



GLOBAL  
REFINISH  
SYSTEM



AUTOMOTIVE REFINISH

# Product Information

Low VOC Primer Surfacer

## D860

### Product Description

D860 Low VOC Primer Surfacer is a light brown, one-pack, waterborne primer surfacer for use under Global topcoat colours. It is intended for use in markets where low VOC primer sealers are allowed a 2.1 lbs/gal maximum.

### Preparation of Substrate

Wash all surfaces to be painted with soap and water. Degrease all surfaces with appropriate Global substrate cleaner (See GLG-142 Global Cleaners bulletin for selection and usage instructions).



Original Paintwork and Electrodeposition Primer should be sanded using European P280 / U.S. 240 grit discs (dry) or European P360 / U.S. 320 grade paper (wet).



Bare Steel, Galvanized Steel and Aluminum must be clean, rust-free and abraded thoroughly using P180 / U.S. 180 to European P280 / U.S. 240 grit paper before application.



Polyester Body Fillers should be dry sanded using European P280 / U.S. 240 grit paper.

Fibre Glass and SMC should be dry sanded using European P400 / U.S. 360 grit paper.

Plastic should be dry sanded with European P600 / U.S. 400 (use a finer grit for softer plastics) and primed first with D820 (See EU99) Plastic Adhesion Promoter or SX1050/SXA1050 (See PD708) Plastic Adhesion Promoters.

Wash off residue and dry thoroughly before re-cleaning with appropriate Global substrate cleaner. The use of a tack rag is recommended.

---

## APPLICATION GUIDE

---

### Mixing Ratio



**D860 Low VOC Surfacers: 10 Vols.**  
**T494 De-ionized Water: 1 Vol.**

Note – Stir well before using, **do not** agitate on paint shaker.

---

### Potlife



None

---

### Additives



None

---

### Spraygun set-up

*Fluid Tip* 1.4 - 1.6 mm or equivalent  
*Spray Viscosity* 40 - 50 secs 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



*Apply* 2 - 3 wet coats  
*Film build per wet coat* 4.0 mils  
*Dried film build per coat* 2.0 mils

---

### Flash off at 20°C / 68°F



*Between coats* 10 - 15 minutes  
*Before stoving* 10 minutes  
*Before Topcoat* 1 – 2 hour minimum  
72 hours maximum, after 72 hours D860 must be sanded.

---

### Drying times



*Dust-free*  
*20°C / 68°F:* 15 minutes

*Dry to handle*  
*20°C / 68°F:* 1 hour



*Dry to Sand*  
*20°C / 68°F:* 1 – 2 hours  
*60°C / 140°F:* 20 – 30 minutes\*

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

---

## APPLICATION GUIDE

---

### **Drying times (Cont.)**



Tape Time	1 hour
20°C / 68°F:	
60°C / 140°F:	20 minutes*



IR (Infrared)	10 minutes
Medium Wave	
Short Wave	5 minutes

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

---

### **Overcoat /Recoat**



Dry to Topcoat	1 - 2 hour minimum
	72 hours maximum



Grade dry	Use European P360 / U.S 320 followed by European 1000 / U.S. 500 grit
Grade wet	Use European P600 / U.S 400 followed by European 1200 / U.S. 600 grit



Overcoat with	Any Global topcoat
---------------	--------------------

---

### **Performance Guidelines**

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

If D860 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:**

Film build per wet coat	4.0 mils
Dried film build per coat	2.0 mils
Minimum after sanding	50µ / 2.0 mils
Maximum after sanding	88µ / 3.5 mils

#### **Theoretical coverage**

590 sq ft per US gallon

*Theoretical coverage in sq.ft. /US gal. Ready-to-spray (RTS), giving 25µm (1 mils) dry film thickness*

#### **Percent solids by volume RTS**

36.8

#### **VOC**

(D860)	146 gms per litre / 1.2 lbs per U.S. gal.
(D860 De-ionized Water, 10:1)	146 gms per litre / 1.2 lbs per U.S. gal.

---

## **Compatible Primers & Surfacer**

---

D860 may be applied directly over:

- D820 Plastic Adhesion Promoter
- D822 Corrosion Resistant Primer Sealer\*
- D824 Prime-Fill Low VOC 2K Surfacer\*
- D825 2K Tintable Surfacer
- D839 2K Component Primer\*
- D848 Waterborne 2K Primer Surfacer Sealer
- D8002 UHS Sealer\*
- D8006 Direct to Metal Primer Surfacer
- Uni-Prime® DTM
- D859 Low VOC Sealer
- D8070 Series 2K Chromatic Sealer
- SX1056 Flexible 2K Sealer (Specialty Performance Products)

\*Fully cured and sanded

---

## **Compatible Topcoat Systems**

These topcoat systems may be applied directly over D860:

- Global DG Direct Gloss Colour
  - Global BC Basecoat Colour
  - DGLV Direct Gloss Low VOC Colour
- 

## ***This product should not be applied directly over (Incompatible)***

D831 Chromate Free Wash Primer

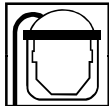
---

## **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.

**PPG Industries  
19699 Progress Drive  
Strongsville, OH 44149**

**PPG Canada Inc.  
1330 Castlefield Avenue  
Toronto, Ontario M6B 4B3**

# Global At A Glance D860

## NAME

<b>Mix:</b> 	<b>D860 Low VOC Surfacers: 10 Vols.</b> <b>De-ionized Water: 1 Vol.</b>
<b>Pot life:</b> 	None
<b>Additives:</b> 	None
<b>Air Pressure:</b> 	<i>HVLP:</i> 0.7 bar / 10 PSI <i>Conventional:</i> 3 – 4 bar / 45 – 55 PSI <i>Fluid tip:</i> 1.4 – 1.6 mm or equivalent
<b>Application:</b> 	<i>Apply:</i> 2 – 3 wet coats <i>Between coats:</i> 10 – 15 minutes <i>Before Stoving:</i> 10 minutes  <i>Film Build Per Wet Coat:</i> 4.0 mils <i>Dried Film Build Per Coat:</i> 2.0 mils
<b>Dry Times:</b> 	<i>Dust-free</i> 20°C / 68°F: 15 minutes  <i>Dry to handle</i> 20°C / 68°F: 1 hour
	<i>Dry to sand</i> 20°C / 68°F: 1 – 2 hours 60°C / 140°F: 20 – 30 minutes
	<i>Tape</i> 20°C / 68°F: 1 hour 60°C / 140°F: 20 minutes
	<i>IR (Infrared)</i> Medium wave: 10 minutes Short wave: 5 minutes
	<i>Dry to Topcoat</i> 20°C / 68°F: 1 – 2 hour minimum 72 hours maximum
	<i>Overcoat with:</i> Any Global Topcoat

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

**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.

© 2001 PPG Industries

**PPG Industries  
19699 Progress Drive  
Strongsville, OH 44149**

**PPG Canada Inc.  
1330 Castlefield Avenue  
Toronto, Ontario M6B 4B3**