

# DCU2002



The DELTRON® NXT™ DCU2002 High Solids Polyurethane clear delivers a premium-quality, high-gloss, 4.2 VOC finish and is designed for either air dry or force dry spray booth applications.

## Features & Benefits

- Excellent gloss
- Premium force dry clear
- High solids
- Easy application

## Compatible Surfaces

DCU2002 may be applied over:

- *Deltron NXT* Basecoat
- *Deltron* (DBC) Basecoat
- ENVIROBASE® High Performance (EHP) Basecoat

## Required Products

### Hardeners

DCX8	High Solids Hardener Medium Temperature
DCX9	High Solids Hardener Hot Temperature/Force Dry
DCX61	High Solids Hardener General Purpose
DFX11	Low VOC Hardener

### Reducers

DT1565	Fast Thinner (55-65°F)
DT1575	Medium Thinner (65-77°F)
DT1585	Slow Thinner (77-90°F)
DT1595	Very Slow Thinner (95+°F)
DT1598	Ultra Slow Thinner (98+°F)

## Surface Preparation:



- Wash all surfaces to be painted with soap and water, then apply the appropriate ONECHOICE® or *Deltron NXT* cleaner. Ensure the substrate is thoroughly cleaned and dried both before and after application work.



- Wet sand with US 500-600 / European P800-P1200 grade paper or dry sand with US 400-500 / European P600-P800 grade paper.



- Wash off residue and dry thoroughly before recleaning with appropriate cleaner. The use of a SX1070 *OneChoice* tack rag is recommended.

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

**Mix Ratio & Pot Life:**



**Standard Mix:**

DCU2002 : DCX Hardener : DT Reducer  
 4 : 1 : 1



DCU2002 : DFX11 Hardener : DT Reducer  
 5 : 5 : 1



**Pot Life:** 4:1:1 4 hours at 70°F (21°C)  
 5:5:1 3 hours at 70°F (21°C)

**Additives:**

DCU2002 cannot be tinted



**SL814 Universal Flexibilizer :**

DCU2002 : DCX Hardener : DT Reducer : SL814  
 4 : 2 : 1 : 2

DCU2002/DCX9/DT (4:1:1) may be used on flexible parts without SL814

DCU2002/DFX11 is not recommended over flexible parts.

Note: It is not necessary to add SL814 to DCU2002 when the part is mounted on the vehicle.

- DX73 Fisheye Preventer:** up to 0.5 oz. per RTS quart.
- SL84 Accelerator** up to 0.5 oz. per RTS quart when using DCX hardeners.
- SL87 Extender** up to 0.5 oz. per RTS quart when using DCX hardeners.
- DXR81 Accelerator** up to 0.5 oz. per RTS quart when using DFX11 hardener
- SU4985 Universal Matting Agent:** See ONECHOICE® bulletin OC-2

DO NOT USE SL84 or SL87 when using DFX11.

**Air Pressure & Spray 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 spray gun manufacturer's recommendations for inlet air pressures.  
 Refer to Document DOX44NXT for optimized gun setting for the most popular spray guns in the field.

**Application:**



**Apply:** 2 wet coats  
**Total Recommended Dry Film:** 2.0-2.5 mils

**Drying Times:**



**Between Coats:** 5-10 minutes with DCX hardeners at 70°F (21°C)  
 3-5 minutes with DFX11 at 70°F (21°C)

**Dry Times at 70°F (21°C) :**

	<u>DCX8</u>	<u>DCX9</u>	<u>DCX61</u>	<u>DFX11</u>
<b>Dust Free:</b>	80-90 minutes	100 minutes	70 minutes	15-20 minutes
<b>Tape Time:</b>	5-6 hours	6 hours	6 hours	12 hours



**Air Dry:** 16 hours at 70°F (21°C)



**Force Dry: \*** **Purge:** 0-5 minutes at 70°F (21°C)  
**DCX Hardeners:** 30 minutes at 140°F (60°C)  
**DFX11:** 15-30 minutes at 120-140°F (49-60°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

## Polishing:



Use a 3-step process:

1. After bake cycle and 1 hour cool down, use a premium wool pad with a minor cutting compound.
2. Follow with a medium foam pad with machine glaze.
3. Use a soft foam pad with a fine glaze to remove any minor imperfections.

## Recoat and Repair:



**Recoat:** Recoat after force dry and cool down or 6-8 hours air dry at 70°F (21°C).

DCU2002 must be sanded before recoating with primer, color or clear.



**Repair:**

**DCX Hardener:** Repair after force dry and cool down or 16 hours air dry at 70°F (21°C)

**DFX11 Hardener:** Repair after force dry and cool down or 5 hours air dry at 70°F (21°C)

## 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:

	DCX8	DCX9	DCX61	DFX11
VOC	4.11	4.11	4.11	4.27
Total Solids by Weight (RTS)	48.5%	48.4%	48.5%	46.2%
Total % Solids by Volume (RTS)	42.0%	42.0%	42.1%	39.8%
Sq. Ft. Coverage/US Gallon (1 mil 100% transfer efficiency)	674	674	675	639

**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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