



GLOBAL REFINISH
SYSTEM

Product Information

2K *A*-Chromatic Surfacer LV (2.1 VOC)

DLV8001 White

DLV8005 Gray

DLV8007 Black

Product Description

The 2K A-Chromatic Surfacer LV's (DLV800x) are premium quality primer surfacers suitable for the wide range of repair work done in today's refinish bodyshops.

2K A-Chromatic Surfacer LV's offer excellent adhesion, film build, surface leveling and gloss holdout over a wide range of substrates. A variety of A-Chromatic grays can be achieved by intermixing the white, gray and black surfacers. This versatile, quick drying, easy to apply and sand primer may be applied as a conventional spray filler or primer surfacer.

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. 240 / European P280 grit discs (dry) or U.S. 320 / European P360 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. When using the 2K A-Chromatic Surfacer as a spray filler or primer surfacer, abrade the electrodeposition primer as recommended in the "original paintwork" section.



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 and primed with D831 Chromate-Free Wash Primer after sanding.

Polyester Body Fillers should be dry sanded with U.S. 180 / European P180 followed by 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 prime first with D820 Plastic Adhesion Promoter.

APPLICATION GUIDE:

Mix Ratios:

When Mixed as:



Spray Filler Optimum Film Build

DLV800x 2K Surfacer : 4 Vols
DLV8291 Hardener : 1 Vol
Compliant Thinner : —



Pot life when sprayed as a Spray Filler

Pot life when sprayed as a Primer Surfacer



Primer Surfacer Optimum Drying Speed

DLV800x 2K Surfacer : 4 Vols
DLV8291 Hardener : 1 Vol
Compliant Thinner : 1 Vol

30 minutes @ 70°F / 21°C

1 hour @ 70°F / 21°C

Compliant Thinner Selection:

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

Additives:



SLV814 Universal Flexibilizer

Ready-to-spray DLV800x 2K Surfacer: 10 Vols
SLV814: 1 Vol

Spraygun Set-up:



When Sprayed as a:

Spray Filler

Primer Surfacer

1.7 - 2.0 mm or equivalent

1.6 - 1.8 mm or equivalent

Spray Pressure:

HVLP at air cap 10 PSI
Conventional at spray gun 45 PSI

Number of Coats:



When Sprayed as a:

Spray Filler

Primer Surfacer

Apply

Up to a maximum of 4 wet coats

2 to 3 wet coats

Film build per wet coat

5.0 mils

4.0 mils

Dried film build per coat

2.0 mils

1.5 mils

Flash Off at 68°F / 20°C:



Between Coats
Before Baking

Spray Filler

Primer Surfacer

5 – 10 minutes

5 – 10 minutes

N/A

10 minutes

Drying Times:



Dust-free
68°F / 20°C

Spray Filler

Primer Surfacer

15 minutes

15 minutes



Dry to Handle
68°F / 20°C

60 minutes

60 minutes



Dry to Sand
68°F / 20°C
140°F / 60°C

6 hour dry, preferably overnight
Do not force dry

1½ hours
30 minutes*



Tape Time
68°F / 20°C
140°F / 60°C

N/A
N/A

N/A
N/A



IR (Infrared)
Medium Wave
Short Wave

Do not force dry

20 minutes
10 minutes

* Baking 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

Overcoat / Recoat:



Dry to Topcoat
68°F / 20°C
140°F / 60°C



Grade wet



Grade dry

Overcoat with

Spray Filler

6 hours (after sanding)
N/A

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

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

Envirobase or any Global Topcoat

Primer Surfacer

1½ hours (or after sanding)
30 minutes (or after sanding)

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 used.

When **Spot Priming** 2K A-Chromatic Surfacer LV as a Primer Surfacer, adopt the following procedures:

- Thoroughly sand the surface to the edge of the panel or an inch or two beyond the damaged area, whichever is smaller.
- After applying the material and allowing it to dry as normal, be careful to thoroughly level the repair edge when sanding.
- Do not attempt spot repair on original or refinish thermoplastic applications, lacquer or 1K finishes.

Also... 2K A-Chromatic Surfacer LV and its ancillaries are sensitive to moisture, so all equipment must be perfectly dry. Partially used cans of hardener must be carefully closed.

Technical Data:

| | <u>Spray Filler</u> | <u>Primer Surfacer</u> |
|---|-----------------------------|-----------------------------|
| Total dry film build: | | |
| Minimum after sanding | 2.0 mils | 2.0 mils |
| Maximum after sanding | 10.0 mils | 6.0 mils |
| Film build per wet coat | 5.0 mils | 4.0 mils |
| Dried film build per coat | 2.0 mils | 1.5 mils |
| % solids by volume RTS | 40.55 | 33.79 |
| Theoretical coverage | Approx. 650 sq.ft. / US Gal | Approx. 542 sq.ft. / US Gal |
| <i>Theoretical coverage in sq.ft./US gal. ready-to-spray (RTS), 1.0 mil dry film thickness.</i> | | |

| RTS Combinations: | DLV800X : DLV8291 | DLV800X : DLV8291 : D8764/74/67 | DLV800X : DLV8291 : D8764/74/67 + SLV814 |
|---|-------------------|------------------------------------|---|
| | Volume Ratio: | 4 : 1 | 4 : 1 : 1 |
| Applicable Use Category | Primer | Primer | Primer |
| VOC Actual (g/l) | 137 - 142 | 114 - 119 | 108 - 111 |
| VOC Actual (lbs/gal) | 1.15 - 1.19 | 0.96 - 0.99 | 0.89 - 0.92 |
| VOC Regulatory (less water less exempt) (g/l) | 240 - 249 | 240 - 249 | 230 - 240 |
| VOC Regulatory (less water less exempt) (lbs/gal) | 2.0 - 2.08 | 2.0 - 2.08 | 1.92 - 2.00 |
| Density (g/l) | 1505 - 1556 | 1455 - 1497 | 1414 - 1493 |
| Density (lbs/gal) | 12.56 - 12.98 | 12.14 - 12.49 | 11.80 - 12.46 |
| Volatiles wt. % | 45.9 - 48.1 | 53.2 - 55.2 | 54.0 - 57.3 |
| Water wt. % | 0.0 | 0.0 | 0.0 |
| Exempt wt. % | 37.1 - 38.6 | 45.6 - 47.1 | 46.7 - 49.6 |
| Water vol. % | 0.0 | 0.0 | 0.0 |
| Exempt vol. % | 43.0 - 43.3 | 52.5 - 52.8 | 53.6 - 53.8 |

AChromatic Gray Mixing Chart

2K AChromatic Surfacer LV

This chart can be used to mix the 2K A-Chromatic Surfacer LV. The G1 – G7 ratios will help to achieve better hiding when used as a guide for mixing the 2K A-Chromatic Surfacer 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 | DLV8001 | 4 | 126 | 252 | 508 | 1025 | 142 | 285 | 574 | 1158 |
| | DLV8291 | 1 | 151 | 301 | 607 | 1224 | 171 | 340 | 686 | 1383 |
| | D8767 | 1 | 177 | 354 | 713 | 1437 | 200 | 400 | 806 | 1624 |
| G2 | DLV8001 | | 120 | 240 | 484 | 977 | 136 | 271 | 547 | 1104 |
| | DLV8005 | N/A | 126 | 252 | 509 | 1026 | 142 | 285 | 575 | 1159 |
| | DLV8291 | | 150 | 301 | 599 | 1224 | 169 | 340 | 677 | 1383 |
| | D8767 | | 177 | 354 | 705 | 1438 | 200 | 400 | 797 | 1625 |
| G3 | DLV8001 | 3 | 94 | 189 | 381 | 769 | 106 | 213 | 430 | 869 |
| | DLV8005 | 1 | 126 | 252 | 509 | 1026 | 142 | 285 | 575 | 1159 |
| | DLV8291 | 1 | 150 | 301 | 607 | 1225 | 169 | 340 | 686 | 1384 |
| | D8767 | 1 | 177 | 354 | 713 | 1439 | 200 | 400 | 806 | 1626 |
| G4 | DLV8001 | | 42 | 84 | 169 | 342 | 47 | 95 | 191 | 386 |
| | DLV8005 | N/A | 126 | 253 | 510 | 1029 | 142 | 286 | 576 | 1163 |
| | DLV8291 | | 151 | 302 | 608 | 1228 | 171 | 341 | 687 | 1388 |
| | D8767 | | 177 | 355 | 714 | 1441 | 200 | 401 | 807 | 1628 |
| G5 | DLV8005 | 4 | 127 | 253 | 511 | 1030 | 143 | 286 | 577 | 1164 |
| | DLV8291 | 1 | 151 | 302 | 609 | 1229 | 171 | 341 | 688 | 1389 |
| | D8767 | 1 | 177 | 355 | 715 | 1442 | 200 | 401 | 808 | 1629 |
| G6 | DLV8005 | | 81 | 162 | 327 | 658 | 91 | 183 | 369 | 743 |
| | DLV8007 | N/A | 123 | 247 | 498 | 1001 | 139 | 279 | 563 | 1131 |
| | DLV8291 | | 148 | 296 | 597 | 1199 | 167 | 334 | 675 | 1355 |
| | D8767 | | 174 | 348 | 703 | 1413 | 197 | 393 | 794 | 1597 |
| G7 | DLV8007 | 4 | 122 | 243 | 498 | 990 | 138 | 275 | 555 | 1119 |
| | DLV8291 | 1 | 146 | 292 | 590 | 1189 | 165 | 330 | 667 | 1343 |
| | D8767 | 1 | 173 | 345 | 696 | 1402 | 195 | 390 | 786 | 1584 |

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

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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