Product Information

D822 Corrosion Resistant Primer

**Product Description**
D822 Corrosion Resistant Primer is a two-pack primer for use under Global topcoat colours. It can be used either as a primer-surfacer or as a non-sanding primer sealer. It must be activated with D823 Corrosion Resistant Primer Catalyst.

**Preparation of Substrate**
In all cases, wash with soap and water, then use the appropriate Global cleaner. See GLG142 Global Cleaners bulletin for selection and usage instructions. Ensure that the substrate is thoroughly cleaned and dried both before and after preparation work.

- **Original Paintwork and Electrodeposition Primer** must be sanded using European P280 / U.S. 240 grit discs (dry) or European P360 / U.S. 320 grade paper (wet). Exposed bare metal should be spot-primed with a suitable bare metal primer (see below).

- **Bare Steel and Aluminum** must be clean, rust-free and abraded before application (minimum 2 coats of D822). For maximum corrosion resistance apply one coat of D831 Chromate-free Wash Primer.

- **Galvanized Steel** must be thoroughly abraded and primed with one coat of D831 Chromate-free Wash Primer.

- **Polyester Body Fillers** should be dry sanded using European P400 / U.S. 360 grit paper.

- **Fibre Glass and SMC** should be dry sanded using European P280 / U.S. 240 grit paper. A minimum of 2 coats of D822 is required over these substrate types.

Ensure that the substrate is thoroughly cleaned and dried after preparation work.
# APPLICATION GUIDE

## Mixing Ratio

**Primer-Surfacer**

- **D822**: 3 vols
- **D823**: 1 vol

*If VOC is not a concern, add up to ½ vol of the appropriate temperature range Global thinner to improve flow properties and potlife.

**Primer-Sealer**

- **D822**: 3 vols
- **D823**: 1 vol
- **D-Thinner**: ½ vol

### D-Thinner Selection:

Appropriate Temperature Range:

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

*Note: D8700 Retarder may be mixed with thinners in temperatures over 35°C / 95°F. The retarder can be mixed up to 25% with the appropriate thinner. Do not use alone as a reducer.*

## Potlife

- **@ 20°C / 68°F**: 1 - 1½ hours

## Additives

- **D822 can be tinted using**
  - **DG toners only!**
  - When mixed it can be sprayed as a surfacer or sealer.
  - **D822**: 3 vols
  - **D823**: 1 vol
  - **D-Thinner**: 1 vol

## Spraygun set-up

**Fluid Tip**: 1.4 – 1.6 mm or equivalent

**Spray Viscosity**: 22 seconds ZAHN #2 @ 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

- **Primer Surfacer**: 2 – 4 wet coats
- **Primer Sealer**: 1 – 2 wet coats
- **Primer Surfacer Sealer or Tinted Sealer**
  - **Primer Surfacer**: 3.5 – 4.0 mils
  - **Sealer or Tinted Sealer**: 3.0 – 3.5 mils
  - **Recommended dried film build per coat**: 2.0 mils

## Flash off at 20°C / 68°F

- **Between coats**: 5 – 10 minutes
- **Before stoving**: 10 minutes
- **Before Topcoat**: 20 minutes minimum (1 coat)
  - 45 minutes minimum (2 coats)
  - 8 hours maximum, before sanding is required
**APPLICATION GUIDE**

**Drying times**

- **Dust-free**
  - 20°C / 68°F: 10 minutes

- **Dry to sand**
  - 20°C / 68°F: 1 – 2 hours
  - 60°C / 140°F: 20 – 30 minutes

- **Tape Time**
  - 20°C / 68°F: 1 – 2 hours
  - 60°C / 140°F: 20 – 30 minutes

- **IR (Infrared)**
  - Medium wave: 20 minutes
  - Short wave: 10 minutes (includes 3 minute ramp-up time)

**Overcoat / Recoat**

- **Topcoat over Primer Sealer**
  - 20 minutes minimum (1 coat)
  - 45 minutes minimum (2 coats)
  - 8 hours maximum, before sanding is required

- **Overcoat with**
  - Any Global topcoat

**Sanding**

- If rework is necessary or maximum flash time is exceeded,
  - **Grade wet**
    - European P600 / U.S. 400
    - followed by European P1200 / U.S. 600
  - **Grade dry**
    - European P360 / U.S. 320
    - followed by European P1000 / U.S. 500

**Performance Guidelines**

The use of HVLP spray equipment can give an increase in transfer efficiency of about 10% depending on the make and model of equipment used.

If D822 is used for spot priming, the panel to be primed must be thoroughly sanded beyond the edge of the spot repair.

**Technical Data**

- **Total Dry Film Build:**
  - Minimum after sanding
  - Maximum after sanding
  - Film Build Per wet coat
  - Dried film build per coat

- **Primer Surfacer**
  - 50 µm / 2.0 mils
  - 150 µm / 6.0 mils
  - 87 – 100 µm / 3.5 – 4.0 mils
  - 50 µm / 2.0 mils

- **Sealer or Tinted Sealer**
  - 37 µm / 1.5 mils
  - 75 µm / 3.0 mils
  - 75 – 87 µm / 3.0 – 3.5 mils
  - 37 µm / 1.5 mils

**Theoretical Coverage:**

- 5.3 m² per l / 217 sq.ft. per US gal.
- 4.3 m² per l / 174 sq.ft. per US gal.

- **% Solids By Volume RTS**
  - 54.2
  - 48.1

**VOC**

- (D822) 395 gms per litre / 3.3 lbs per US gal.
- (D822:D823, 3:1) 360 gms per litre / 3.0 lbs per US gal. (less exempts)
- (D822:D823:D872, 3:1:½) 419 gms per litre / 3.5 lbs per US gal. (less exempts)
- (D822:D823:DG:D872, 3:1:1:1) 467 gms per litre / 3.9 lbs per US gal. (less exempts)
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.

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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# Global At A GLANCE

## D822

### Mix:

<table>
<thead>
<tr>
<th>Primer-Surfacer</th>
<th><em>D822</em> 3 vols</th>
<th><em>D823</em> 1 vol</th>
</tr>
</thead>
</table>

*If VOC is not a concern, add up to ½ vol of the appropriate temperature range Global thinner to improve flow properties and potlife.*

<table>
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<tr>
<th>Primer-Sealer</th>
<th><em>D822</em> 3 vols</th>
<th><em>D823</em> 1 vol</th>
<th>D-Thinner ½ vol</th>
</tr>
</thead>
</table>

### Additives:

- D822 can be tinted using DG toners only!
- When mixed it can be sprayed as a surfacer or sealer.

<table>
<thead>
<tr>
<th>3 vols of D822</th>
<th>1 vol of D823</th>
<th>1 vol of appropriate D-Thinner</th>
<th>1 vol of DG Toner</th>
</tr>
</thead>
</table>

### Pot life:

- @ 20°C / 68°F: 1 - ½ hours

### Air Pressure:

- HVLP at the cap: 0.7 bar / 10 PSI
- Conventional at the gun: 3 - 4 bar / 45 - 55 PSI
- Fluid tip: 1.4 - 1.6 mm or equivalent

### Application:

- **Apply as Primer Surfacer:**
  - 2 – 4 wet coats
  - 5 – 10 minutes
- **Apply as Primer Sealer:**
  - 1 – 2 wet coats
  - 1 – 2 hours
  - If rework is necessary, 20 – 30 minutes**
- **Film Build Per wet coat:**
  - 3.5 – 4.0 mils
- **Dried Film Build Per coat:**
  - 2.0 mils
- **Sealer or Tinted Sealer**
  - 3.0 – 3.5 mils
  - 1.5 mils

### Dry Times:

- **Before stoving:**
  - Dust-free: 10 minutes
  - 20°C / 68°F: 10 minutes
  - Dry to sand: If rework is necessary, 1 – 2 hours
  - 20°C / 68°F: 1 – 2 hours
  - 60°C / 140°F: 20 – 30 minutes**
- **Tape Time:**
  - 20°C / 68°F: 1 – 2 hours
  - 60°C / 140°F: 20 – 30 minutes**
- **IR (Infrared):**
  - Medium wave: 20 minutes
  - Short wave: 10 minutes (includes 3 minute ramp time)
- **Overcoat Primer Sealer:**
  - 20°C / 68°F: 20 minutes minimum (1 coat)
  - 45 minutes minimum (2 coats)
  - 8 hours maximum before sanding is required

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

**Warning:** Do not use sealer applications over polyester body filler substrates.
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