GLOBAL REFINISH SYSTEM

Product Information

2K Chromatic Sealer LV (2.8 VOC)

DLV8081 White
DLV8085 Gray
DLV8087 Black
DLV8088 Red
DLV8089 Yellow
DLV8090 Blue

Product Description

The 2K Chromatic Sealer LV's (DLV80xx) are premium quality primer sealers suitable for the advanced technology finishes used in today's refinish bodyshops.

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

Preparation of Substrate



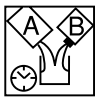
- In all cases, wash all surfaces to be painted with soap and water, then apply the appropriate Global cleaner. See EU-134 Global Cleaners bulletin for selection and usage instructions. Ensure that the substrate is thoroughly cleaned and dried both before and after application work.
- Original Paintwork 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 LV must be applied in two coats. With the higher film build of 2K Chromatic Sealer LV, 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 LV 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:

DLV80xx 2K Sealer:	**3 Vols.**
DLV8291 Catalyst:	**1 Vol.**
Compliant 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 LV must be applied in two coats. With the higher film build of 2K Chromatic Sealer LV, additional flash time for the sealer may be necessary.



Pot Life — 1 hour @ 70°F / 21°C

Thinner Selection:

D8764	Fast Compliant Thinner
D8774	Medium Compliant Thinner
D8767	Slow Compliant Thinner

Additives:

SLV814 Universal Flexibilizer

Ready-to-Spray DLV80xx 2K Sealer:	**10 Vols**
SLV814:	**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 @ 70°F / 21°C for 1 coat 30 minutes @ 70°F / 21°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 — 1 1/2 hours

IR (Infrared)

IR Medium Wave	10 minutes
IR Short Wave	5 minutes

APPLICATION GUIDE

Overcoat / Recoat

Envirobase or any Global Topcoat

15 minutes @ 70°F / 21°C for 1 coat
30 minutes @ 70°F / 21°C for 2 coats

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

Grade wet — U.S. 500 / P1000 grade paper

Grade dry — 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 550 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 LV)	3.1 lbs per U.S. gallon / 376 gms per liter
(2K Chromatic Sealer LV: Hardener: Thinner, 3:1:1)	2.8 lbs per U.S. gallon / 336 gms per liter

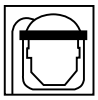
RTS Combinations:	DLV808X : DLV8291 : D8764/74/67	DLV808X : DLV8291 : D8764/74/67 + SLV814
Volume Ratio:	3 : 1 : 1	3 : 1 : 1 + 10%
Applicable Use Category	Primer	Primer
VOC Actual (g/l)	177 - 183	165 - 170
VOC Actual (lbs/gal)	1.48 - 1.53	1.37 - 1.42
VOC Regulatory (less water less exempt) (g/l)	326 - 329	313 - 316
VOC Regulatory (less water less exempt) (lbs/gal)	2.72 - 2.75	2.61 - 2.64
Density (g/l)	1322 - 1373	1319 - 1385
Density (lbs/gal)	11.03 - 11.46	11.01 -11.56
Volatiles wt. %	54.5 - 56.7	55.3 - 57.0
Water wt. %	0.0	0.0
Exempt wt. %	41.1 - 43.3	42.4 - 45.0
Water vol. %	0.0	0.0
Exempt vol. %	44.5 - 45.5	46.3 - 47.2

AChromatic Gray Mixing Chart — 2K Chromatic Sealers LV

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

Mix Ratio By Volume			Mix Ratio By Cumulative Weight							
			Grams				Parts			
	Mix Ratio		1/4 Pint	***1/2 Pint***	Pint	***Quart***	1/4 Pint	***1/2 Pint***	Pint	***Quart***
G1	**DLV8081**	**3**	104	***207***	417	***834***	117	***234***	471	***942***
	DLV8291	**1**	134	***266***	535	***1070***	151	***300***	604	***1209***
	D8767	**1**	166	***329***	662	***1324***	187	***372***	748	***1496***
G2	**DLV8081**		98	***196***	396	***792***	111	***221***	447	***895***
	DLV8085	**N/A**	103	***206***	417	***834***	116	***233***	471	***942***
	DLV8291		133	***265***	535	***1070***	150	***299***	535	***1209***
	D8767		165	***328***	662	***1324***	186	***371***	748	***1496***
G3	**DLV8081**	**2**	69	***138***	278	***556***	78	***156***	314	***628***
	DLV8085	**1**	103	***206***	415	***831***	116	***233***	469	***939***
	DLV8291	**1**	132	***265***	533	***1068***	149	***299***	602	***1207***
	D8767	**1**	163	***328***	660	***1322***	184	***371***	746	***1494***
G4	**DLV8081**	**1**	35	***69***	139	***278***	39	***78***	157	***314***
	DLV8085	**2**	103	***205***	413	***827***	116	***231***	467	***934***
	DLV8291	**1**	132	***264***	531	***1064***	149	***298***	600	***1202***
	D8767	**1**	163	***327***	658	***1318***	184	***369***	743	***1489***
G5	**DLV8085**	**3**	102	***204***	412	***824***	115	***230***	465	***931***
	DLV8291	**1**	131	***263***	530	***1060***	148	***297***	599	***1198***
	D8767	**1**	162	***326***	657	***1314***	183	***368***	742	***1484***
G6	**DLV8085**	**2**	68	***136***	275	***555***	77	***154***	311	***627***
	DLV8087	**1**	102	***204***	411	***822***	115	***230***	464	***929***
	DLV8291	**1**	131	***263***	529	***1058***	148	***297***	598	***1196***
	D8767	**1**	162	***326***	656	***1312***	183	***368***	741	***1482***
G7	**DLV8087**	**3**	101	***203***	409	***818***	114	***229***	462	***924***
	DLV8291	**1**	130	***262***	527	***1054***	147	***296***	595	***1191***
	D8767	**1**	161	***325***	654	***1308***	182	***367***	739	***1478***

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 (412) 434-4515; In Canada (514) 645-1320

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PPG Industries
19699 Progress Drive
Strongsville, OH 44149
1-800-647-6050

PPG Canada Inc.
2301 Royal Windsor Drive
Mississauga, Ontario L5J 1K5
1-888-310-4762

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