DELTRON® NXT

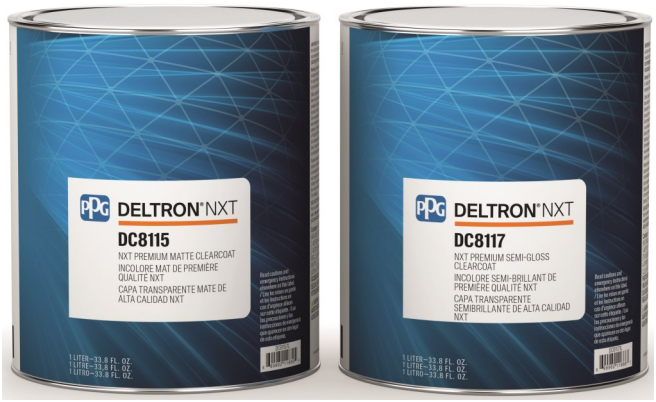
Premium Matte and Semi-Gloss Clearcoat System

P-252

DC8115 / DC8117

The DELTRON® NXT™ Premium Matte and Semi-Gloss Clearcoat System consists of two versatile 2K acrylic urethane clearcoats designed to reproduce a range of low gloss levels, including the specialized repairs of vehicles originally finished with a low gloss clearcoat over a single or multistage basecoat color system. To allow for the normal gloss variations due to color, model, position or repair on vehicle etc., the actual mix of the two clearcoats can be varied to match the vehicle to be repaired.

DC8115 or DC8117 or mixes of the two may be used over rigid plastics without the need for special additives. It is designed for use over *Deltron NXT* Basecoat (see data sheet P251) and ENVIROBASE® High Performance Basecoat (EB143).



Features & Benefits

- Easy application
- High solids
- Excellent efficiency

Compatible Surfaces

DC8115/DC8117 may be applied over:

- *Deltron NXT* (NXT) Basecoat
- *Envirobase* High Performance (EHP) Basecoat

Required Products

Hardener
DCH8239 High Solids Hardener

Reducers
DT1575 Medium Thinner (65-77°F)
DT1585 Slow Thinner (77-90°F)
Acetone

Surface Preparation:

- When masking a repair, care should be taken to minimize direct contact of masking tape onto the original matte finish. Where it is necessary to use masking tape directly on the original finish, the tape must be removed before baking to avoid marking of the original, which may not recover.
- DC8115/DC8117 clearcoats must be applied on top of a clean and dust-free basecoat. Use of a tack cloth is recommended after the basecoat has flashed off.
- Care should be taken to avoid dirt inclusion at all stages. Rectification of dirt inclusion in matte or low gloss finishes is not possible after the final coat of clearcoat.
- In all cases, wash surfaces to be painted with soap and water and then apply the appropriate PPG substrate cleaner. Ensure that the substrate is thoroughly cleaned and dried, both before and after application work.
- Wet sand with European P800-P1200 / US 500-600 grade paper or dry sand with European P600-P800 / US 400-500 grade paper.
- Wash off sanding residue and dry thoroughly before re-cleaning with the appropriate PPG substrate cleaner. The use of a tack rag is recommended.

Deltron NXT DC8115/DC8117 Premium Matte and Semi-Gloss Clearcoat System

Mix Ratio & Pot Life:

National Rule Mix Ratio:

DC8115/DC8117 Clearcoats	:	DCH8239 Hardener	:	DT15XX Reducer
3	:	1	:	1½

Compliant Mix Ratio:

	DC8115/DC8117 Clearcoats	:	DCH8239 Hardener	:	DT15XX Reducer	:	Acetone
Standard Temperature Conditions (below 85ºF)	3	:	1	:	½ DT1585	:	1½
High Temperature Conditions (above 85ºF)	3	:	1	:	½ DT1595	:	1½

Note: The volume ratio shown above is for reference, however, it is important that to ensure accurate and replicable mixing of matte clearcoat finishes, they should be mixed by weight on a scale. To verify a color match and gloss level, it is recommended that a test panel be sprayed before spraying the vehicle. FC01-FC05 matte levels will appear with the color formulas that require a low gloss finish. All mix by weight volumes for these formulas may be found in PAINTMANAGER®.

Pot Life: 1-2 hours at 68°F (20°C) (depending on reducer)

Blending Ratio:

DC8115 or DC8117 clearcoats may be used individually or combined to achieve five different levels of gloss. See table below for % combinations.

	FC01 = Flat *Lamborghini* full body matte finish	**FC02 = Matte**	**FC03 = Eggshell** *Mercedes Benz*, Smart, BMW®, Fiat full body matte finishes	**FC04 = Satin**	**FC05 = Semi-Gloss** Older *Mercedes Benz* lower body cladding
% of Gloss	**0-10.0%**	**10.1-20.0%**	**20.1-30.0%**	**30.1-45.0%**	**45.1-60%**
DC8115 %	100	85	70	40	0
DC8117 %	0	15	30	60	100

Additives:

None

Note: Matte finish clearcoats may be applied over rigid plastics without the need to add a Flexibilizer.

Air Pressure & Spray Gun Setup:

HVLP:	10 psi at the air cap
Compliant:	29-40 psi at the gun
Gun Setup:	1.2-1.3 mm; 1.4-1.5 for larger jobs/higher temperatures
Spray Viscosity:	15 seconds DIN4 at 68°F (20°C)

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

Application Process:

The preparation of color test panels to check the color and number of coats of clearcoat to achieve the correct matte effect is strongly recommended. The original matte finish can sometimes become less matte over time due to weathering and cleaning processes used by car owners. DC8115/DC8117 can be used individually or combined to achieve five levels of gloss.

Notes: No Fade-out process is possible for matte colors.

The clearcoat can be de-nibbed to remove minor dirt inclusions after the flash off time between coats listed below Any de-nibbing must be completed before the final coat of reduced gloss clearcoat is applied. Dirt removal from the final low gloss finish is not possible.

Apply: 1 Full single coat
Flash off until evenly matte all over
1 Full single coat followed immediately by a lighter (½ coat) cross coat.
Flash off until evenly matte before baking.

Deltron NXT DC8115/DC8117 Premium Matte and Semi-Gloss Clearcoat System

Drying Times:

Between Coats: 10-13 minutes at 68°F (20°C)
Dust Free: 45 minutes at 68°F (20°C)
Dry to Handle 12-16 hours at 68°F (20°C)
Tape Time: 23-26 hours at 68°F (20°C)

Air Dry: 8 hours at 68°F (20°C)

Force Dry: * 15-30 minutes purge time ensuring the clearcoat is completely matte before baking

40 minutes at 140°F (60°C)

IR (Infrared): **Medium Wave:** 15-20 minutes
Short Wave: 8-15 minutes

*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.

Overcoat / Recoat:

Recoat Time: 16 hours at 68°F (20°C) or after force dry and cool down. Must be sanded before recoating with primer, color or clear.

Grade Wet: European P800-P1200 / US 500-600
Grade Dry: European P600-P800 / US 400-500

Recoating times will be extended at lower temperatures.

Equipment Cleaning:

Spray guns, gun cups, storage pots, etc., should be cleaned thoroughly after each use with any appropriate PPG general purpose solvent.

Performance Guidelines:

The gloss levels achieved with this clear may vary depending on film thickness and application. Low film thickness and dry application will give a lower gloss level. High film thickness and wetter application will give a higher gloss level. It is recommended that DC8115/DC8117 clearcoats be used only for complete panel repairs.

Technical Data:

Total dry film build:

Minimum: 2.0 mils

Maximum: 2.5 mils

Recommended film build per wet coat: 2.1-3.1 mils

Recommended dried film build per coat: 1.0-1.25 mils

RTS Combinations:

	DC8115 : DCH8239 : DT15XX	DC8115 / DC8117 : DCH8239 : DT15XX	DC8117 : DCH8239 : DT15XX
Volume Ratio	*3 : 1 : 1.5*	*3 : 1 : 1.5*	*3 : 1 : 1.5*
VOC Actual (g/L)	*401-403*	*404*	*409*
VOC Actual (lbs./ US gal.)	*3.35-3.36*	*3.37*	*3.41*
VOC Regulatory (less water, less exempt (g/L)	*533-534*	*536*	*542-543*
VOC Regulatory (less water, less exempt (lbs./ US gal.)	*4.45-4.46*	*4.47*	*4.52-4.53*
Density (g/L)	*967-968*	*964*	*955-956*
Density (lbs./ US gal)	*8.07-8.08*	*8.04*	*7.97-7.98*
Solids wt.%	*38-38.1*	*37.6*	*36.6*
Solids vol.%	*29.5*	*29.3*	*28.8*
Sq. Ft. Coverage at 1 mil. at 100% transfer efficiency	*473*	*470*	*462*

Deltron NXT DC8115/DC8117 Premium Matte and Semi-Gloss Clearcoat System

General Care & Maintenance of Matte Finishes:

The following guidance on care and cleaning of matte finish vehicles is aimed at the car owner, and applies to both the OE and repair finish. Particular care must be taken with matte finishes to maintain an original even matte effect. See below for guidance for the car owner on maintaining the even matte effect over time.

Matte/Low gloss finishes can be relatively easily marked with general handling and day-to-day use (door/hood/deck lid opening, shoe scuffing on entry or exit of vehicle etc.). Care should be taken with these operations because marking or changing of the matte effect could result.

Care should be taken to avoid spillage of fuel onto the matte/low gloss finishes. Fuel spills should be removed as soon as possible using the washing guidelines below to avoid permanent damage or altering of the low gloss effect.

1. To keep the matte surface effect, the use of paint cleaner, abrasives or polishes and wax polishes **must** be avoided. The vehicle must **not** be polished.
2. Polishing will lead to a higher, uneven gloss effect.
3. Cleaning with unsuitable materials could alter the matte effect (generally increasing gloss).
4. Automated car washing should be avoided. The preferred car washing method is by hand with a soft sponge, mild soap and lots of water. Frequent car washing over a period of time could lead to increased and inconsistent gloss levels across a car panel. Washing under direct sunlight should also be avoided.
5. Insects and bird droppings should be removed immediately. These residues should be soaked in water to soften and/or remove carefully with high pressure cleaning equipment. In the case of strongly adhered residues, a spray on insect remover should be used prior to washing.
6. Whenever using any type of cleaning fluids with soft sponges or cloths, it is essential not to apply pressure or rub the matte finish. A gentle wipe/spray on, wipe off technique should be used. Applying pressure will alter the matte effect and result in an uneven appearance.

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

We protect and beautify the world®

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:
www.ppgrefinish.com

Product Information Effective 04/2025