



GLOBAL REFINISH
SYSTEM

Product Information

D8102 Pre-Flexed Matte Clear

Product Description

Global Refinish System D8102 Pre-Flexed Matte Clear is a premium, pre-flexed and pre-flattened clear in one package. It can be blended with a variety of Global clears to achieve the gloss level desired. D8102 is used in some low gloss clear formulas to match OEM gloss requirements. D8102 will allow the blended clear to fit the “Specialty Coating” category in VOC regulated areas under both anti-glare safety and elastomeric coating designations.

D8102 is designed to be used over Global BC Color (see Data Sheet EU-02).

Preparation of Substrate



Wash all surfaces to be painted with soap and water, then apply the appropriate Global cleaner. See EU-134 Global Cleaners for selection and usage instructions. Ensure that the substrate is thoroughly cleaned and dried both before and after application work.



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



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

Apply Global BC Color or Envirobase Color over original baked finishes or over recommended Global Primers. See Data Sheet EU-02 for Global Basecoat Color or EU-130 Envirobase Color for application details.

APPLICATION GUIDE

Mixing Ratio for a flat finish:



D8102	6 vols
Hardener D884, D887 or D82xx	1 vol
Thinner D870/D871/D872*	1 vol

Mixing Ratio for a matte or satin finish:

You can increase the gloss of D8102 to Matte or Satin with D890, D893, D894, D8101, D8121 or D8150.

Use the table below, then use the following mix ratio.



D8102 and D Clear	4 vols
Hardener D884, D887 or D82xx	1 vol
Thinner D870/D871/D872*	1 vol

* For exceptional conditions of temperature and humidity (> 35°C / 95°F and >70% RH) the use of D873 Very Slow Thinner is recommended.

Blending by Weight	Hardener	Gloss	Grams D8102	Grams D Clear	RTS VOC (lbs/gal)	RTS VOC (gms/ltr)
D890	D884	Matte	97	3	4.95	593
	D887	Matte	95	5	4.92	590
D890	D884	Satin	93	7	4.89	586
	D887	Satin	90	10	4.85	581
D893	D884	Matte	95	5	4.95	593
	D887	Matte	90	10	4.91	588
D893	D884	Satin	85	15	4.87	584
	D887	Satin	80	20	4.83	579
D894	D884	Matte	95	5	4.94	592
	D887	Matte	95	5	4.94	592
D894	D884	Satin	85	15	4.85	581
	D887	Satin	80	20	4.81	576
D8101	D884	Matte	95	5	4.93	591
	D887	Matte	90	10	4.88	585
D8101	D884	Satin	85	15	4.83	579
	D887	Satin	80	20	4.78	573
D8121	D82xx	Matte	95	5	4.94	592
	D82xx	Satin	85	15	4.82	578
D8150	D82xx	Matte	95	5	4.94	592
	D82xx	Satin	85	15	4.83	579
Blending by Volume	Hardener	Gloss	Parts by Volume D8102	Parts by Volume D Clear	RTS VOC (lbs/gal)	RTS VOC (gms/ltr)
D890	D884	Matte	10	1/3	4.95	593
	D887	Matte	10	1/2	4.92	590
D890	D884	Satin	10	3/4	4.89	586
	D887	Satin	9 1/2	1	4.85	581
D893	D884	Matte	10	1/2	4.95	593
	D887	Matte	9 1/2	1	4.91	588
D893	D884	Satin	9	1 1/2	4.87	584
	D887	Satin	8 1/2	2	4.83	579
D894	D884	Matte	10	1/2	4.94	592
	D887	Matte	10	1/2	4.94	592
D894	D884	Satin	9	1/2	4.85	581
	D887	Satin	8 1/2	2	4.81	576
D8101	D884	Matte	10	1/2	4.93	591
	D887	Matte	9 1/2	1	4.88	585
D8101	D884	Satin	9	1 1/2	4.83	579
	D887	Satin	8 1/2	2	4.78	573
D8121	D82xx	Matte	10	1/2	4.94	592
	D82xx	Satin	9	1 1/2	4.82	578
D8150	D82xx	Matte	10	1/2	4.94	592
	D82xx	Satin	9	1 1/2	4.83	579

APPLICATION GUIDE

Pot life:



2-3 hours @ 20°C / 68°F

Additives:



D885 for enhanced cure. Add 1/2 oz. per (RTS) U.S. qt.

D886 to extend flow in higher temperatures. Add 1/2 oz. per (RTS) U.S. qt.

(Where recommended, the addition of additives will increase the VOC .04 - .05 lbs/gal.)

Spraygun set-up:



Fluid Tip

1.3 or equivalent

Spray pressure:

HVLP at air cap

10 PSI / 0.7 bar

Conventional at spray gun

45 – 55 PSI / 3 – 4 bar

Number of coats:



Apply

2 wet coats

Flash off at 68°F / 20°C:



Between Coats

5 – 10 minutes

Before Baking

0 – 15 minutes

Drying times:



Dust-free

68°F / 20°C

20 – 30 minutes*



Dry to Handle

68°F / 20°C

4 hours*



Tape Time

68°F / 20°C

8 hours*

140°F / 60°C

10 – 15 minutes**



IR medium

15 minutes

* *Air dry times using D884.*

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

Overcoat/Recoat:



Overcoat/Recoat Time

Recoat after force dry/cool down or 1 hour at 20°C (68°F)

May be sanded after force dry/cool down +2 hours or 10 hour at 20°C (68°F)



Grade Wet

D8102 must be sanded after 72 hours before recoating to ensure good adhesion.

U.S. 500 – 600 / European P800 – P1200



Grade Dry

U.S. 400 – 500 / European P600 – P800

Overcoat or recoat with any Global or Topcoat

Performance Guidelines:

Fading out D8102

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.

Allow the Global BC Color to flash off for 15 minutes (but no longer than 24 hours) before applying D8102 Clear. The timing will depend on thickness and temperature.

Recoating times will be extended at lower temperatures. Global D8102 may be sanded with U.S. 1200 grit paper or finer and polished when hard, to rectify minor imperfections.

Technical Data:

Total dry film build

Minimum	2.0 mils / 50 μ
Maximum	3.0 mils / 75 μ

Theoretical coverage

417 sq.ft. per U.S. gal. 10.2 m²

Percent solids by volume RTS

37.9%

VOC less exempt solvents

(D8102)	5.35 lbs. per U.S. gal. / 641 gms per litre
(D8102:D884:D872) (6:1:1)	5.08 lbs. per U.S. gal. / 609 gms per litre
D8102 blended w/ clear, thinner & hardener RTS (4:1:1)	See page 2 charts

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.
 - 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

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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