



DELTRON[®]



Deltron Matt Clearcoat System

PRODUCTS

Matt Clearcoat	D8115
Semi-Gloss Clearcoat	D8117
Hardeners	DH720, DH730
Thinners	DT820, DT830, DT850

NOTE: DT850 is only recommended for interiors, small parts e.g. mirrors and in **very cold** conditions

PRODUCT DESCRIPTION

The Clearcoats D8115 (Matt) and D8117 (Semi-Gloss) are designed for use over Envirobase High Performance and Deltron basecoats.

Deltron Matt Clearcoat System consists of two versatile 2K acrylic urethane clearcoats designed to reproduce a range of low gloss levels for the specialised repairs of vehicles or areas of vehicles originally finished with a low gloss clearcoat over a single or multistage colour basecoat system (e.g. Mercedes full body Matt Finish). To allow for the normal gloss variations - due to colour, model, position of repair on vehicle etc., the actual mix of the two Clearcoats can be varied to match the vehicle to be repaired.

The D8115 / D8117 or mixes of the two may be used over rigid plastics without the need for special additives.

PREPARATION OF SUBSTRATE

When masking a repair, care should be taken to minimise direct contact of masking tape onto the original Matt finish. Where it is necessary to use masking tape directly on the original finish, the tape must be removed before baking to avoid marking of the original which may not recover.

The Deltron D8115 / D8117 Clearcoats must be applied on top of a clean and dust-free basecoat. The light use of a tack cloth is recommended after the basecoat has flashed off.

Care should be taken to avoid dirt inclusion at all stages. Rectification of dirt inclusion in Matt or Low Gloss finishes is not possible after the final coat of clearcoat.

D8115/D8117 MIX RATIOS

To allow for normal variations in the gloss level, depending on colour, model, position of repair on vehicle, it is possible to mix the D8115 and D8117 together in any ratio to match the required gloss for a particular repair. The % ratio's quoted below are the best start point for the 5 gloss level ranges.

Gloss Level	FC01	FC02	FC03	FC04	FC05
	Matt e.g. Lamborghini full body Matt Finish		Low Gloss e.g. Mercedes, Smart, BMW, Fiat full body Matt finishes		Semi Gloss e.g. Older Mercedes Plastic side mouldings
Clearcoat	Percentage Parts by Weight (%)				
D8115	100	70	50	30	0
D8117	0	30	50	70	100

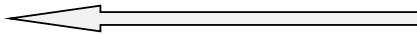
The resulting mix is then activated and thinned as below

Note: Test panels MUST be produced using the intended hardener/thinner/ratio/spraygun combination to check for colour and gloss level against the vehicle to be repaired.
DT850 thinners is recommended to only be used on small areas or components (Mirror covers etc.)

* HARDENER / THINNER / MIX RATIO SELECTION

Smaller areas / Verticals / Higher Gloss
 Below 25°C
 Smaller Spraygun tip size

Larger Areas / Horizontals / Lower Gloss
 Above 25°C
 Larger Spraygun tip size

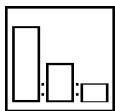


Faster Hardener/Thinner



Slower Hardener/Thinner

MIXING RATIO BY VOLUME



PRODUCT

D8115 / D8117
 Hardener*
 Thinner*

PARTS

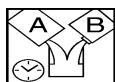
3 VOLUME
 1 VOLUME
 1 VOLUME

WEIGHT

See table, page 4

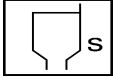
*Choose Hardener/Thinner according to guide below

POTLIFE @ 20°C



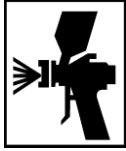
1-2 hours depending on hardener/thinner

SPRAY VISCOSITY @ 20°c



15 Seconds (DIN4)

APPLICATION AND FLASH-OFF



SPRAYGUN SETUP:	1.2mm - 1.4mm
SPRAY PRESSURE:	
HVLP / RP	2 – 3 bar
CONVENTIONAL	30 – 45 PSI / 200-300 KPA

Application

1 Full single coat
Flash off until evenly Matt all over
+
1 Full single coat followed immediately by lighter
(½ coat) cross coat.
Flash off until evenly Matt all over before baking.

Flash off between spray coats 15 - 30 minutes or until fully and evenly matt over the whole repair area.*

Flash off before bake or IR Dry 15 - 30 minutes or until fully and evenly matt over the whole repair area.*

***Note:** Allowing the Clearcoat Mix to flash off fully between coats and before bake is important to achieve an even appearance and gloss level over the whole repair area. The actual flash off times will depend on the hardener/ thinner combination to achieve the correct gloss effect and could vary between 15 – 45 minutes.

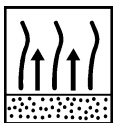
DRYING TIMES

Through dry at 60°C*

30 minutes with DH720,
40 minutes with DH730

Through dry at IR
(medium wave)

8 - 15 minutes (depending upon colour)



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

Total dry film build:

45 – 55 µm

REPAIR AND RECOATING

<i>Sanding:</i>	Essential before recoating to ensure good adhesion
- <i>grade wet</i>	<i>P800</i>
- <i>grade dry</i>	<i>P400-500</i>
 <i>Overcoat / Recoat time:</i>	
- <i>Force dry at 60°C, or IR</i>	After cooling
- <i>Air drying at 20°C</i>	12 hours
 <i>Overcoat with:</i>	Deltron Primers
	Envirobase High Performance
	Deltron Topcoats

WEIGHT MIX TABLES FOR D8115/D8117

GUIDELINES FOR WEIGHT MIXING

Where a specific volume of clearcoat mix is required, this may be best achieved by weight mixing, using the guidelines below. The weights are cumulative - please do NOT tare the balance between additions.

Target Volume of RFU Paint required (Litres) @ 3:1:1	Weight Clearcoat D8115/D8117 or Blends	Weight HS Hardener DH7XX	Weight Thinner DT8XX
DO NOT TARE THE SCALE BETWEEN ADDITIONS			
0.10 L	63g	83g	100g
0.20 L	126g	166g	201g
0.25 L	157g	207g	250g
0.33 L	207g	273g	330g
0.50 L	314g	414g	501g
0.75 L	471g	621g	751g
1.00 L	629g	829g	1002g
1.50 L	943g	1243g	1503g
2.00 L	1257g	1657g	2004g
2.50 L	1572g	2072g	2506g

PERFORMANCE AND LIMITATIONS

The Gloss levels achieved with this clear may vary depending upon film thickness and application. Low film thickness and dry application will give a **Lower** Gloss. High film thickness and wet application will give a higher gloss level.

To remove minor dirt inclusions in the final finish, the repair should be fully dried, de-nibbed after cooling and one further coat of the Clearcoat Mix applied. Care should be taken to avoid too high clearcoat film thicknesses because the final colour could be affected. In this situation, the repair will require sanding and recoating with Basecoat and Clearcoat.

Dirt removal from the final Matt Finish is not possible.

GENERAL CARE AND MAINTENANCE OF MATT FINISHES

The following guidance on Care and Cleaning of matt finish vehicles is aimed at the car owner, and applies to both the OE and the repair finish.

Particular care must be taken with Matt Finishes to maintain an original even Matt effect.

Guidance for the car owner on maintaining the even matt effect over time

Matt/Gloss finishes can be relatively easily marked with general handling and day to day use (door/bonnet/boot opening, shoe scuffing on entry or exit of vehicle etc.). Care should be taken with these operations because marking or changing of the Matt effect could result.

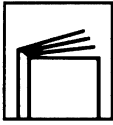
Care should be taken to avoid spillage of fuel onto the Matt/Low Gloss finishes. Spilt fuel should be removed as soon as possible using the washing guidelines below, to avoid permanent damage or altering of the Matt/Low Gloss effect.

1. In order to keep the Matt surface effect, the use of paint cleaner, abrasives or polishes and wax polishes must be avoided. The vehicle must not be polished.
2. Polishing will lead to a higher, uneven gloss effect.
3. Cleaning/Polishing with unsuitable materials could alter the Matt effect (generally increased gloss).
4. Automated car washing machines should be avoided. The preferred car washing method is by hand with a soft sponge, neutral soap and lots of water. Too frequent car washing could over a period of time lead to increased and inconsistent gloss levels across a car panel. Washing under direct sunlight should be avoided.
5. Insects and bird residues should be removed immediately. The residues should be soaked in water to soften and/or removed carefully with a high pressure cleaning equipment. In the case of strongly adhered residues, a spray on insect remover should be used prior to washing.
6. Whenever using any type of cleaning fluids with soft sponges or cloths, it is essential not to apply pressure or rub the Matt finish. A gentle wipe/spray on, wipe off technique

EQUIPMENT CLEANING

After use, clean all equipment thoroughly with cleaning solvent or thinner.

HEALTH AND SAFETY



Please refer to Material Safety Data Sheets for full Health and Safety details and product can labels.

Deltron Hardeners and activated Clearcoats contain isocyanate and therefore particular safety precautions must be taken.

Goggles must be worn when mixing and using to prevent accidental splashing into the eye. If contact occurs with eyes give prolonged irrigation with water and get medical attention immediately.

Good ventilation and extraction must be provided in the working environment.

Wear suitable protective equipment to prevent skin contact with this material.

When spraying this product the operator (and persons in vicinity) must wear suitable air-fed breathing apparatus.

Do not smoke whilst using this material.

This product is for professional use only.

The information given in this sheet is for guidance only. Any person using the product without first making further inquiries as to the suitability of the product for the intended purpose does so at his own risk and we can accept no liability for the performance of the product or for any loss or damage (other than death or personal injury resulting from our negligence) arising out of such use. The information contained in this sheet is liable to modification from time to time in the light of experience and our policy of continuous product development.

Drying times quoted are average times at 20°C/68°F. Film thickness, humidity and shop temperature can all affect drying times.



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