



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.

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## APPLICATION GUIDE:

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### 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

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### “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.

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### Additives:



D814 Plasticiser

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

**D814: 1 Vol**

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### Spraygun Set-up:



Fluid Tip

1.4 – 1.6 mm or equivalent

Spray Viscosity

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

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### Spray Pressure:

HVLP at air cap 10 PSI

Conventional at spray gun 40 – 45 PSI

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### Number of Coats:



Apply

1-2 wet coats

Film build per wet coat

2.5 mils

Dried film build per coat

1.0 mils

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### 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.

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### 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

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## APPLICATION GUIDE

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### 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

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### 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.

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### 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

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

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### **Emergency Medical or Spill Control Information (412) 434-4515; In Canada (514) 645-1320**

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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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