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**DURACRYL® Single Stage and Basecoat/Clearcoat Lacquer**


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# DDL

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**DDL DURACRYL®** is a fast dry, acrylic based lacquer system designed for repair of motor vehicles. This repair system is useful in spot or section repairs as well as overall finishing.

**DDL** single stage colors can be polished to a full gloss. **DURACRYL®** basecoat colors have formula comments that tell when the clearcoat is required.

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**Compatible Surfaces**


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**DDL may be applied over:**

- Cleaned, sanded and primed OEM or Refinish topcoat
- DPLF Epoxy Primer
- DPX801 Universal Plastic Adhesion Promoter
- DSX1900 Bonding Clear
- DX54 ROADGUARD® Chip Resistant Coating
- DZ Kondar® Acrylic Primer Surfacer

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**Required Products**


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	<b>DTL Thinners</b>
Cold Temperature (below 50°F)	DTL10
Cool Temperature (50 – 65°F)	DTL16
Medium Temperature (65 - 85° F)	DTL876
Warm/Hot Temperatures (85 – 110°F)	DTL105
Retarder (over 85°F) up to 25% of thinner	DTX114
	<b>Clear</b>
<i>DURACRYL®</i> Hi-Performance Clear	DCA468

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# DDL

## Directions for Use

### Preparation:



DDL colors are designed to be applied over properly cleaned, sanded and primed surfaces.

- Wash painted surfaces thoroughly with soap and water to remove water-soluble contaminants, then clean with the appropriate PPG Cleaner.
- Sand with 320 grit sandpaper or equivalent. **Note: When doing a spot repair, sand with 1200 grit, 12 inches beyond where color will end. Re-clean and apply DSX1900 to the sanded area.**
- Re-clean with the appropriate PPG Cleaner. Prime or seal as needed.

### Mixing Ratio:



#### Standard Option

<b>DDL Color</b>	:	<b>DTL Thinner</b>
1	:	1 1/2

There is no Pot life for this mixture

#### Painting Flexible parts

Prepare and prime the flexible part with the appropriate flexible primer. Mix color as follows:



<b>DDL Color</b>	:	<b>DTL Thinner</b>	:	<b>DX369</b>
4	:	6	:	1

If clear is needed, mix as follows:



<b>DCA468</b>	:	<b>DTL Thinner</b>	:	<b>DX369</b>
4	:	8	:	1



Pot life is 2 hours at 70°F with DX369

### Additives:



DX73 Fisheye Eliminator, when necessary, can be used in DDL or DCA468 up to 1/2 oz per RTS qt. Surface to be painted must be thoroughly cleaned. *Silicone additives should never be used unless absolutely necessary because the flow-out of paint is decreased in direct relation to the amount used.*

### Application:



Apply:	4 – 6 coats or to hiding for Single Stage 2 – 4 coats or until hiding for Basecoats
Film build per wet coat	2.0 – 3.0 mils
Dry film build per coat	0.4 – 0.5 mils

### Air Pressure:

HVLP at air cap	10 PSI
Conventional at the gun	35 - 45 PSI

### Spray Gun Set-up:



Fluid Tip:	1.2 – 1.5 mils
Spray Viscosity	14 – 21 seconds #2 Zahn

## Directions for Use

### Drying Times:



Between Coats:	5 – 10 minutes
Dust Free:	5 – 10 minutes
Tack Free:	15 – 30 minutes
Tape Free:	1 – 2 hours
Before Clearcoat (If needed):	Allow the final coat of color to dry 30 minutes, but no longer than 24 hours before clearcoating. After 24 hours the DDL Color must be sanded and additional color applied. <i>See note below.</i>



Blending:	Reduced DCA468 may be added to reduced DDL for Blending out.
Polishing DDL:	Air dry overnight or bake 40 minutes at 140°F

**Note:** *To avoid the risk of crazing it is best to apply all coats of lacquer in the same day.*

### Clearcoating:



DCA468 **DURACRYL**® Hi-Performance Clear is required over basecoat **DURACRYL**® and is optional over single stage **DURACRYL**®.

Apply 3 – 4 coats using the ratio below:

<b>DCA468</b>	:	<b>DTL Thinner</b>
1	:	2

DCA468 must be polished to a full gloss

Blending:	Reduced DCA468 may be added to reduced DDL for Blending out.
Polishing DCA468:	Air dry overnight or bake 40 minutes at 140°F

### Technical Data:

<b>DDL</b>	
VOC (PKG)	4.8 – 6.0 lbs. per US Gal
VOC (RTS)	5.9 – 6.7 lbs. per US Gal
<b>DCA468</b>	
VOC (PKG)	5.1 lbs. per US Gal
VOC (RTS)	6.2 – 6.5 lbs. per US Gal
Total Solids by Volume (RTS)	7 – 12%
Sq. Ft Coverage / US Gal (1mil @ 100% Transfer Efficiency)	112 - 192
Film build per wet coat	2 – 3 mils
Dry film build per coat	0.4 – 0.5 mils
Recommended dry film after polishing	Single stage: 1.8 – 3.0 mils Basecoat color: 0.5 – 2.0 mils (Plus 2 mils of clearcoat)

**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.

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

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EMERGENCY MEDICAL OR SPILL CONTROL INFORMATION (304) 843-1300; IN CANADA (514) 645-1320

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