

TECHNICAL DATASHEET



RLD404V

April 2026

D8178 Rapid Low Energy Clearcoat

PRODUCTS

D8178	<u>Rapid Low Energy Clearcoat</u>
D8312	<u>Fast UHS Hardener for D8178 Clearcoat</u>
D8313	<u>Medium UHS Hardener for D8178 Clearcoat</u>
D8314	<u>Slow UHS Hardener for D8178 Clearcoat</u>
D8760	<u>Accelerator Thinner for D8178 – Bake</u>
D8761	<u>Accelerator Thinner for D8178 – Fast</u>
D8762	<u>Accelerator Thinner for D8178 – Medium</u>
D8763	<u>Accelerator Thinner for D8178 – Slow</u>

PRODUCT DESCRIPTION

D8178 Rapid Low Energy Clearcoat delivers industry-leading drying speed with flexible options; 5 minutes at 50°C, 10 minutes at 40°C, or 45 minutes air dry at 20°C while providing superior gloss, excellent flow, and effortless application. D8178 is designed for efficiency and sustainability, minimizing material consumption and energy use leading a low CO2 footprint. D8178 empowers workshops to accelerate turnaround times, reduce costs, and achieve flawless, durable finishes with ease, all while supporting environmental responsibility.”

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THESE PRODUCTS ARE FOR PROFESSIONAL USE ONLY



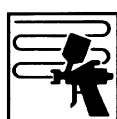
DELTRON®

PREPARATION OF SUBSTRATE



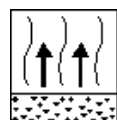
Apply on top of a clean and dust free ENVIROBASE® High Performance (the use of a tack rag is recommended to remove dust from the basecoat film).

APPLICATION AND FLASH OFF



One visit Application

Apply 1 light/medium closed coat followed by 1 full coat.
The first coat should be applied as a light closed coat. Second coat is applied as a full coat.



Flash off between coats

No Flash off
If 1-2 single panels – 30 to 60 sec flash off

RFU MIXED PRODUCT DETAILS

Pot-life at 20°C

30 minutes sprayable time at 20°C.

Viscosity

14-16 seconds DIN4 cup at 20°C.

SPRAYGUN SET UP

Temperature	Nozzle	Note
15°C - 30°C:	1.2mm	If using 1.3mm, adjust needle set-up for less material delivery.
From 25°C to 30°C:		1.3mm is optional.
Above 30°C:	1.3mm	In very high temperatures and for large repairs, use 1.4mm.

Inlet Pressure: 2.0 - 2.2 Bar

Follow Spray gun manufacture recommendations.

FILM THICKNESS

Dry Film Thickness: 50-60 µm (Higher DFT will extend drying times)

DRYING TIME

Drying Time:	20°C	40°C	50°C
Dust free:	15-20 minutes	-----	-----
Dry to handle:	30 minutes	10 minutes	5 minutes
Polishing:	45 minutes	After cooling	After cooling

Mixing Ratio By Volume:

D8178	2 parts
Hardener	1 parts
Thinner	0.5 parts

Choose Thinner according to application temperature*.

As with all ultra-high solid products, cold ready for use paint temperatures can lead to more difficult application and overspray absorption. It is strongly recommended that ready for use product is applied at a temperature greater than 15°C.

MIXING BY WEIGHT:

The weights are cumulative - Do **NOT** tare the balance between additions.

Total Volume Required	D8178	Hardener	Thinner
100 ml	56.6g	86.9g	99.3g
200 ml	113.1g	173.7g	198.6g
300 ml	169.7g	260.6g	297.9g
400 ml	226.3g	347.4g	397.1g
500 ml	282.9g	434.3g	496.4g
600 ml	339.4g	521.1g	595.7g
700 ml	396.0g	608.0g	695.0g
800 ml	452.6g	694.9g	794.3g
900 ml	509.1g	781.7g	893.6g
1000 ml	565.7g	868.6g	992.9g

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HARDENER & THINNER SELECTION

Hardener and Thinner selection			
	Temperature	Hardener	Thinner
Air-Dry	15-20°C	D8312 Fast	D8761 Fast
	20-30°C	D8313 Medium	D8762 Medium
	Above 30°C	D8314Slow	D8763 Slow
Bake	-----	D8313 Medium	D8760 Bake

OVERCOATING/RECOATING

Overcoat / Recoat time - After cooling, or after Air-drying.

It is essential to sand before recoating to ensure good adhesion.
Sand with P800 (wet) or P400-800 (Dry).

Overcoat with - Envirobase HP

POLISHING

After the indicated baking time it is ready to polish after cooling down.

When air dry, ready to polish after 45 min @ 20°C.

If left longer, polishing could result more difficult.

FADE - OUT REPAIR PROCEDURE

- Prepare the fade out area with a 3000 grade soft pad on a DA sander.
- Apply D8178 according to the information above.
- Take care to minimise the clearcoat edge in the fade-out area.
- Immediately melt overspray edge using PPG Spot Blender. (Aerosol or Can version)
- It is not recommended to fade out on ½ panels such as doors. It is more efficient to Clearcoat the whole panel.
- After a thorough bake or if necessary application of an IR lamp for 5 mins, sand the edge briefly with 3000 grade soft pad on a DA sander.
- This step is not essential but makes the polishing much easier.
- Polish with normal process system.

PAINTING VERY SOFT PLASTIC/FOAM SUBSTRATES

Majority of plastics used on cars are considered **Rigid**. These plastics may have some flexibility when painted off the car, but are rigid once mounted.

D8178 Rapid Low Energy Clearcoat only require the addition of the Plasticiser Additive (See Flexible chart below) when painting very flexible plastics, mostly found on older vehicles, e.g. foam type.

Cumulative Mixing by Weight

Do not tare the balance between additions

Substrate	Appearance	D8178	D843	D844	D814	D819	Hardener	Thinner
RIGID	Gloss	567,4 g	-	-	-	-	870,6 g	993,3 g
	Fine Textured	259,0 g	572,7 g	-	-	-	771,1 g	965,3 g
	Coarse Textured	331,0 g	-	597,7 g	-	-	821,7 g	974,4 g
FLEXIBLE	Gloss	438,1 g	-	-	574,4 g	-	886,5 g	987,5 g
	Fine Textured	194,7 g	477,6 g	-	-	579,9 g	787,9 g	973,2 g
	Coarse Textured	261,3 g	-	471,8 g	-	609,1 g	841,8 g	984,9 g

EQUIPMENT CLEANING

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

HEALTH AND SAFETY



These products are for professional use only, and are not to be used for purposes other than those specified. The information on this TDS is based on present scientific and technical knowledge, and it is the responsibility of the user to take all necessary steps in order to ensure the suitability of the product for the intended purpose. For Health and Safety information please refer to the material Safety Data Sheet, also available at: www.ppgrefinish.com

VOC INFORMATION

The EU limit value for this product (product category: IIB.d) in ready to use form is max. 420g/litre of VOC. The VOC content of this product in ready to use form is max. 420g/litre. Depending on the chosen mode of use, the actual ready to use VOC of this product may be lower than that specified by the EU Directive code.

For Further Information Please Contact

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