

DCU2021



DELTRON[®] NXT[™] DCU2021 Urethane Clear is easy to apply and produces a high gloss finish.

With a VOC rating of 4.2, this clearcoat meets requirements of the U.S. National Rule Automotive Refinish Regulation.

Features & Benefits

- High solids
- Versatile, choice of 4 hardeners
- Air dry or bake
- Fits most shop conditions

Compatible Surfaces

DCU2021 may be applied over:

- *Deltron* (DBC) Basecoat
- *Deltron* NXT 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 SX2070 *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:

DCU2021 : DCX Hardener : DT Reducer
 4 : 1 : 1



DCU2021 : DFX11 : 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)
 Flexibilized: 1-2 hours at 70°F (21°C)

Additives:



SL814 Universal Flexibilizer:

DCU2021 : DCX Hardener : DT Reducer : SL814
 4 : 2 : 1 : 2



Note: It is not necessary to add SL814 when the part is already mounted on the vehicle. DCU2021/DCX9/DT (4:1:1) may be used on flexible parts without SL814. DCU2021/DFX11 is not recommended over flexible parts.

DX73 Fisheye Eliminator 0.5 oz. per RTS quart
 SL84 Enhancer up to 0.5 oz. per RTS quart
 SL87 Extender up to 0.5 oz per RTS quart
 DXR81 Accelerator up to 0.5 oz per RTS quart
 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
 3-5 minutes with DFX11

Dry Times at 70°F (21°C) :

	<u>DCX8</u>	<u>DCX9</u>	<u>DCX61</u>	<u>DFX11</u>
Dust Free:	60-70 minutes	100 minutes	70 minutes	15-20 minutes
Tape Time:	5-6 hours	6 hours	6 hours	10 hours



Air Dry: 16 hours at 70°F (21°C)



Force Dry: * Purge: 0-5 minutes
 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 or metal temperature. Additional time must be allowed during force dry to allow metal to reach recommended temperature.

Polishing:



Air Dry: DCX Hardener: 12 hours at 70°F (21°C)
DFX11: 10 hours at 70°F (21°C)

Force Dry: DCX Hardener: After cool down
DFX11: 4-6 hours after cool down

Recoat and Repair:



Recoat: Recoat after force dry cool down or 6-8 hours air dry at 70°F (21°C).
DCU2021 must be sanded before recoating with primer, color or clear.

Repair:
DCX Hardener Repair after force dry and cool down or 8 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.

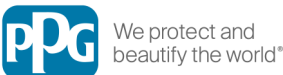
Technical Data:	DCX8	DCX9	DCX61	DFX11
VOC (with hardener) lbs./ US gal.	4.10	4.10	4.10	4.27
Total % Solids by Weight	48.5%	48.4%	48.5%	46.2%
Total % Solids by Volume	42.0%	42.0%	42.0%	39.8%
Sq. Ft. Coverage/US gal. (1 mil. 100% transfer efficiency)	673	673	674	638

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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