

## DELTA® Basecoat Blending Converter

# DHSX591

DHSX591 is a basecoat blending converter designed specifically for use in Delta® DFHS and DUHS high solids polyurethane fleet finishes. The addition of DHSX591 to any of these single-stage color systems creates a high solids basecoat product that is easy to blend into the OEM finish. Delta® color systems using DHSX591 basecoat blending converter exhibit minimal orange peel and excellent metallic control.

Features	Advantages	Benefits
<ul style="list-style-type: none"> <li>• Easy to handle</li> <li>• Lowers basecoat viscosity</li> <li>• Improves metallic control</li> </ul>	<ul style="list-style-type: none"> <li>• Reduces time spent blending color</li> <li>• Improved appearance</li> <li>• Minimizes metallic "haloing"</li> </ul>	<ul style="list-style-type: none"> <li>• Increased productivity</li> <li>• Goes on smooth</li> <li>• Creates "invisible" spot repairs</li> </ul>

### Compatible Surfaces

Delta® Basecoats may be applied over:

DX1793 Chrome Free Self Etching Primer	DPU174 High Solids Polyurethane Primer
DPU166 High Solids Chromate Primer 2.8 VOC Max	DCB100 Multi-Purpose Blending Clear
DPHS52 Low VOC Primer	OEM Enamels
	Cured Air Dry Finishes

**If sanding prior to the application of Delta® Basecoat color, use 240 - 600 grit wet or dry.**

Basecoat Converter	
Delta® Basecoat Blending Converter	DHSX591
Hardener	
Basecoat Blending Activator	DDH592



# APPLICATION GUIDE DHSX591

**Mixing Ratio:**



DFHS/DUHS : DHSX591 + DDH592  
 1 part : 1 1/2 part + 5 % by Volume of color/DHSX591 mix

Mixed Volume Required	DFHS/DUHS Color	DHSX591	DDH592	Total RTS Ounces
1 pint	6 oz.	9 oz.	3/4 oz.	15 3/4 oz.
1 quart	12 oz.	18 oz.	1 1/2 oz.	31 1/2 oz.
1/2 gallon	24 oz.	36 oz.	3 oz.	63 oz.
1 gallon	48 oz.	72 oz.	6 oz.	126 oz.

**Pot life:**



6 hours @ 70°F and 50% RH  
 (High heat and humidity will Shorten pot life)

**Additives:**



Accelerators: No Recommendation  
 Extenders: No Recommendation  
 Fisheye: No Recommendation  
 Flex: No Recommendation  
 Flattening: No Recommendation

**Spraygun set-up:**



**Fluid Tip**  
 1.0 - 1.4 mm for Pressure Feed/HVLP  
 1.0 - 1.6 mm for Conventional Feed/HVLP

**Air Pressure**  
 HVLP at air cap 10 PSI  
 Conventional at spray gun 40-55 PSI

*Consult the Fleet Training Manual Spray Equipment section for gun set-up requirements.*

**Minimum number of coats:**



1 - 2 coats or until hiding is achieved

**Total film build per coat:**

	<u>Wet</u>		<u>Dry</u>
	DFHS	DUHS	
Minimum	2.1	2.0 mils	0.7 mils
Maximum	4.0	3.8 mils	1.3 mils

**Flash Time at 70°F:**



5 - 10 minutes between coats

# DHSX591

**Drying times:**



**Air Dry @ 70°F**

**DFHS**

Dust 25 minutes

Tack 35 minutes

Tape 5 hours

**DUHS**

Dust 35 minutes

Tack 50 minutes

Tape 6 hours

**Recoat time:**

30 minutes minimum and up to 24 hours maximum at 70°F.  
After 24 hours, sanding is required.

**Repair time:**

5 hours minimum dry time at 70°F.

**Dry Time to Clearcoat:**

30 minutes minimum and up to 24 hours maximum at 70°F.  
After 24 hours, the basecoat color must be sanded and additional color applied before clearcoating.

**TEST PROPERTIES**

	<b>DHSX591</b>	<b>DFHS/ DHSX591</b>	<b>DUHS/ DHSX591</b>
VOC Packaged lbs. per U.S. gal.	2.16	3.5	3.5
VOC RTS Applied lbs. per U.S. gal.	Not applicable	3.5	3.5
Volume Solids (RTS)	Not applicable	32.8%	34.5%
Square Foot Coverage (RTS U.S. Gallon 100% Transfer Efficiency)	Not applicable	526	553
Pencil Hardness**	Not applicable	Not applicable	Not applicable

\*\* Film properties, including pencil hardness, are given where ultimate air cure is reached, usually 7 days.

**Compatible Clearcoats:**

- DCB100 Multi-Purpose Blending Clear
- DCU2050 Graffiti Resistant Clear
- DCU2070 Delta® Urethane Clear

### INSTRUCTIONS FOR USE

#### How To Mix:



#### Mix Basecoat Blending Converter

DFHS/DUHS : DHSX591 + DDH592

1 part : 1½ part + 5% by volume  
of color/DHSX591 mix

Mixed Volume Required	DFHS/DUHS Color	DHSX591	DDH592	Total RTS Ounces
1 pint	6 oz.	9 oz.	¾ oz.	15¾ oz.
1 quart	12 oz.	18 oz.	1½ oz.	31½ oz.
½ gallon	24 oz.	36 oz.	3 oz.	63 oz.
1 gallon	48 oz.	72 oz.	6 oz.	126 oz.



**Pot life:** 6 hours at 70°F (21°C)

#### Air Pressure:



**HVLP:** 10 PSI at the air cap

**Conventional:** 40-55 PSI at the gun

**Fluid tip:** 1.0 - 1.4 mm for Pressure Feed/HVLP

1.0 - 1.6 mm for Conventional Feed/HVLP

#### Application:



**Apply:** 1 - 2 coats or until hiding is achieved

**Between coats:** 5 - 10 minutes

#### Dry Time:



#### Air Dry @ 70°F

**DFHS**                      **DUHS**

Dust 25 minutes      Dust 35 minutes

Tack 35 minutes      Tack 50 minutes

Tape 5 hours              Tape 6 hours

#### Dry Time To Clearcoat:

30 minutes minimum and up to 24 hours maximum at 70°F. After 24 hours, the basecoat color must be sanded and additional color applied before clearcoating.

**PRODUCTS NEEDED FOR JOB**

For additional information,  
refer back to the complete FL508

## HEALTH AND SAFETY

See Material Safety Data Sheet and Labels for additional safety information and handling instructions.

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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