

DCU 2035

IDENTITY

DIAMOND COAT PLUS

CODE

DCU 2035

Hardener

Medium Temperature	DCX 8
Hot Temperature/Force Dry	DCX 9
General Purpose	DCX 61

DT Reducers

Cool Temperature	DT 860 (60 - 70°F) (16 - 21°C)
Medium Temperature	DT 870 (65 - 80°F) (18 - 27°C)
Warm Temperature	DT 885 (75 - 90°F) (24 - 32°C)
Hot Temperature	DT 895 (85°F & Above) (29°C & Above)
Hot Temperature	(#) DT 898 (90°F & Above) (32°C & Above)

DT Retarder

DT 8110 (85°F & Above) (29°C & Above)

ENHANCER™

DX 84

Extender

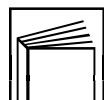
DX 87

BACKGROUND

DCU 2035 DIAMOND COAT PLUS Clear is a 3.5 lbs/gal VOC compliant, high quality urethane finish recommended for use over DELTRON® (DBU) Basecoat and DELTRON 2000 (DBC) Basecoat. DCU 2035 may be used in air dry or force dry booths.

DIRECTIONS FOR USE

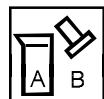
Preparation:



Mix and apply color as directed. Recommended dry time at 70°F (21°C) before clearcoating:

DBU Basecoat - 20 minutes minimum - 24 hours maximum
DBC Basecoat - 20 minutes minimum - 24 hours maximum

Mixing:



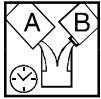
To maintain pot life, in **force dry** situations you must add DX 87 and in **air dry** situations you must add DX 84 at 1 oz. per ready-to-spray (RTS) quart of DCU 2035.

(#) Not currently available in Canada

RTS Clearcoat VOC of DCU 2035 with either DCX 8 ,DCX9 or DCX 61 and various levels of reducer

Clearcoat	Reducer	Hardener	Mixing Ratio	RTS VOC - #/g
DCU 2035 (3.3#/g)	DT (7.1 #/g)	DCX 8 or 9 (1.6 #.g)	4:1:2	3.4 #/g
DCU 2035 (3.3#/g)	DT (7.1 #/g)	DCX 8 or 9 (1.6 #.g)	4:1¼:2	3.5 #/g
DCU 2035 (3.3#/g)	DT (7.1 #/g)	DCX 8 or 9 (1.6 #.g)	4:1½:2	3.6 #/g
DCU 2035 (3.3#/g)	DT (7.1 #/g)	DCX 8 or 9 (1.6 #.g)	4:1¾:2	3.7 #/g
DCU 2035 (3.3#/g)	DT (7.1 #/g)	DCX 8 or 9 (1.6 #.g)	4:2:2	3.8 #/g
DCU 2035 (3.3#/g)	DT (7.1 #/g)	DCX 61 (1.4 #/g)	4:1:2	3.3 #/g
DCU 2035 (3.3#/g)	DT (7.1 #/g)	DCX 61 (1.4 #/g)	4:1¼:2	3.4 #/g
DCU 2035 (3.3#/g)	DT (7.1 #/g)	DCX 61 (1.4 #/g)	4:1½:2	3.6 #/g
DCU 2035 (3.3#/g)	DT (7.1 #/g)	DCX 61 (1.4 #/g)	4:1¾:2	3.7 #/g
DCU 2035 (3.3#/g)	DT (7.1 #/g)	DCX 61 (1.4 #/g)	4:2:2	3.8 #/g

Each blend requires the addition of 1 oz. of either DX84 or DX87 per RTS Quart of Clear

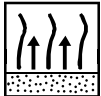


Pot life of the mixtures above is 1½ hours minimum at 70°F (21°C).

Application and Dry Times:



Apply: 1 light to medium coat.
 Fluid tip: 1.3 - 1.5 mm or equivalent
 Air pressure: 10 PSI at the air cap for HVLP guns
 45 - 55 PSI at the gun for conventional guns.



Allow to dry 5 minutes.



Apply 1 wet coat.



Air Dry: 4 - 6 hours at 70°F (21°C)
 Force Dry: Purge time is 0 - 5 minutes at 70°F (21°C)
 Force dry 30 minutes at 140°F (60°C)

Tinting and Additives:



To maintain pot life, in **force dry** situations you must add DX 87 and in **air dry** situations you must add DX 84 at 1 oz. per ready-to-spray (RTS) quart of DCU 2035.

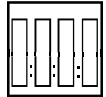
When absolutely necessary, (#)DX 817 Fisheye Preventer may be used in DCU 2035 in a ratio of ½ ounce per RTS quart.

DCU 2035 cannot be tinted.

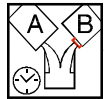
(#) Not currently available in Canada

Painting of Flexible Parts:

When part is off the vehicle (*): See the Preparation section of this Bulletin for color mixing, application, and drying information. Mix DCU 2035 with DX 814 Universal Flexibilizer in the following ratio:



<u>DCU 2035</u>	:	DT <u>Reducer</u>	:	DCX <u>Hardener</u>	:	<u>DX 814</u>	<u>DX 84</u>
1	:	1	:	1	:	1	+ 1 oz/RTS qt



Pot life of flexibilized DCU 2035 is 4 hours at 70°F (21°C).

(*) It is not necessary to add DX 814 to DCU 2035 when the part is already mounted on the vehicle.

Repair or Recoating:



Recoat after cooling 1 - 2 hours following force drying or after 4 hours air dry at 70°F (21°C). If recoating after 16 hours, scuff sand DCU 2035 prior to applying additional primer, sealer, basecoat or clear. Repair after 6 hours air dry at 70°F (21°C) or 4 hours after force drying.

Polishing:



Allow 4 - 6 hours before polishing air dried DCU 2035 at 70°F (21°C) or force dry for 30 minutes at 140°F (60°C) and allow to cool 1 hour before polishing.

Equipment Cleaning:

Spray guns, gun cups, storage pots, etc. should be cleaned thoroughly after each use with DT Reducer, DTL Thinners, or (#)DX 590 All Purpose Clean-up Solvent.

Compatible Surfaces are limited to those listed below:

COMPATIBLE SURFACES DCU 2035 **may be** used over the following:

DELTRON (DBU) Universal Basecoat

DELTRON 2000 (DBC) Basecoat

(#)Starbase™ (DSB) Acrylic Enamel Basecoat Color

(#) Not currently available in Canada

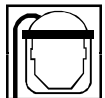
TEST PROPERTIES

Application Viscosity (#2 Zahn):		17 seconds
Flash Point (PMCC)		72°F
VOC (DCU 2035)		3.3 lbs/US gal
VOC (DCX 8)		1.6 lbs/US gal
VOC Applied		≤3.5 lbs/US gal
Weight Solids (Package)		58.8%
Weight solids (a)		57.0%
Volume Solids (a)		50.5%
Sq Ft Coverage at 1 mil (100% transfer efficiency)		811 sq ft/US gal
Film Build Per Coat		0.9 - 1.3 dry mils
Total Recommended Film Build		2 - 2.5 dry mils
Gloss at 20 degrees		90
Dry Time at 70°F (21°C):	Dust	30 - 45 minutes
	Tack	1 - 1½ hours
	Tape	3 - 4 hours
Recoat Sensitivity at 24 hours:		None
Chip Resistance		Very Good
Pencil Hardness		2B - B
Salt Spray:		Excellent
Humidity Resistance/Adhesion		Excellent
Gas Resistance		Excellent

(a) Ready-To-Spray (4:1:2 DCU 2035:DT 870:DCX 8 + 1 oz DX 84/RTS qt)

RESISTANCE TESTING

Treated steel panel used for evaluation were primed with Original Equipment UNI-PRIME® and topcoated with DELTRON Basecoat prior to DCU 2035. All resistance results were obtained after DCU 2035 had been allowed to dry 72 hours at 70°F (21°C).



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

PPG INDUSTRIES, INC.
19699 PROGRESS DRIVE
STRONGSVILLE, OH 44136

PPG CANADA INC.
880 AVONHEAD ROAD
MISSISSAUGA, ONTARIO L5J 2Z5

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.

DCU 2035

DIAMOND COAT® PLUS
3.5 VOC
CLEAR

**INSTANT
REFERENCE**

INSTRUCTIONS FOR USE

How to Mix:



→ Mix DCU 2035

RTS Clearcoat VOC of DCU 2035 with either DCX 8 ,DCX9 or DCX 61 and various levels of reducer

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Each blend requires the addition of 1 oz. of either DX84 or DX87 per Ready To Spray Quart of Clear

Pot life: 1½ hours at 70°F (21°C)

Air Pressure:



HVLP: 10 PSI at the air cap
Conventional: 45 - 55 PSI at the gun
Fluid tip: 1.3 - 1.5 mm or equivalent

Application:



→ Apply: 1 light coat, followed by 1 wet coat

Between coats: 5 minutes

Dry Time:



Air Dry: 4 - 6 hours at 70°F (21°C)
or
Purge Time: 0 - 5 minutes
Force Dry: 30 minutes at 140°F (60°C)

PRODUCTS NEEDED FOR THE JOB



For additional information, refer back to the complete P-203