



GLOBAL REFINISH  
SYSTEM

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# Product Information

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## D8121 Premium LV Clearcoat 3.5 VOC

### Product Description

D8121 Premium LV Clearcoat is a premium quality, high solids clearcoat specifically formulated for today's high production shop. D8121 offers ease of application along with superior gloss and hold out. The exceptionally short bake cycle and reduced baking temperatures provide increased productivity along with reduced operating cost.

D8121 is designed for use over Global BC (see data sheet EU-02) and Envirobase (see data sheet EU-130).

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### 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 D8121 Premium LV Clearcoat Clear over Global BC and Envirobase. See the product data sheet for details on Global BC (EU-02) & Envirobase system (EU-130) applications.

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## APPLICATION GUIDE:

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### Mix Ratio:



**D8121 Premium LV Clearcoat:** 3 vols

**D82XX Hardener:** 1 vol

**“D” Series Thinner:** 1 vol



*Potlife @ 68°F / 20°F:* 4 hours

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### Hardener Selection:

D8210 : 55° – 75°F / 13° – 24°C

D8220 : 75° – 95°F / 24° – 35°C

D8230 : 95°F / 35°C & above

D8245 : 95°F/35°C - above (Overalls)

### “D” Series Thinner Selection:

D870 : Up to 65°F / 18°C

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.*

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### Additives:



Use **D759 Matting base** to *flatten* D8121 Clear.

**Matte Finish**  
D8121 : D82XX : D87X : D759  
3 : 1 : 1 : 3

**Satin Finish**  
D8121 : D82XX : D87X : D759  
3 : 1 : 1 : 1

Use **D814 Plasticiser** to *flexibilize* D8121 Clear.

D8121 : D82XX : D87X : D814  
2 : 1 : 1 : 1

*Note: When these products are used in accordance with the recommendations for combination with D759 or D814, RTS VOC is compliant with the 7.0 lbs./gal. Specialty Coatings category.*

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### Spraygun set-up:



*Fluid Tip*

1.3 – 1.5 mm or equivalent

*Spray Viscosity*

14 – 15 seconds #2 ZAHN (Signature type) @ 68°F / 20°C

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### Spray pressure:

*HVLP at air cap*

8 – 10 PSI

*Conventional at spray gun*

45 – 55 PSI

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### Number of coats:



*Apply:* 2 coats

*Film build per wet coat* 3.3 – 3.9 mils

*Dried film build per coat* 1.2 – 1.4 mils

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### Flash off at 68°F / 20°C:



*Between coats* 5 – 10 minutes

*Before stoving* 0 – 5 minutes

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### Drying times:



*Dust-free*

68°F / 20°C

20 – 40 minutes

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## APPLICATION GUIDE

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### Drying times continued:



*Dry to handle*

68°F / 20°C  
140°F / 60°C

3 – 4 hours minimum  
15 – 20 minutes



*Tape Time*

68°F / 20°C  
140°F / 60°C

6 – 8 hours  
1 hour after cool down



*Air Dry*

68°F / 20°C  
120°F / 50°C  
140°F / 60°C

8 hours  
D8210 – 10 minutes  
D8220 – 10 minutes  
D8230 – 10 minutes

*IR (Infrared)*

Medium Wave  
Short Wave

15 minutes  
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.

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### Overcoat/Recoat:



*Overcoat/Recoat Time*

16 hours at 68°F / 20°C or after force dry/cool down.  
D8121 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.

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### Performance Guidelines:

Allow the Global BC Color to flash off for 15 minutes (but no longer than 24 hours) before applying D8121 Clear. The timing will depend on thickness and temperature.

Recoating times will be extended at lower temperatures. Global D8121 may be sanded with 1200 grit paper or finer and polished when hard, to rectify minor imperfections.

#### Fading Out - D8121 Clear

After spot repairing, clean the gun and then spray **D8753 Blend Ease Universal 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.

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### Technical Data:

#### Total dry film build

Minimum	2.0 mils
Maximum	3.0 mils
Recommended film build per wet coat	3.3 – 3.9 mils
Recommended dried film build per coat	1.2 – 1.4 mils

#### Theoretical coverage

569.74 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

35.52

#### VOC Regulatory (Less Water, Less Exempts)

D8121 : D8220 : D872, 3 : 1 : 1                      3.5 lbs. per US gal.

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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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### Emergency Medical or Spill Control Information (412) 434-4515; In Canada (514) 645-1320

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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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