

D863 / D818

ACCELERATED SYSTEMS

PRODUCT DESCRIPTION

All Global Refinish System topcoats and clears are formulated to give fast drying and short process times in all normal working conditions and temperatures.

Global Accelerated Systems products can be used to reduce drying times in normal conditions.

ACCELERATED SYSTEM PRODUCTS

D863 Accelerated Hardener

D818 Accelerator

These products may be used separately, or in combination. The recommended temperature range for each product or combination is as follows:

15 - 24°C / 59 - 75°F D863 Accelerated Hardener with optional D818 Accelerator
24°C / 75°F and higher D803 Fast MS Hardener with D818 Accelerator

D863 Accelerated Hardener is used as a replacement for MS Hardener in the Global Refinish System mix. D818 Accelerator is an additive which accelerates the reaction of the paint component with its hardener. It is added to the mixed ready to spray product (DG / D800 + hardener + thinner) prior to application.

APPLICATION NOTES

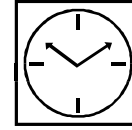
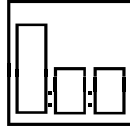
This data sheet should be used in conjunction with individual product data sheets which contain details of application viscosity, number of coats, film build, etc.

ACCELERATED SYSTEMS

MAY BE USED IN

MIXING RATIO

DRYING TIMES ***



DG / D800
D863 Accelerated
Hardener
D818 Accelerator System

DG / D800 2 vols
 D863 1 vol
 Thinner* 1 vol∞
 Add D818†

Dust-free 15 minutes
 Tape free:
 20°C / 68°F 4 hours
 50°C / 122°F 25 minutes**
 60°C / 140°F 15 minutes**

∞ for higher build use ½ vol thinner

† Add ½ U.S. fl. oz. of D818 per ready-to-spray (RTS) U.S. quart. Use D885 instead of D818 to preserve pot life.

Potlife

2 hours @ 20°C / 68°F

DG / D800
D863 Accelerated
Hardener System

DG / D800 2 vols
 D863 1 vol
 Thinner* 1 vol∞

Dust-free 15 - 20 minutes
 Tape free:
 20°C / 68°F 6 hours
 50°C / 122°F 30 minutes**
 60°C / 140°F 20 minutes**

∞ for higher build use ½ vol thinner

* Choose Thinner according to application temperature:

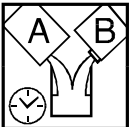
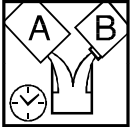
Temperature	Thinner
15 - 24°C / 59 - 75°F	D870
Over 24°C / 75°F	D871

Potlife

3 - 4 hours @ 20°C / 68°F

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

*** Drying times are affected by film build and humidity.

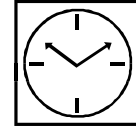
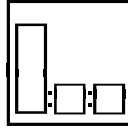


ACCELERATED SYSTEMS

MAY BE USED IN

MIXING RATIO

DRYING TIMES ***



DG / D800
D803 Fast MS Hardener
D818 Accelerator System

DG / D800 3 vols
 D803 1 vol
 Thinner* 1 vol
 Add D818†

Dust-free 20 minutes
 Tape free:
 20°C / 68°F 7 hours
 60°C / 140°F 30 minutes**

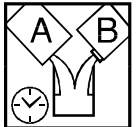
† Add ½ U.S. fl. oz. of D818 per ready-to-spray (RTS) U.S. quart.

* Choose Thinner according to application temperature:

Temperature	Thinner
15 - 24°C / 59 - 75°F	D870
Over 24°C / 75°F	D871

Potlife
DG Colour
D800 Clear

1 - 2 hours @ 20°C / 68°F
 3 hours @ 20°C / 68°F



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

*** Drying times are affected by film build and humidity.

PERFORMANCE AND LIMITATIONS

The use of Accelerated Hardener D863 or Accelerator D818 is not recommended in D880 Clear or with 2-pack primers.

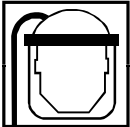
Excessive quantities of Accelerator D818 in Global DG Colours or D800 Clear may reduce the gloss level of the dried paint film.

Users are reminded that the best results are always obtained under good clean spraying and drying conditions.

PROPERTIES

VOC

(D818)	623 gms per litre / 5.2 lbs per US gal.
(D863)	467 gms per litre / 3.9 lbs per US gal.
(D885)	958 gms per litre / 8.0 lbs per US gal.
(D800:D863:D871+D818, 2:1:1+½ oz. / RTS qt.)	611 gms per litre / 5.1 lbs per US gal.



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.

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PPG Industries, Inc.
19699 Progress Drive
Strongsville, OH 44136

PPG Canada, Inc.
2301 Royal Windsor Drive
Mississauga, Ontario L5J 1K5