



AUTOMOTIVE REFINISH

GLOBAL  
REFINISH  
SYSTEM



# Product Information

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# Foundation Coats

**D825 Tintable Foundation Coat**  
**D839 2K Foundation Coat**  
**D891 Foundation Coat**  
**D8006 UHS Foundation Coat**  
**UniPrime<sup>®</sup> DTM Foundation Coat**

- D8040 WHITE
- D8041 BLACK
- D8042 GRAY
- D8043 RED
- D8044 YELLOW
- D8045 BLUE

Foundation Coats or Ground Coats are tinted primer sealers which assist in hiding or color match of basecoat colors used in Multi-Stage Topcoat Systems. When Foundation Coats or Ground Coats are used, the resulting Ready-to-Spray VOC calculation must comply with the limits for a Multi-Stage System. When tinting primer sealers, the VOC of the sealer must meet the limits of that category prior to adding any tint.

## 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 should 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).



Electrodeposition Primer must be thoroughly cleaned as outlined above and may then be directly overcoated with D825 or D839 Foundation Coats without abrading. If D891, D8006 or D8040 - D8045 are used as Foundation Coats, the Electrodeposition Primer must be sanded as required in the original paintwork recommendation.



Aluminum, Bare Steel and Galvanized Steel must be clean, rust-free and abraded thoroughly using European P180 / U.S. 180 to European P280 / U.S. 240 grit paper and primed with D831 Chromate-Free Wash Primer after sanding.

Polyester Body Fillers should be dry sanded with European P180 / U.S. 180 followed by European P280 / U.S. 240 grit paper. Do not apply Uniprime<sup>®</sup> DTM as a sealer over polyester body fillers.

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

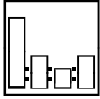
Ensure that the substrate is thoroughly cleaned and dried after preparation work.

# D825 Tintable Foundation Coat

D825 is a translucent, premium quality tintable Foundation Coat for today's advanced technology finishes. D825 is designed to be tinted with D894 or DG colour to reach a wide spectrum of colours. Tinted D825 must be mixed with D8296 hardener.

## APPLICATION GUIDE

### Mixing Ratio:



<b>D825</b>	<b>4 vols</b>
<b>DG Color</b>	<b>2 vols</b>
<b>D8296 hardener</b>	<b>1 vol</b>
<b>Thinner*</b>	<b>2 vols</b>

### Thinner Selection

Fast Compliant  
Medium Compliant  
Retarder - may replace up to 25% of recommended thinner levels in very warm conditions.

### Temperature

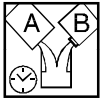
up to 18°C / 65°F  
18° - 25°C / 65° - 77°F

### Thinner

D8764  
D8774  
D8700

**\*Do not use D8767**

### Potlife:



1 hour @ 21°C / 70°F tinted.

### Additives:



None

### Spraygun set-up:



1.4 - 1.6 mm or equivalent

### Spray pressure:

*HVLP at air cap*  
*Conventional at spray gun*

0.7 bar / 10 PSI  
4 bar / 40 – 50 PSI

### Number of coats:



1 wet coat

### Drying times:



*Dry time to topcoat:*  
*Dry to Dirt Nib*

15 minutes @ 70°F (21° C)  
3 hours

**Note:** After 72 hours you must sand and re-apply product.

### Technical Data:

#### Total dry film build

minimum 25µm / 1.0 mils  
maximum 35µm / 1.4 mils

#### Theoretical coverage

11.9 m<sup>2</sup> per l / 487sq. ft. per US gal

#### Percent solids by volume RTS

35.3

#### VOC

D825 package 503 gms per litre / 4.2 lbs. per US gal.  
D825: D8296 (4:1) 407 gms per litre / 3.4 lbs. per US gal.  
D825 package less exempt solvents 503 gms per litre / 4.2 lbs. per US gal.  
D825:DG:D8296:Compliant Thinner (4:2:1:2) 623 gms per litre / 5.2 lbs. per US gal  
D825:DG:D8296:Compliant Thinner (4:2:1:2) less exempt solvents 467 gms per litre / 3.9 lbs. per US gal

# D839 2K Foundation Coat

D839/D8296 has been specifically designed as a premium quality Foundation coat for today's advanced technology finishes. D839 can be used over sanded original finishes and/or properly prepared and treated bare steel, aluminum, fiberglass, and plastic substrates.

## APPLICATION GUIDE

### Mixing Ratio:



<b>D839</b>	<b>4 vols</b>
<b>DG Color</b>	<b>2 vols</b>
<b>D8296</b>	<b>1 vol</b>
<b>Thinner*</b>	<b>2 vols</b>

### Thinner Selection

Fast Compliant  
Medium Compliant  
Retarder - may replace up to 25% of recommended thinner levels in very warm conditions.

### Temperature

up to 18°C / 65 °F  
18° - 25°C / 65° - 77°F

### Thinner

D8764  
D8774  
D8700

**\*Do not use D8767**

### Potlife:



1 hour @ 21°C / 70°F

### Additives:



None

### Spraygun set-up:



1.6 - 1.8 mm or equivalent

### Spray pressure:

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

### Number of coats:



1 wet coat

### Drying times:



Dry time to topcoat	15 minutes @ 21°C / 70°F
Dry to Dirt Nib	3 hours @ 21°C / 70°F

**Note:** After 72 hours you must sand and re-apply product.

### Technical Data:

#### Total dry film build

Minimum 25µm / 1.0 mils

Maximum 35µm / 1.4 mils

Theoretical coverage 13.6 m<sup>2</sup> per l / 558sq. ft. per US gal

Percent solids by volume RTS 34.8

#### VOC

D839 Package 503 gms per litre/ 4.2 lbs. per US gal

D839 Package less exempt solvents 503 gms per litre/ 4.2 lbs. per US gal

D839:D8296 (4:1) 407 gms per litre/ 3.4 lbs. per US gal

D839:D8296:Compliant Thinner:DG 623 gms per litre/ 5.2 lbs. per US gal

(4:2:1:2)

D839:D8296:Compliant Thinner:DG 467 gms per litre/ 3.9 lbs. per US gal

(4:2:1:2) less exempt solvents

# D891 Foundation Coat

D891 Sealer is a grey two-pack Foundation Coat for use under Global Bascoat colours. It is designed to give the optimum topcoat appearance. It must be activated with D892 Catalyst.

## APPLICATION GUIDE

### Mixing Ratio:



<b>D891</b>	<b>4 vols</b>
<b>D892</b>	<b>2 vols</b>
<b>Global thinner</b>	<b>1 vols</b>
<b>DG Colour</b>	<b>1 vols</b>

### Thinner Selection

Cool / Compliant  
Warm / Compliant  
Hot / Compliant  
Very Hot  
Retarder - may replace up to 25% of recommended thinner levels in very warm conditions.

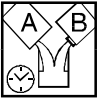
### Temperature

up to 18°C / 65 °F  
18° - 25°C / 65° - 77°F  
25° - 35°C/ 77° - 95°F  
Over 35°C / 95°F

### Compliant or D-Thinner

D8764 or D870  
D8774 or D871  
D8767 or D872  
D873  
D8700

### Potlife:



1 hour @ 21°C / 70°F tinted

### Additives:



None

### Spraygun set-up:



1.4 - 1.6 mm or equivalent

### Spray pressure:

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

### Number of coats:



1 wet coat

### Drying times:



*Dry time to topcoat:* 20 minutes @ 70°F (21°C)

**NOTE: D891 must be scuffed after 75 min. @ 70°F (21°C) or 60 min. @ 90°F (32°C).**

### Technical Data:

#### Total dry film build

Minimum 25µm / 1.0 mils

Maximum 37.5µm / 1.5 mils

Theoretical coverage 19.8 m<sup>2</sup> per l / 808sq. ft. per US gal.

Percent solids by volume RTS 50.4

#### VOC

D891 package 347 gms per litre/ 2.9 lbs. per US gal

D891 package less exempt solvents 347 gms per litre/ 2.9 lbs. per US gal

D891:D892 :D800 Series Thinner :DG Colour (4:2:1:1) 455 gms per litre/ 3.8 lbs. per US gal.

D891:D892 :D800 Series Thinner :DG Colour (4:2:1:1) 443 gms per litre/ 3.7 lbs. per US gal.

Less exempt solvents

D892 package 419 gms per litre/ 3.5 lbs. per US gal

D892 package less exempt solvents 300 gms per litre/ 2.5 lbs. per US gal

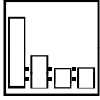
D891:D892 :D8000 Series Thinner :DG Colour (4:2:1:1) Less exempt solvents 371 gms per litre/ 3.1 lbs. per US gal

# D8006 UHS Foundation Coat

D8006 UHS is a grey 2.8 VOC two-pack Foundation Coat for use under Global basecoat colours. D8006 must be activated with D8205 UHS Hardener.

## APPLICATION GUIDE

### Mixing Ratio:



<b>D8006</b>	<b>4 vols</b>
<b>D8205</b>	<b>2 vols</b>
<b>Global Thinner</b>	<b>1 vol</b>
<b>DG Colour</b>	<b>1 vol</b>

### Thinner Selection

Cool / Compliant  
Warm / Compliant  
Hot / Compliant  
Very Hot

*Retarder - may replace up to 25% of recommended thinner levels in very warm conditions.*

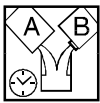
### Temperature

up to 18°C / 65 °F  
18° - 25°C / 65° - 77°F  
25° - 35°C/ 77° - 95°F  
Over 35°C / 95°F

### Compliant or D-Thinner

D8764 or D870  
D8774 or D871  
D8767 or D872  
D873  
D8700

### Potlife:



30 minutes @ 21°C / 70°F

### Additives:



None

### Spraygun set-up:



1.4 - 1.6 mm or equivalent

### Spray pressure:

*HVLP at air cap*

0.7 bar / 10 PSI

*Conventional at spray gun*

3 - 4 bar / 45 - 55 PSI

### Number of coats:



1 wet coat

### Drying times:



*Dry time to topcoat: 1 coat*

30 minutes @ 70°F (21°C)

Must be scuffed after 8 hours @ 70°F (21°C)

**Note:** When topcoating with BC, you must add D888 Activator to BC color @ 1.5 oz. per ready-to-spray quart

### Technical Data:

#### Total dry film build

Minimum

25µm / 1 mil

Maximum

37.5µm / 1.5 mils

#### Theoretical coverage

25.7m<sup>2</sup> per l / 1048 sq. Ft. per US gal

#### Percent solids by volume RTS

53.6

#### VOC

D8006

288 gms per litre/ 2.4 lbs. per US gal

D8006 less exempt solvents

263 gms per litre/ 2.2 lbs. per US gal

D8006:D8205:D800 Series Thinner :DG (4:2:1:1)

383 gms per litre/ 3.2 lbs. per US gal

D8006:D8205:D800 Series Thinner :DG (4:2:1:1)  
less exempt solvents

359 gms per litre/ 3.0 lbs. per US gal

D8206

288 gms per litre/ 2.4 lbs. per US gal

D8206 less exempt solvents

204 gms per litre/ 1.7 lbs. per US gal

D8006:D8205:D8000 Series Thinner :DG (4:2:1:1)

288 gms per litre/ 2.4 lbs. per US gal

less exempt solvents

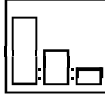
# UniPrime<sup>®</sup> DTM Foundation Coat

UniPrime<sup>®</sup>DTM is a two-pack Foundation Coat for use under Global basecoat colours. It can be applied directly to sanded aluminum, galvanized steel or cold rolled steel, without a pretreatment or wash primer application. If applied direct to metal substrates, two coats are required in order to maintain a minimum dry film build of 2.0 mils. UniPrime<sup>®</sup>DTM is available in six stand-alone bases which may be blended together to obtain a variety of colours.

## APPLICATION GUIDE

### Mixing Ratio:

Primer Sealer



UniPrime<sup>®</sup> DTM  
D8240 Hardener  
Global D series Thinner

2 vols  
1 vol  
½ vol max

### Thinner Selection

Cool / Compliant  
Warm / Compliant  
Hot / Compliant  
Very Hot  
Retarder - may replace up to 25% of recommended thinner levels in very warm conditions.

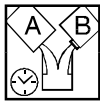
### Temperature

up to 18°C / 65 °F  
18° - 25°C / 65° - 77°F  
25° - 35°C/ 77° - 95°F  
Over 35°C / 95°F

### Compliant or D-Thinner

D8764 or D870  
D8774 or D871  
D8767 or D872  
D873  
D8700

### Potlife:



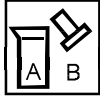
45 minutes @ 20°C / 68°F with global thinner

### Additives:



None

### Tinting:



DTM Primer colors may be blended together.  
See DTM Swatch Deck – DOX431

**Note:** DTM Primer cannot be tinted with any other product

### Spraygun set-up:



1.4 - 1.6 mm or equivalent

### Spray pressure:

HVLP at air cap 0.7 bar / 10 PSI  
Conventional at spray gun 2.5 - 3.5 bar / 35 - 45 PSI

### Number of coats:



1 - 2 medium coats

**Note:** In direct to metal applications, maintain a minimum of 2.0 mils of dry film.

### Drying times:



Dry to Topcoat	1Coat	2 Coats
20°C / 68°F:	30 minutes minimum**	60 minutes minimum**
60°C / 140°F	15 minutes	15 minutes

\*\*If the sealer is allowed to dry more than 6 hours, it must be scuffed and reapplied before color application.

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# UniPrime<sup>®</sup> DTM Foundation Coat (Continued)

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## Technical Data:

### Total dry film build

Minimum 25µm / 1.0 mils

Maximum 75µm / 3.0 mils

### Theoretical coverage

18.4 m<sup>2</sup> per l / 746 sq. ft. per US gal.

### Percent solids by volume RTS

46.6

### VOC

D804X package 371 gms per litre / 3.1 lbs. per US gal.

D804X:D8240:D800 Series Thinner (2:1: ½) 455 gms per litre / 3.8 lbs. per US gal.

D804X:D8240:D800 Series Thinner (2:1: ½) 431 gms per litre / 3.6 lbs. per US gal.

less exempt solvents

D804X:D8240:Compliant Thinner (2:1: ½) 491 gms per litre / 4.1 lbs. per US gal.

D804X:D8240:Compliant Thinner (2:1: ½) 359 gms per litre / 3.0 lbs. per US gal.

less exempt solvents

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## Overcoat:



Compatible Topcoats

BC Basecoat Colour

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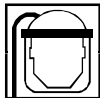
## Performance Guidelines:

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

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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.
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### 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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