

DC5050

The DELTRON® NXT™ DC5050 Premium Glamour Clearcoat is specifically formulated for exceptional gloss, ease of application, easy buffability and exceptional hold out.

DC5050 provides users with industry-leading applications and gloss. It is designed for use over *Deltron NXT* Basecoat (see P-251) and ENVIROBASE® High Performance Basecoat (see EB143).



Features & Benefits

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

Compatible Surfaces

DC5050 may be applied over:

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

Required Products

Hardener

- DCH3070 Low Temp Hardener 60-75°
- DCH3085 Medium Temp Hardener 75-95°F
- DCH3095 Hi Temp Hardener 95°F (35°C) and above
- DCH3098 Ultra Hi Temp Hardener 95°F (35°C) and up

Thinners

- 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)

Use only DCH3085, DCH3095 and DCH3098 over *Envirobase* High Performance

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 *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:



DC5050 : DCH30XX Hardener : DT15XX Thinner
3 : 1 : 1



Pot Life: 4 hours at 70°F (21°C)

Additives:



SL814 Universal Flexibilizer:

DC5030 : DCH30XX Hardener : DT15xx Series Thinner : SL814

2 : 1 : 1 : 1

SU4985 Matting Agent: See *OneChoice* OC-2

Air Pressure & Spray Gun Setup:



HVLP : 8-10 psi at the air cap
Compliant : 29-40 psi at the gun
Gun Setup : 1.2-1.5 mm or equivalent

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

Refer to Document DOX440NXT for optimized gun setting for the most popular spray guns in the field.

Application:



Apply: 2 wet coats
Total recommended dry film: 1.2-1.4 mils
Maximum dry film build: 3.0 mils
Spray the first coat like you want the last coat to look

Drying Times:



Between Coats: 5-10 minutes at 70°F (21°C)
Dust Free: 60-90 minutes at 70°F (21°C)
Dry to Handle: 4-5 hours at 70°F (21°C)
Tape Time: Overnight at 70°F (21°C)



1 hour cool down at 140°F (60°C)

Air Dry: Overnight at 70°F(21°C)



Force Dry: * Purge: 0-5 minutes
DCH3070 Hardeners: 20 minutes at 140°F (60°C)
DCH3085/3095/3098 30 minutes at 140 °F (60°C)



IR (Infrared): **Medium Wave:** 45 minutes
Short Wave: 25 minutes



*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:



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.
- Use a soft foam pad with a fine glaze to remove any minor imperfections

Overcoat and Recoat:



Recoat: 16 hours air dry at 70°F (21°C) or after force dry and cool down.
DC5050 must be sanded before recoating with primer, color or clear.



Grade Wet: European P800-P1200 / US 500-600

Grade Wet: 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.

RTS Combinations

DC5050 : DCH30XX :
DT15XX

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SL814

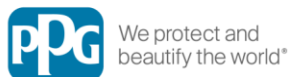
Volume Ratio	3 : 1 : 1	2 : 1 : 1 : 1
VOC Actual (g/L)	470 - 475	492 - 496
VOC Actual (lbs./ US gal.)	3.92 - 3.96	4.11 - 4.14
VOC Regulatory (less water, less exempt (g/L)	489 - 492	509 - 513
VOC Regulatory (less water, less exempt (lbs./ US gal.)	4.08 - 4.11	4.25 - 4.28
Density (g/L)	958 - 970	952 - 961
Density (lbs./ US gal)	8 - 8.09	7.95 - 7.96
Solids wt. %	47.8 - 47.9	45.6 - 45.7
Solids vol. %	41.2 - 41.8	39.3 - 39.8
Sq. Ft. Coverage at 1 mil. at 100% transfer efficiency	661 - 670	630 - 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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