



GLOBAL REFINISH
SYSTEM

Product Information

D8150 Performance Clearcoat

Product Description

D8150 Performance Clearcoat is a premium quality high solid clear specifically formulated for today's high production shops. The exceptionally short bake cycle and reduced baking temperatures provide increased productivity along with reduced operating costs.

D8150 provides users with industry leading speed, efficiency, application and gloss. It is designed for use over Global BC (see data sheet EU-02) and Envirobase High Performance (see data sheet EU-143).

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.



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



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

Apply D8150 Performance Clear over Global BC and Envirobase High Performance. See the product data sheet for details on Global BC & Envirobase High Performance system applications.

APPLICATION GUIDE:

Mix Ratio for D8150 Performance Clearcoat:



D8150 : 3 vols
D83xx Hardeners : 1 vol
“D” Series Thinner : 1 vol



Potlife @ 68°F / 20°F: 4 hours

Use the tables to determine the proper hardener and thinner needed for your application.
Hardener selection may be dependent on the size of repair.

Hardener Selection:

D8370: 55° - 70°F (13° - 21°C)
D8371: 70° - 85°F (21° - 29°C)
D8372: 85° - 95°F (29° - 35°C)
D8373: 95°F / 35°C & above

Use only D8371, D8372 and D8373 over Envirobase High Performance.

“D” Series Thinner Selection:

D870 : Up to 65°F / 18°C – 65°F
D871 : 65° – 77°F / 18° – 25°C
D872 : 77° – 95°F / 25° – 35°C
D873 : Over 95°F / 35°C
D8700: May replace up to 25% of recommended thinner levels in very warm conditions

Note: Smaller areas may require faster thinner

Additives:



Use SU4985 Matting Agent to flatten D8150 Clear.

	D8150 : SU4985 : D83xx : D87x							
	Flat =	4	:	8	:	1	:	1
D8150	Eggshell =	4	:	6	:	1	:	1
	Semi-gloss =	4	:	4	:	1	:	1

Use D814 Plasticiser to flexibilize D8150 Clear.

D8150 : D83xx : D87x : D814							
	2	:	1	:	1	:	1

Spraygun set-up:



Fluid Tip 1.3 – 1.5 mm or equivalent
Spray Viscosity 17 – 18 secs #2 ZAHN (Signature type) @ 68°F / 20°C

Spray pressure:

HVLP at air cap 8 – 10 PSI
Conventional at spray gun 45 – 55 PSI

Number of coats:



Apply: 2 coats
Film build per wet coat 3.0 – 3.5 mils
Dried film build per coat 1.2 – 1.4 mils

Flash off at 68°F / 20°C:



Between coats 5 – 10 minutes
Before baking 0 – 5 minutes

Drying times:



Dust-free
68°F / 20°C 20 – 40 minutes
Dry to handle
68°F / 20°C 3 – 4 hours minimum

APPLICATION GUIDE

Drying times continued:



Air Dry

68°F / 20°C

8 hours



Bake

140°F / 60°C (*Metal Temp*)*

When using D8370 - 10 minutes

When using D8371, D8372 and D8373 - 20 minutes

Tape Time

68°F / 20°C

6 – 8 hours

140°F / 60°C (*Metal Temp*)*

After a bake cycle and 1 hour cool down



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.

Overcoat/Recoat:



Overcoat/Recoat Time

16 hours at 68°F / 20°C or after force dry/cool down.

D8150 must be sanded before recoating with primer, color or clear.



Grade wet

U.S. 500 – 600 / European P800 – 1200

Grade dry

U.S. 400 – 500 / European P600 – 800



Overcoat with

Any Global topcoat system



Polishing

After bake cycle and 1 hr cool down. Use a foam pad with a minor cutting compound to remove any minor imperfections.

Performance Guidelines:

Allow the Global BC Color to flash off for 15 minutes (but no longer than 24 hours) before applying D8150 Clear. The timing will depend on thickness and temperature. Recoating times will be extended at lower temperatures. Global D8150 may be sanded with 1200 grit paper or finer and polished when hard, to rectify minor imperfections.

Fading Out - D8150 Clear

After spot repairing, clean the gun and then spray D8753 Blending Solvent 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	2.0 mils
Maximum	3.0 mils
Recommended film build per wet coat	3.0 – 3.5 mils
Recommended dried film build per coat	1.2 – 1.4 mils

Theoretical coverage

657 sq.ft. per US gal.

Theoretical coverage in sq.ft./US gal. Ready-to-spray (RTS), giving 1 mils dry film thickness.

Percent solids by volume RTS

40.93

VOC Regulatory (Less Water, Less Exempts)

D8150:D83xx:D872, 3:1:1	3.92 lbs. per US gal. (470 gms per litre)
D8150:SU4985:D83xx:D872, 4:8:1:1	4.87 lbs. per US gal. (584 gms per litre)
D8150:SU4985:D83xx:D872, 4:6:1:1	4.75 lbs. per US gal. (569 gms per litre)
D8150:SU4985:D83xx:D872, 4:4:1:1	4.57 lbs. per US gal. (548 gms per litre)
D8150:D83xx:D872:D814, 2:1:1:1	4.27 lbs. per US gal. (512 gms per litre)

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.

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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