



GLOBAL REFINISH  
SYSTEM

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# Product Information

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## D820 Plastic Adhesion Promoter

### Product Description

D820 is for use on the variety of plastic substrates found on motor vehicles. D820 provides adhesion for subsequent Global 2K primers and topcoats.

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### Preparation of Substrate



Wash all surfaces to be painted with soap and water. Degrease all surfaces with D846 Degreasing Agent for Plastics (See EU-134 Global Cleaners bulletin for usage instructions).



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



Wet flat with European P600 / U.S. 400 grade paper (use finer grit paper for softer plastics), and clean again with D846 Degreasing Agent for Plastics.

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## APPLICATION GUIDE:

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### Mix Ratio:



D820 is supplied ready-to-spray, no thinning is necessary.

Always shake well before using.



Potlife:

None

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### Additives:



None

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### Spraygun set-up:



Fluid Tip

1.3 - 1.5 mm or equivalent

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### Spray pressure:

HVLP at air cap

7 - 10 PSI

Conventional at spray gun

55 PSI

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### Number of coats:



Apply

1 wet coat

Film build per wet coat

0.4 mils

Dried film build per coat

0.2 mils

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### Flash off at 68°F / 20°C:



Before Topcoat

30 Minutes

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### Drying times:



Dust-free

68°F / 20°C:

2 Minutes



Dry to handle

68°F / 20°C:

15 minutes



Through Dry

68°F / 20°C:

30 Minutes

140°F / 60°C:

15 minutes

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

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## APPLICATION GUIDE

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### Overcoat / Recoat:



Overcoat / Recoat  
@ 68°F / 20°C:

30 Minutes Minimum  
24 Hours Maximum

Grade wet

N/A



Grade dry

N/A

Overcoat with

Any Global 2K primer (Except D831) or Topcoat.

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### Technical Data:

Total dry film build	
Minimum	0.2 mil
Maximum	0.2 mil
Recommended film build per wet coat	0.4 mils
Recommended dried film build per coat	0.2 mils
Theoretical coverage	249 sq.ft. per US gal.
<i>Theoretical coverage in sq.ft./US gal. ready-to-spray (RTS), giving 0.2 mils dry film thickness</i>	
Percent solids by volume RTS	3.1
RTS Volume Ratio:	As is
Applicable Use Category	Adhesion Promoter
VOC Actual (g/L)	835
VOC Actual (lbs/gal)	6.97
VOC Regulatory (less water less exempt) (g/L)	835
VOC Regulatory (less water less exempt) (lbs/gal)	6.97
Density (g/L)	868
Density (lbs/gal)	7.24
Volatiles wt. %	96.2
Water wt. %	0.0
Exempt wt. %	0.0
Water vol. %	0.0
Exempt vol. %	0.0

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### Health and Safety:

**See Material Safety Data Sheet and Labels for additional safety information and handling instructions.**



- Before opening the package, be sure all the warning messages on the label and MSDS are understood.
- 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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