

Acrylic Urethane Sealers

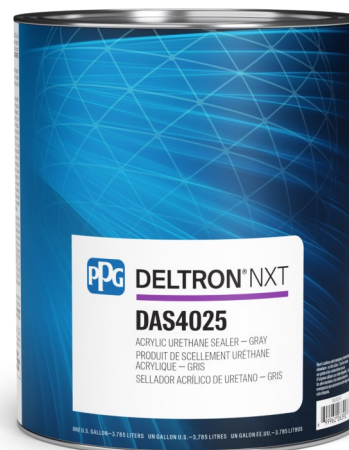
P-256

DAS4021 White / DAS4025 Gray / DAS4027 Dark Gray

The PPG DELTRON® NXT™ DAS402x series is comprised of three premium-quality, high-velocity sealers. The product is available in white, gray, and dark gray and suitable for the premium solventborne and waterborne finishes used in today's collision repair shops. These fast-drying acrylic urethane sealers have excellent flow properties and gloss holdout.

DAS402x can be used directly over unsanded OEM E-Coat, sanded original finishes, and/or properly prepared and treated bare steel, aluminum, fiberglass and plastic.

For optimum topcoat coverage, a choice of 7 gray shades (G1-G7) can be achieved by mixing the white, gray and dark gray sealers.



Features & Benefits

- Fast drying
- Excellent color hold out
- Highly productive
- Available in 3 colors for optimum topcoat coverage

Required Products

Hardener

DCX3030 Undercoat Hardener

Reducer

DT1565 Fast Thinner (55-65°F)

DT1575 Medium Thinner (65-77°F)

DT1585 Slow Thinner (77-90°F)

DT1595 Very Slow Thinner (95+°F)

Compatible Surfaces

DAS402x may be applied over:

- Properly cleaned and sanded gel coated fiberglass
- Properly cleaned E-Coat
- Properly cleaned and sanded OEM finishes
- Properly prepared and treated bare steel and aluminum
- *Deltron NXT* Etch Primers
- *Deltron NXT* Plastic Adhesion Promoter
- *Deltron NXT* Surfacer
- DPLF Epoxy Primer
- DPLV 2.1 VOC Epoxy Primer
- ONECHOICE® Etch Primers
- *OneChoice* Plastic Adhesion Promoters

Surface Preparation:



- Wash the area to be painted with soap and water, then clean with an appropriate PPG cleaner.



- Sand the bare metal areas completely with P180-P220 grit abrasive. Sand old finishes with P400 grit dry by hand or machine or P400-P500 grit wet.
- Exposed bare metal should be spot primed with a suitable bare metal primer.



- Re-clean with an appropriate PPG cleaner followed by a tack cloth to eliminate dirt prior to painting.

Mix Ratio:



DAS402x : DCX3030 Hardener : DT15 Series Reducer
4 : 1 : 1



Pot Life: 2 hours at 70°F (21°C). Note: Pot life is shortened as temperatures increases.

****DT1598 should NOT be used in this product****

Additives:



SL814 Universal Flexibilizer: 10% to RTS mix

Air Pressure & Gun Setup:



HVLP: 8-10 psi at the air cap
Compliant: 26-29 psi at the gun

Gun Setup: 1.3-1.4 mm or equivalent

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

Application:



Apply: 1 wet coat

Dry Film build per coat: 1-1.2 mils

Drying Times:



Air Dry:

Dust Free: 10 minutes at 70°F (21°C)

Tape Time: 1½ hours at 70°F (21°C)



Dry to Topcoat: 1 Coat 15 minutes at 70°F (21°C)

After 72 hours, sealer must be scuffed before applying basecoat or topcoat..
 If sanded film is below 1 mil, sealer must be reapplied.



IR:

Medium Wave: 10 minutes

Short Wave: 5 minutes

Compatible Topcoats:

DAS402x may be topcoated with:
 Deltron NXT Basecoat
 Deltron DBC Basecoat
 ENVIROBASE® High Performance Basecoat

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:	DAS402x : DCX3030 : DT15xx Reducer		DAS402x : DCX3030 : DT15xx Reducer + SL814	
Volume Ratio	4:1:1		4:1:1:10%	
Applicable Use Category	Primer Sealer		Primer Sealer	
VOC Regulatory (less water less exempt) (g/L)	538		545	
VOC Regulatory (less water less exempt) (lbs./gal)	4.49		4.55	
Total Solids by Weight (RTS)	54.4		53.0	
Total Solids by Volume (RTS)	34.8		34.4	
Sq. ft. coverage / US gal. (1 mil. At 100% transfer efficiency)	558		552	

A-Chromatic Gray Mixing Chart

Acrylic Urethane Sealers

Use this chart as a guide to mix the G1-G7 ratios to achieve better hiding when mixing the Acrylic Urethane Sealers.

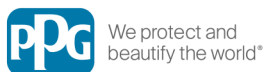
Mix Ratio By Volume			Mix Ratio By Cumulative Weight							
			Grams				Parts			
	Mix Ratio		¼ Pint	½ Pint	Pint	Quart	¼ Pint	½ Pint	Pint	Quart
G1	DAS4021	4	108	215	430	862	121	241	482	965
	DCX3030	1	127	254	508	1015	142	284	568	1137
	DT15xx	1	151	302	604	1206	169	338	676	1351
G3	DAS4021	2.7	72	144	288	576	81	161	323	645
	DAS4025	1.3	108	215	430	860	120	241	482	964
	DCX3030	1	127	253	507	1014	142	284	568	1136
	DT15xx	1	151	301	603	1205	169	337	675	1350
G5	DAS4025	4	107	215	429	859	120	240	481	962
	DCX3030	1	126	253	506	1012	142	283	567	1133
	DT15xx	1	150	301	602	1203	168	337	674	1348
G6	DAS4025	2.7	71	142	284	568	80	159	318	636
	DAS4027	1.3	108	215	430	860	120	241	482	964
	DCX3030	1	127	253	507	1014	142	284	568	1136
	DT15xx	1	151	301	603	1205	169	337	675	1350
G7	DAS4027	4	107	215	430	860	120	241	481	963
	DCX3030	1	127	253	506	1013	142	284	567	1134
	DT15xx	1	150	301	602	1204	169	337	674	1348

See 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

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