatic Sealer NR as a Wet-on-Wet Sealer without abrading.
- Polyester Body Fillers should be dry sanded using U.S. 240 / European P280 grit paper.
- Fiber Glass and SMC should be dry sanded using U.S. 240 / European P280 grit paper.
- Plastic should be dry sanded with U.S. 400 / European P600 (use a finer grit for softer plastics) and primed first with a PPG Plastic Adhesion Promoter.

APPLICATION GUIDE:

Mix Ratio:



D80xx 2K Sealer NR: 3 Vols.
D8291 Catalyst: 1 Vol.
“D” Thinners: 1 Vol.



***Warning:** Additional film build on etch primed sections is strongly recommended. A minimum of 1.5 mils of the 2K Chromatic Sealer NR must be applied in two coats. With the higher film build of 2K Chromatic Sealer NR, additional flash time for the sealer may be necessary.*

Pot Life

1 hour @ 68°F / 20°C

“D” Thinner Selection:

D870: Up to 65°F / 18°C

D872: 77° – 95°F / 25° – 35°C

D871: 65° – 77°F / 18° – 25°C

D873: Over 95°F / 35°C

D8700 Retarder may be mixed with thinners in temperatures over 95°F / 35°C. The retarder should be mixed up to 10% with the appropriate thinner. Do not use retarder alone as a reducer.

Additives:



D814 Plasticiser

Ready-to-Spray D80xx 2K Sealer NR: 10 Vols

D814: 1 Vol

Spraygun Set-up:



Fluid Tip

1.4 – 1.6 mm or equivalent

Spray Viscosity

20 – 25 seconds #2 Zahn @ 70° F / 21°C

Spray Pressure:

HVLP at air cap

10 PSI

Conventional at spray gun

40 – 45 PSI

Number of Coats:



Apply

1-2 wet coats

Film build per wet coat

2.5 mils

Dried film build per coat

1.0 mils

Flash off at 68°F / 20°C:



Between Coats

5 – 10 minutes

Before Baking

5 – 10 minutes

Before Topcoating

15 minutes @ 68°F / 20°C for 1 coat

30 minutes @ 68°F / 20°C for 2 coats

After 72 hours, sealer must be sanded. If sanded film is below 1 mil, sealer must be reapplied.

Drying times:



Dust-free

68°F / 20°C

10 minutes



Dry to Handle

68°F / 20°C

1 hour



Tape Time

68°F / 20°C

1½ hours



IR (Infrared)

IR Medium Wave

10 minutes

IR Short Wave

5 minutes

APPLICATION GUIDE

Overcoat / Recoat



Envirobase or any Global Topcoat

15 minutes @ 68°F / 20°C for 1 coat
30 minutes @ 68°F / 20°C for 2 coats

After 72 hours, sealer must be sanded. If sanded film is below 1 mil, sealer must be reapplied.



Grade wet
Grade dry

U.S. 500 / P1000 grade paper
U.S. 500 / P1000 grade paper

Performance Guidelines

The use of HVLP spray equipment can give an increase in transfer efficiency of around 25% depending upon the make and model of equipment use.

For all substrates except unsanded electrodeposition primer, ensure that the surface is thoroughly sanded to the panel edge or an inch or two beyond the damaged area, whichever is the smaller.

Do not attempt spot repair on original or refinish thermoplastic applications, lacquer or 1K finishes.

Partially used cans of hardener must be carefully closed.

Technical Data

Total dry film build:

Minimum	1.0 mil
Maximum	1.5 mils
Film build per wet coat	2.5 mils
Dried film build per coat	1.0 mils

Theoretical coverage 555 sq.ft. per US gal.

Theoretical coverage in sq.ft./US gal. ready-to-spray (RTS), 1.0 mil dry film thickness

Percent solids by volume RTS 34.5

VOC

2K Chromatic Sealer NR	3.1 lbs per U.S. gallon
2K Chromatic Sealer NR : Hardener : Thinner, 3 : 1 : 1	4.3 lbs per U.S. gallon

Health and Safety:

See Material Safety Data Sheet and Labels for additional safety information and handling instructions.

- The contents of this package may have to be blended with other components before the product can be used. Before opening the packages, be sure you understand the warning messages on the labels and MSDS's of all the components, since the mixture will have the hazards of all its parts.
- 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.



*A*Chromatic Gray Mixing Chart

2K Chromatic Sealer NR

This chart can be used to mix the 2K Chromatic Sealer NR. The G1 – G7 ratios will help to achieve better hiding when used as a guide for mixing the 2K Chromatic Sealer NR.

Mix Ratio By Volume			Mix Ratio By Cumulative Weight							
Mix Ratio			Grams				Parts			
			¼ Pint	½ Pint	Pint	Quart	¼ Pint	½ Pint	Pint	Quart
G1	D8081	3	104	208	417	834	117	235	470	941
	D8291	1	127	254	509	1018	143	287	574	1149
	D871	1	147	294	589	1179	166	332	665	1331
G2	D8081		99	198	397	795	112	224	448	897
	D8085	N/A	104	208	416	833	117	235	470	940
	D8291		126	253	507	1014	143	286	572	1144
	D871		146	293	586	1172	165	330	661	1322
G3	D8081	2	69	139	278	556	78	156	313	627
	D8085	1	103	207	415	831	117	234	468	937
	D8291	1	126	253	507	1015	143	286	572	1145
	D871	1	147	294	586	1176	165	331	663	1327
G4	D8081	1	34	69	139	278	39	78	156	312
	D8085	2	103	206	413	827	114	228	456	912
	D8291	1	126	252	505	1011	142	285	570	1140
	D871	1	145	293	586	1172	165	330	661	1322
G5	D8085	3	103	206	412	824	116	232	464	929
	D8291	1	126	252	504	1008	142	284	568	1137
	D871	1	146	292	584	1169	164	329	659	1319
G6	D8085	2	68	137	274	549	77	154	309	619
	D8087	1	102	205	411	822	115	231	463	927
	D8291	1	125	251	503	1006	141	283	567	1135
	D871	1	145	291	583	1167	164	329	658	1317
G7	D8087	3	102	204	409	818	115	230	461	923
	D8291	1	125	250	501	1002	141	282	565	1131
	D871	1	145	290	581	1163	164	328	656	1313

Emergency Medical or Spill Control Information (412) 434-4515; 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.

PPG Automotive Refinish

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