DELTRON®

P-241

Deltron® Velocity Premium Clearcoat

DC4000

DC4000 is a high velocity, premium clearcoat, specifically developed to enhance productivity in air-dry and low bake collision repair facilities.

Deltron Velocity Premium Clearcoat offers ease of application along with great gloss and hold out.

The exceptionally short bake provides increased productivity along with reduced operating cost.

Features

- Low temperature, fast bake
- Easy application

Advantages

- Process time savings
- Less rework

Benefits

- Customer satisfaction

Compatible Surfaces

DC4000 may be applied over:

- *DELTRON*® (DBU) Universal Basecoat
- *DELTRON*® 2000 (DBC) Basecoat
- *CONCEPT*® (DCC) Acrylic Urethane

Required Products

	Hardener
Low Temperature	DCH3070 (55°– 75°F / 13°– 24°C)
Medium Temperature	DCH3085 (75°– 95°F /24°– 35°C)
High Temperature	DCH3095 (95°F / 35°C & above)
Ultra High Temperature	DCH3098 (95°F / 35°C & above)

PPG

DC4000

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).

Mixing Ratio:

Standard Mix

DC4000	:	DCH30xx Hardener
4	:	1

Mixing DC4000 as a Cut-in Clear

Add 1 part DBC Color to 1 part DC4000 then ...

DBC / DC4000 Mix	:	DCH30xx Hardener	:	DT Reducer
4	:	1	:	1/2

Pot life is 1 1/2 – 2 hours at 70 ℉ (21 ℃) for standard mix

Additives:

DX814 Flexibilizer

DC4000	:	DCH30xx Hardener	:	DX814
3	:	1	:	1/2

Application:

Apply:	2 wet coats

Air Pressure:

HVLP:	10 PSI at the air cap
Conventional:	45 – 55 PSI at the gun

Spraygun Set-up:

Fluid Tip:	1.3 – 1.5 mm or equivalent
Film build per wet coat:	3 – 3.5 mils
Dried film build per coat:	1.2 – 1.4 mils

Directions for Use

Drying times:

Between coats:	5 – 7 minutes
Dust-free:	
70°F / 21°C	15 – 25 minutes
Tack Free:	
70°F / 21°C	30 – 45 minutes
Tape Time:	
70°F / 21°C	12 – 16 hours
Air Dry:	
70°F / 21°C	4 – 6 hours
Force Dry:	
Purge	None
Bake w/3070	10 minutes @140°F (60°C)
Bake w/3085 or 3095	20 minutes @140°F (60°C)
Bake w/3098	20 minutes @140°F (60°C)
IR (Infrared):	
Medium wave	5 minutes half bake, 9 minutes full
Short wave	5 minutes
Polishing:	
Air Dry	4 – 6 hours @ 70°F (21°C)
Force Dry	Immediately after cool down
	DC4000 can be lightly sanded with 1500 – 2000 grit sandpaper and compounded. Use a foam pad with a minor cutting compound to remove any minor imperfections.
Repair and Recoat:	Recoat after force dry and cooling cycle or 4 – 6 hours air dry 70°F (21°C).
	Repair after force dry and cooling cycle or 4 – 6 hours air dry 70°F (21°C).
	DC4000 must be sanded before recoating with primer, color or clear.

Note: *All force dry times are quoted for metal temperature. Additional time must be allowed during force dry to allow metal to reach recommended temperature.*

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 less exempt solvents (Applied 4:1)	4.15 lbs/gal. (497 g/l)
VOC less exempt solvents as a Cut-in Clear (Applied 4:1:½)	5.03 lbs/gal. (603 g/l)
VOC less exempt solvents w/DX814 (Applied 3:1:½)	4.17 lbs/gal. (500 g/l)
Total Solids by Volume (Applied 4:1)	39.9%
Sq. Ft Coverage / US Gal (Applied 4:1) (1 mil, 100% transfer efficiency)	639

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Resistance Testing:

Treated steel panels used for evaluation were primed with Original Equipment *UNIPRIME*®, *DELTRON*® Sealer and topcoated with *DELTRON*® Basecoat prior to DC4000 Clearcoat. All resistance results were obtained after DC4000 Clearcoat had been allowed to dry approximately 72 hours at moderate temperatures (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 (412) 434-4515; 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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Part No. P-241 12/06