Product Description

Global Refinish System DGLV is a high-performance two-pack acrylic urethane topcoat designed for the direct gloss repair and respray of cars and commercial vehicles, where local regulations require a maximum VOC of 3.5 lb./gal.

The performance of Global Refinish System DGLV in a recommended Global repair system meets or exceeds motor manufacturer warranty requirements and the Global Refinish System carries many OEM approvals.

Preparation of Substrate:

Apply over original baked finishes or over recommended Global primers.

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.

Apply DGLV Color after (WET) sanding with U.S. 400 – 500 / European P600 – 800 grade paper or dry sanding with U.S. 360 – 400 / European P400 – 600 grade paper.

Wash off residues and dry thoroughly before recleaning with appropriate Global substrate cleaner. The use of a tack rag is recommended.
**APPLICATION GUIDE:**

**Mix Ratio:**

- DGLV 2 vols
- D884 Hardener 1 vol
- Add Thinner 5 – 10% by volume
- Add D885/D886 1 oz. per ready-to-spray quart

Potlife @ 68°F / 20°C 1 - 2 hours @ 68°F / 20°C temperature:

Use the below chart to choose the appropriate thinner and additive according to the application.

<table>
<thead>
<tr>
<th>Temperature</th>
<th>Thinner</th>
<th>Dry Method</th>
<th>Additive</th>
</tr>
</thead>
<tbody>
<tr>
<td>Up to 65°F / 18°C</td>
<td>D8764</td>
<td>Air Dry</td>
<td>1 oz. D885</td>
</tr>
<tr>
<td>65° – 77°F / 18° – 25°C</td>
<td>D8774</td>
<td>Air Dry</td>
<td>1 oz. D885</td>
</tr>
<tr>
<td>Over 95°F / 25°C</td>
<td>D8767</td>
<td>Air Dry/Baking</td>
<td>½ oz. D885 + ½ oz. D886</td>
</tr>
</tbody>
</table>

**Additives:**

- **D885 Accelerator and/or D886 Extender** are required to properly mix DGLV.
- Use the ratios found in the mixing section.

- **SLV814 Universal Flexibilizer:** Mix at 2 : 2 : 1 : 1 (DG : Hardener : D Thinner : SLV814)
- See EU47 for further information on D814 Plasticiser.

**Spraygun set-up:**

- Fluid Tip 1.3 – 1.5 mm or equivalent
- Spray Viscosity 20 – 30 secs ZAHN 2 @ 20°C / 68°F

**Spray pressure:**

- HVLP 10 PSI / 0.7 bar *(at air cap)*
- Conventional 45 – 55 PSI / 3 – 4 bar *(at spray gun)*

**Number of coats:**

- Apply 2 – 3 coats or until hiding
- Film build per wet coat 2.0 mils
- Dried film build per coat 1.0 mils

**Flash off at 68°F / 20°C:**

- Between coats 3 – 7 minutes
- Before stoving 0 – 10 minutes

**Drying times:**

- Dust-free 68°F / 20°C 50 – 70 minutes
- Dry to handle 68°F / 20°C 6 – 8 hours
- Tape Time 68°F / 20°C 6 – 8 hours
- 140°F / 60°C 3 hours
- Through dry 68°F / 20°C 24 hours
- 140°F / 60°C 30 minutes
- IR (Infrared) Medium Wave 10 – 15 minutes, depending on color
- Short Wave 8 minutes, depending on color.

**Note:** Force dry times are for quoted metal temperatures. Additional time should be allowed in the force dry schedule to allow metal to reach recommended temperature.
**APPLICATION GUIDE**

**Overcoat/Recoat:**

- **Recoat**
  - After surface has cooled if baked, or after 8 hours minimum @ 68°F /20°C
  - *For best adhesion, sanding is essential before recoating*

- **Grade wet**
  - U.S. 500 / European P800

- **Grade dry**
  - U.S. 360 / European P400

- **Overcoat with**
  - With any Global primers, topcoats or clearcoats.
  - Clearcoats can be applied after a minimum of 2 hours dry.

**Performance Guidelines:**

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

**Fading Out:**

After spot repairing, mix equal parts of RTS CLV and D853, Global Refinish System Fade-Out Thinner. Spray this mixture 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.

**Product Compatibility**

- **DGLV may be applied over:**
  - Cured Air Dry Finishes
  - OEM Basecoat/Clearcoat *(must be sanded)*
  - OEM Enamels *(must be sanded)*
  - OEM & Refinish Lacquers *(must be sanded and sealed)*
  - D820 Plastic Adhesion Promoter *(not in Rule 1151 area)*
  - D822 Corrosion Resistant Primer *(not in Rule 1151 area)*
  - D831 Chromate Free Wash Primer *(must be sealed or primed afterwards)*
  - D891 Sealer *(not in Rule 1151 area)*
  - D8080 UV Cured Primer Surfacer
  - SX/SX1050 Plastic Adhesion Promoter *(Specialty Performance Products)*
  - SX1056 Flexible 2K Sealer
  - SX1057 Flexible 2K Surfacer
  - SX1080 2K Rollable Surfacer LV
  - SX4903 Advanced Plastic Bond *(See OC-1)*

**Technical Data:**

**Total dry film build:**
- Minimum: 2.0 mils / 50µm
- Maximum: 4 mils / 100µm

**Theoretical coverage**: 417 sq.ft. per US gal. / 10.3 m² per liter

*Theoretical coverage in sq.ft./US gal. (m²/litre) Ready-to-spray (RTS), giving 2 mils (50µm) dry film thickness.*

**Percent solids by volume RTS**: 52%

<table>
<thead>
<tr>
<th></th>
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<th></th>
<th></th>
</tr>
</thead>
<tbody>
<tr>
<td>Package Color (as is)</td>
<td>Single-Stage Coating</td>
<td>2 : 1 + 10% + 1 oz/qt</td>
<td>2 : 2 : 1 : 1 + 1 oz/qt</td>
</tr>
<tr>
<td>Applicable Use Category</td>
<td>DGLV</td>
<td>DGLV : D884 + D87XX + D885/D886</td>
<td>DGLV : D884 : D87XX : D886/SLV814 : D885/D886</td>
</tr>
<tr>
<td>VOC Actual (g/L)</td>
<td>452 - 515</td>
<td>330 - 371</td>
<td>221 - 260</td>
</tr>
<tr>
<td>VOC Actual (lbs/gal)</td>
<td>3.77 - 4.30</td>
<td>2.76 - 3.10</td>
<td>1.85 - 2.18</td>
</tr>
<tr>
<td>VOC Regulatory (less water less exempt) (g/L)</td>
<td>452 - 515</td>
<td>364 - 419</td>
<td>304 - 354</td>
</tr>
<tr>
<td>VOC Regulatory (less water less exempt) (lbs/gal)</td>
<td>3.77 - 4.30</td>
<td>3.04 - 3.50</td>
<td>2.54 - 2.96</td>
</tr>
<tr>
<td>Density (g/L)</td>
<td>1005 - 1353</td>
<td>1045 - 1255</td>
<td>1098 - 1213</td>
</tr>
<tr>
<td>Density (lbs/gal)</td>
<td>8.39 - 11.29</td>
<td>8.72 - 10.47</td>
<td>9.16 - 10.12</td>
</tr>
<tr>
<td>Volatiles wt. %</td>
<td>33.4 - 49.3</td>
<td>35.1 - 44.7</td>
<td>46.4 - 52.5</td>
</tr>
<tr>
<td>Water wt. %</td>
<td>0.0</td>
<td>0.0</td>
<td>0.0</td>
</tr>
<tr>
<td>Exempt wt. %</td>
<td>0.0</td>
<td>8.7 - 10.4</td>
<td>28.1 - 31.1</td>
</tr>
<tr>
<td>Water vol. %</td>
<td>0.0</td>
<td>0.0</td>
<td>0.0</td>
</tr>
<tr>
<td>Exempt vol. %</td>
<td>0.0</td>
<td>9.0</td>
<td>27.1</td>
</tr>
</tbody>
</table>
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 (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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