

DC4010

DC4010 is a high velocity, premium clearcoat, specifically developed to enhance productivity in air-dry and low bake collision repair facilities.

DELTRON® DC4010 offers ease of application, outstanding flow and leveling, superior clarity and a deep rich gloss. DC4010 is extremely versatile and can be used for multi-panel and overall refinishing. While offering good air-dry performance, DC4010 is best suited for low bake or force dry conditions. DC4010 has an extremely short bake cycle which reduces in-booth time, energy cost and can improve paint shop productivity.

DC4010 is designed to meet the most stringent VOC regulations in both the US and Canada.



Features & Benefits

- Short bake
- Easy application
- Process time savings
- Excellent gloss and hold out

Compatible Surfaces

DC4010 may be applied over:

- ENVIROBASE® High Performance Basecoat
- Deltron 2000 (DBC) Basecoat
- Deltron (DBU) Universal Basecoat

Required Products

Hardener

- | | |
|---------|---|
| DCH3610 | Low Temp Hardener LV 60-75°F (16-24°C) |
| DCH3620 | Medium Temp Hardener LV 75-95°F (24-35°C) |
| DCH3630 | High Temp Hardener LV 95°F (35°C) and above |
| DCH3640 | Ultra High Temp Hardener LV 95°F (35°C) & above |

Refer to the Product Information Bulletin of the color system for its application, dry times, and blend recommendations.

Mix Ratio:



Standard Mix

DC4010	:	DCH36xx Hardener
4	:	1

Accelerated Mix:

DC4010	:	DCH36xx Hardener	:	SL93LV
4	:	1	:	2%



Pot Life :

Standard Mix: 2½ - 3 hours at 70°F (21°C)

Accelerated Mix: 2 - 2.5 hours at 70°F (21°C)

Additives:



SLV814 Universal Flexibilizer

DC4010	:	DCH36xx	:	SLV814
3	:	1	:	½

SLV814 Universal Flexibilizer with SL93LV Accelerator

DC4010	:	DCH36xx	:	SLV814	:	SL93LV
3	:	1	:	½	:	2%

SL93LV Accelerator:

See above for ratio

SLV4985 Universal Flattening Agent:

See ONECHOICE® bulletin OC-7

Air Pressure and Gun Setup:



HVLP:

8 - 10 psi at the air cap

Compliant:

29 - 40 psi at the gun

Gun Setup:

1.3 - 1.6 mm or equivalent

Note: For best overall results, refer to spraygun manufacturer's recommendations for inlet air pressures.

Application:



Apply:

2 wet coats

Total Recommended Dry Film:

2.0 - 2.5 mils

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Drying Times:



Between Coats: 5 - 7 minutes at 70°F (21°C)

Dust Free: 30 - 40 minutes at 70°F (21°C)
15 - 20 minutes at 70°F (21°C) with SL93LV

Tape Time: 12 - 16 hours at 70°F (21°C)
6 - 8 hours at 70°F (21°C) with SL93LV



Air Dry: 4 - 6 hours at 70°F (21°C)
2½ - 3 hours at 70°F (21°C) with SL93LV



Force Dry:

Purge: None
w/DCH3610: 15 minutes at 140°F (60°C)
w/DCH3620/3630/3640: 20 minutes at 140°F (60°C)
With SL93LV: 10 minutes at 140°F (60°C)



IR (Infrared):

Medium Wave: 5 minutes half bake, 10 minutes full
Short Wave: 5 minutes



Polishing:

Air Dry: 4 - 6 hours at 70°F (21°C)
1½ - 2 hours at 70°F (21°C) with SL93LV

Force Dry: After cool down

DC4010 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.



Recoat and Repair

Recoat: Recoat after force dry and cool down or 4-6 hours air dry 70°F (21°C).

DC4010 must be sanded before recoating with primer, color, or clear.

Repair: Repair after force dry and cool down or 4 - 6 hours air dry 70°F (21°C)



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.

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Technical Data:	DC4010 : DCH36xx	DC4010 : DCH36xx : SL963LV	DC4010 : DCH36xx : SLV814
Volume Ratio	4:1	4:1:2%	3:1:1½
Applicable Use Category	Clear Coating	Clear Coating	Clear Coating Flexed
VOC Actual (g/L)	129	127	116
VOC Actual (lbs./ gal)	1.08	1.06	0.97
VOC Regulatory (less water less exempt) (g/L)	244	243	219
VOC Regulatory (less water less exempt (lbs./ gal)	2.04	2.03	1.83
Density (g/L)	1100	1105	1118
Density (lbs./ gal)	9.18	9.22	9.33
Volatiles wt. %	60.8	61.7	60.3
Water wt. %	0.0	0.0	0.0
Exempt wt. %	49.0	50.1	49.9
Water vol. %	0.0	0.0	0.0
Exempt vol. %	46.7	47.5	47.1
Solids vol. %	38.2	37.5	39.5
Solids wt. %	39.2	38.3	39.7
Sq. ft. coverage ./ US gal. (1 mil. At 100% transfer efficiency)	613	602	634

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



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.

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 public. Products mentioned may be hazardous and should only be used according to direction, 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.

PPG Automotive Refinish
19699 Progress Drive
Strongsville, OH 44149
800.647.6050

PPG Canada Inc.
2301 Royal Windsor Drive, Unit #6
Mississauga, Ontario L5J 1K5
888.310.4762

Follow us online:  
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