AUTOMOTIVE REFINISH

Product Information

D822

Corrosion Resistant Primer Sealer

Product Description
D822 Corrosion Resistant Primer is a two-pack sealer for use under Global topcoat colours. It must be activated with D823 Corrosion Resistant Primer Sealer Catalyst.

Preparation of Substrate

In all cases, wash with soap and water, then use the appropriate Global cleaner. See GLG142 Global Cleaners bulletin for selection and usage instructions. Ensure that the substrate is thoroughly cleaned and dried both before and after preparation work.

Original Paintwork and Electrodeposition Primer must be sanded using European P280 / U.S. 240 grit discs (dry) or European P360 / U.S. 320 grade paper (wet). Exposed bare metal should be spot-primed with a suitable bare metal primer (see below).

Bare Steel and Aluminum must be clean, rust-free and abraded before application (minimum 2 coats of D822). For maximum corrosion resistance apply one coat of D831 Chromate-free Wash Primer.

Galvanized Steel must be thoroughly abraded and primed with one coat of D831 Chromate-free Wash Primer.

Polyester Body Fillers should be dry sanded using European P400 / U.S. 360 grit paper. A minimum of 2 coats of D822 is required over these substrate types.

Fibre Glass and SMC should be dry sanded using European P280 / U.S. 240 grit paper.

Ensure that the substrate is thoroughly cleaned and dried after preparation work.

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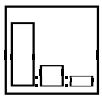
APPLICATION GUIDE

Mixing Ratio

Primer Sealer



D822	**3 vols**
D823	**1 vol**
D-Thinner	**½ vol**

D-Thinner Selection:	*D-Exempt Thinner*	*Appropriate Temperature Range:*
D870	**D8764**	**Up to 18°C / 65 °F**
D871	**D8774**	**18° - 25°C / 65° - 77°F**
D872	**D8767**	**25° - 35°C / 77° - 95°F**
D873		**Over 35°C / 95°F**

Note: *D8700 Retarder may be mixed with thinners in temperatures over 35°C / 95°F. The retarder can be mixed up to 25% with the appropriate thinner. Do not use D8700 alone as a reducer.*

Potlife

@ 20°C / 68°F — 1 - 1½ hours

Additives

D822 can be tinted using DG toners only!

3 vols - D822
1 vol - D823
1 vol - D-Thinner
1 vol - DG Toner

Spraygun set-up

Fluid Tip	1.4 – 1.6 mm or equivalent
Spray Viscosity	22 seconds ZAHN #2 @ 20°C / 68°F

Spray pressure

HVLP at air cap	0.7 bar / 10 PSI
Conventional at spray gun	3 - 4 bar / 45 - 55 PSI

Number of coats

Primer Sealer — 1 – 2 wet coats

Recommended film build per wet coat	3.0 - 3.5 mils
Recommended dried film build per coat	1.5 mils

Flash off at 20ºC / 68ºF

Between coats	5 – 10 minutes
Before stoving	10 minutes
Before Topcoat	20 minutes minimum (1 coat) 45 minutes minimum (2 coats) 8 hours maximum, before sanding is required

APPLICATION GUIDE

Drying times

Dust-free
20ºC / 68ºF: 10 minutes

Dry to sand — *If rework is necessary,*
20ºC / 68ºF: 1 – 2 hours
60ºC / 140ºF 20 – 30 minutes

Tape Time
20ºC / 68ºF: 1 – 2 hours
60ºC / 140ºF 20 – 30 minutes

IR (Infrared)
Medium wave 20 minutes
Short wave 10 minutes (includes 3 minute ramp-up time)

Overcoat /Recoat

Topcoat over Primer Sealer
20 minutes minimum (1 coat)
45 minutes minimum (2 coats)
8 hours maximum, before sanding is required

Overcoat with Any Global topcoat

Sanding

If rework is necessary or maximum flashtime is exceeded,

Grade wet European P600 / U.S. 400 followed by European P1200 / U.S. 600

Grade dry European P360 / U.S. 320 followed by European P1000 / U.S. 500

Performance Guidelines

The use of HVLP spray equipment can give an increase in transfer efficiency of about 10% depending on the make and model of equipment used.

If D822 is used for spot priming, the panel to be primed must be thoroughly sanded beyond the edge of the spot repair.

Technical Data

Total Dry Film Build:	***Sealer or Tinted Sealer***
Minimum after sanding	37 µm / 1.5 mils
Maximum after sanding	75 µm / 3.0 mils
Film build per wet coat	75 - 87 µm / 3.0 - 3.5 mils
Dried film build per wet coat	37 µm / 1.5 mils
****Theoretical Coverage:**	12.5 m² per l / 514 sq.ft. per US gal.
When Tinted 3:1:1:1	11.3 m² per l / 464 sq.ft. per US gal.
% Solids By Volume RTS	48.1
When Tinted 3:1:1:1	43.4

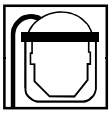
***Theoretical coverage in m^2/litre and sq.ft./US gal. ready-to-spray (RTS), giving 100µm (4 mils) dry film thickness for Primer Surfacer and 37µm (1.5 mils) for primer sealer.*

VOC

(D822)	395 gms per litre / 3.3 lbs per US gal.
(D822:D823:D872, 3:1:½)	419 gms per litre / 3.5 lbs per US gal. (less exempts)
(D822:D823:D8774, 3:1:1:1)	371 gms per litre / 3.1 lbs per US gal. (less exempts)

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.

Emergency Medical or Spill Control Information (304) 843-1300; 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.

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Global At A GLANCE

D822

Corrosion Resistant Primer Sealer

Mix:		
Primer-Sealer 	***D822** **D823** **D-Thinner**	**3 Vols** **1 vol** **½ vol**

Thinner Selection — ***Temperature range:***

D870	Up to 18°C / 65 °F
D871	18° - 25°C / 65° - 77°F
D872	25° - 35°C / 77° - 95°F
D873	Over 35°C / 95°F

Note: *D8700 Retarder may be mixed with thinners in temperatures over 35°C / 95°F. The retarder can be mixed up to 25% with the appropriate thinner. Do not use alone as a reducer.*

Additives: 	*D822 can be tinted using DG toners only!*	**3 vols of D822** **1 vol of D823** **1 vol of appropriate D-Thinner** **1 vol of DG Toner**
Pot life: 	@ 20°C / 68°F	1 - 1½ hours
Air Pressure: 	*HVLP at the cap:* *Conventional at the gun:* *Fluid tip:*	0.7 bar / 10 PSI 3 - 4 bar / 45 - 55 PSI 1.4 - 1.6 mm or equivalent
Application: 	*Apply:* *Between coats:* *Film build per wet coat* *Dried film build per coat*	1 - 2 coats 5 - 10 minutes 3.0 - 3.5 mils (sealer or tinted) 1.5 mils (sealer or tinted)
Dry Times: 	*Before stoving:* *Dust-free* 20ºC / 68ºF:	10 minutes 10 minutes
	*Dry to sand* 20ºC / 68ºF: 60ºC / 140ºF:	*If rework is necessary,* 1 - 2 hours 20 - 30 minutes**
	*Tape time* 20ºC / 68ºF: 60ºC / 140ºF:	 1 - 2 hours 20 - 30 minutes**
	*IR (Infrared)* Medium wave Short wave	 20 minutes 10 minutes (includes 3 minute ramp time)
	*Overcoat Primer Sealer* 20ºC / 68ºF:	20 minutes minimum (1 coat) 45 minutes minimum (2 coats) 8 hours maximum before sanding is required

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

Warning: Do not use sealer applications over polyester body filler substrates.

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