

# Product Information

## **D893 Low VOC Performance Clear**

# **Product Description**

D893 Low VOC Performance Clear is a premium quality high solids clearcoat specifically formulated for today's high production shop. The force dry time of D893 is up to 50% lower than traditional clears. D893 can be polished within minutes after cooling down.

D893 is designed for use over Global BC Colour (see Data Sheet EU02).

# **Preparation of Substrate**



In all cases, wash all surfaces to be painted with soap and water, then apply the appropriate Global cleaner. See GLG-142 Global Cleaners bulletin for selection and usage instructions. Ensure that the substrate is thoroughly cleaned and dried both before and after application work.



Wet sand with European P800-1200 / U.S. 500-600 grade paper or dry sanding with European P600-800 / U.S. 400-500 grade paper.



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

Apply Global BC Colour over original stoved finishes or over recommended Global Primers. See Data Sheet EU02 for Global BC system application details.

Product Information Effective 7/02 EU-112

# **APPLICATION GUIDE**

# **Mixing Ratio:**



D893 3 vols
Hardener 1 vol
D-Thinner 1 vol

**Hardener Selection** 

D884 Air Dry / General Purpose D887 Stoving / Mar Resistance Thinner Selection

D870 Up to 18°C / 65°F D871 18° - 25°C / 65° - 77°F D872 25° - 35°C / 77° - 95°F D873 Over 35°C / 95°F

D8700 May replace up to 25% of recommended thinner levels in very warm conditions.

Note: Smaller areas may require faster thinner.

#### Potlife:



@ 20°C / 68°F

 $1 - 1^{1/2}$  hours

#### **Additives:**



Use **D759 Matting Base** to flatten D894 Clear Use **D814 Plasticiser** to flexibilize D894 Clear See EU-33 for application instructions. See EU-47 for application instructions.

# Spraygun set-up:

Fluid Tip 1.3 – 1.5 mm or equivalent

Spray Viscosity 17 – 18 secs #2 ZAHN (Signature type @ 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 normal coats

Film build per wet coat 2.40 - 3.00 mils Dried film build per coat 1.00 - 1.25 mils

## Flash off at 20°C / 68°F:



Between coats5-10 minutesBefore stoving0-15 minutes

# **Drying times:**











Dust-free  $20^{\circ}C/68^{\circ}F$  20-25 minutes

Dry to handle

20°C / 68°F 4 hours minimum 60°C / 140°F 15 – 20 minutes

*Tape Time*20°C / 68°F
5 – 6 hours

 $60^{\circ}C/140^{\circ}F$  15 – 20 minutes Through Dry

20°C/68°F 8 hours 60°C/140°F 15 – 20 minutes

IR (infrared)

Medium Wave 15 minutes

Short Wave 8 minutes

Note: All force dry times are quoted for metal temperature. Additional time must be allowed during force dry to allow metal to reach recommended temperature.

## **APPLICATION GUIDE**

#### Overcoat / Recoat:



Overcoat/Recoat Time 10 hours @ 20°C / 68°F or after force dry/cool down + 2 hours



 Grade wet
 European P800 – 1200 / U.S. 500 – 600

 Grade dry
 European P600 – 800 / U.S. 400 – 500



Overcoat with Any Global topcoat system

#### **Performance Guidelines:**

Allow the Global BC Colour to flash off for 15 minutes (but no longer than 24 hours) before applying D893 Clear. The timing will depend on thickness and temperature.

Recoating times will be extended at lower temperatures. Global D893 may be sanded with 1200 grit paper or finer and polished when hard, to rectify minor imperfections.

#### Fading Out - D893 Clear

After spot repairing, clean the gun and then spray Global Blending Thinner D853 around the repaired area to lose the edge and blend the repair into the surrounding panel. Spray starting from the outside of the repair, moving to the center.

#### **Technical Data:**

#### Total dry film build

 Minimum
 50μm / 2.0 mils

 Maximum
 75μm / 3.0 mils

Recommended film build per wet coat  $40-75\mu m \ / \ 2.4-3.0 \ mils$  Recommended dried film build per coat  $25-31\mu m \ / \ 1.0-1.25 \ mils$ 

**Theoretical coverage** 15.8 m<sup>2</sup> per litre / 642.2 sq. ft. per US gal.

Note: Theoretical coverage in m≤ /litre and sq.ft./US gal. Ready-to-spray (RTS),

giving 25 µm (1 mils) dry film thickness.

Percent solids by volume RTS 40.04

VOC

(D893) 494 gms per litre / 4.12 lbs. per US gal. (D893:D884:D872, 3:1:1) 498 gms per litre / 4.15 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.

# 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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