

DELCLEAR® Acrylic Urethane Clear**DAU75**

DAU75 DELCLEAR® Acrylic Urethane is a clearcoat that has been formulated to provide excellent gloss and durability when used over a variety of substrates.

These substrates include **DELSTAR®/DELTHANE®** ULTRA (DAR/DXR80) Polyurethane Acrylic Enamel, **DURACRYL®** (DDL) Acrylic Lacquer, **DELTRON®** (DBU) Universal Basecoat, various metals, and woods.

Compatible Surfaces**DAU75 may be applied over:**

- *Deltron®* (DBU) Universal Basecoat
- *Deltron®* 2000 (DBC) Basecoat
- *Concept®* (DCC) Acrylic Urethane
- *Delstar®/Delthane®* (DAR/DXR80) Polyurethane Acrylic Enamel
- *Duracryl®* Single Stage and Basecoat / Clearcoat Lacquer
- Bare Aluminum (Use Metal Treatments first, see P-226 for instructions)
- Wood

Required Products

	Hardener
Urethane Hardener	DXR80

DAU75

Directions for Use

Preparation:



Where VOC limits allow a maximum of 5.0 lbs./US Gal. for multi-stage systems, reduce DBU Color 150% with DRR Reducer or DBC Color 100% with DT Reducer. Refer to the Product Information Bulletin of the color system for its application, dry times, and blend recommendations. (See P-175CA for DBC and P-152 for DBU Color).

Deltron[®] DBU & DBC Basecoats may be clearcoated with DAU75 after a 30 minute dry time at 70°F (21°C) but no longer than 24 hours.

Delclear[®] (DAU75) may be applied over DAR/DXR80 after a minimum of 4 hours dry, but preferably after DAR/DXR80 has dried overnight at 70°F (21°C).

DAU75 may be applied over *Duracryl*[®] (DDL) Acrylic Lacquer after an overnight dry.

Note: If the color dry times exceed the stated limits, scuff sand and re-apply an additional colorcoat before clearcoating. For additional information, refer to specific product bulletins.

Mixing Ratios:



DAU75	:	DXR80
16	:	1



Pot life of this mixture is 6 hours at 70°F (21°C)

Painting Flexible Parts: (Full panels only)



DAU75	:	DXR80	:	DX369
16	:	1	:	2



Pot life of the flexibilized DAU75/DXR80 mixtures is 3 hours at 70°F (21°C) and could be shorter at higher temperatures.

Additives:



DX84 Accelerator, **DXR81 Accelerator** or **DX87 Extender** may be added up to 1/2 oz sprayable quart. Adding DXR81 Accelerator reduces the pot life to approximately 3 hours at 70°F (21°C), and may decrease gloss.

DAU75 *Delclear*[®] Acrylic Urethane Clear may be tinted with the following:

- DMX Toners
- DX Pearls - up to 4 oz. maximum per unreduced gallon.
- DX Micro-Sequin Flakes & Powder: 4 - 6 ounces per unreduced gallon.
- **DO NOT** tint DAU75 with DMR Bases. Gelling may occur.

Application:



Apply: 2 – 3 wet coats

Air Pressure:

HVLP:	10 psi at the air cap
Conventional:	40 – 50 psi at the gun

Spraygun Set-up:



Fluid Tip:	1.4 – 1.6 mm or equivalent
Film Build Per Wet Coat:	4.8 – 7.1 mils
Dried Film Build Per Coat:	1.0 – 1.5 mils

Directions for Use

Drying Times:



Between Coats: 15 – 20 minutes (no longer than 30 minutes)

Dust:
70°F / 21°C 30 minutes

Tack:
70°F / 21°C 3 hours

Tape:
70°F / 21°C 7 hours



Air Dry:
70°F / 21°C 16 hours

Force Dry:
Purge 0 – 15 minutes
140°F (60°C) 40 minutes



IR (Infrared)
Medium Wave 5 minute half bake, 9 minutes full
Short Wave 5 minutes

Polishing It is not necessary to polish DAU75, however, a mild polish or final buff may be used to remove any minor imperfections. **DO NOT** use a compound or wet sand/polish DAU75.

Repair and Recoat DAU75 can be recoated following a bake cycle of 40 minutes and allowed to cool overnight.
Air dried DAU75 may be recoated after 24 hours dry at 70°F with additional color, clear, or primer.
After 1 week, the DAU75 must be sanded prior to recoating.
After 3 days, DCU2060 must be sanded before recoating.

Equipment Cleaning:

Spray guns, gun cups, storage pots, etc., should be cleaned thoroughly after each use with any appropriate PPG general purpose solvent.

Technical Data::

VOC (Package)	5.88 lbs / U.S.Gal
VOC (Applied 16:1)	5.62 lbs / U.S.Gal
Total Solids by Weight (Applied 16:1)	26%
Total Solids by Volume (Applied 16:1)	21%
Sq. Ft Coverage / US Gal (Applied 16:1)	337 @ 1 mil, 100% transfer efficiency
Film Build Per Wet Coat:	4.8 – 7.1 mils
Dried Film Build Per Coat:	1.0 – 1.5 mil
Recommended Film Build	2.0 to 2.5 mils of dry film

Resistance Testing:

Treated steel panels used for evaluation were primed with OEM primed panels and topcoated with *Deltron*® Basecoat prior to DAU75 Clearcoat. All resistance results were obtained after DAU75 Clearcoat had been allowed to dry approximately 72 hours at moderate temperatures (70°F/21°C).

DAU75

DELCLEAR®
Acrylic Urethane Clear

Important:

The contents of this package must 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 of all components, since the mixture will have the hazards of all its parts. Improper spray technique may result in a hazardous condition. Follow spray equipment manufacturer's instructions to prevent personal injury or fire. Follow directions for respirator use. Wear eye and skin protection. Observe all applicable precautions.

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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