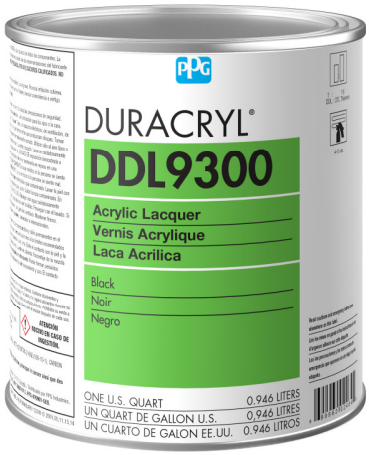


DDL

DDL DURACRYL® is a fast dry acrylic based lacquer system designed for repair of motor vehicles. This repair system is useful in spot or panel repairs as well as overall finishing.

DDL single stage colors can be polished to a full gloss. *Duracryl* basecoat colors have formula comments that tell when clearcoat is required.



Compatible Surfaces

DDL may be applied over:

- Cleaned, sanded and primed OEM finishes
- DPLF Epoxy Primer
- DPX801 Universal Plastic Adhesion Promoter
- DXS1900 Bonding Clear
- DX54 ROADGUARD® Chip Resistant Coating
- DZ KONDAR® Acrylic Primer Surfacer

Required Products

Thinners

DTL10	Cold Temperature Below 50°F (10°C)
DTL16	Cool Temperature 50-65°F (10-18°C)
DTL876	Medium Temperature 65-85°F (18-29°C)
DTL105	Warm/Hot Temperature 85-110°F (29-43°C)
DTX1140	Retarder (over 85°F (29°C) up to 25% of thinner

DDL

Surface Preparation




DDL colors are designed to be applied over properly cleaned, sanded and primed surfaces.

- Wash painted surfaces thoroughly with soap and water to removed water-soluble contaminants, then clean with the appropriate PPG cleaner.
- Sand with 320 grit sandpaper or equivalent. Note: When doing a spot repair, sand with 1200 grit, 12 inches beyond where color will end. Re-clean and apply DSX1900 to the sanded area.
- Re-clean with the appropriate PPG cleaner.
- Prime or seal as needed.

Mix Ratio:



Standard Option

DDL Color	:	DTL Thinner
1	:	1½



Pot Life: None

Additives:



DX73 Fisheye Eliminator: up to 0.5 oz. to RTS quart.

Silicone additives should never be used unless absolutely necessary because the flow-out of paint is decreased in direct relation to the amount used.

Air Pressure and 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 spraygun manufacturer's recommendations for inlet air pressures.

Application:



Apply: 4-6 coats or to hiding for Single Stage
2-4 coats or until hiding for Basecoats

Film build per wet coat: 2.0-3.0 mils
Dry film build per coat: 0.4-0.5 mils

DDL

Drying Times:



Between Coats:

5-10 minutes at 70°F (21°C)

Reduced DCA468 may be added to reduced DDL for blending out.

Note: To avoid the risk of crazing it is best to apply all coats of lacquer in the same day.



Air Dry:

Dust Free: 5-10 minutes at 70°F (21°C)
Tape Time: 1-2 hours at 70°F (21°C)

Allow final coat of color to dry 30 minutes but no longer than 24 hours before clearcoating.



Force Dry:

Purge: 5-10 minutes at 70°F (21°C)
Bake: 40 minutes at 140°F (60°C)



Polishing:

Air Dry: After overnight dry at 70°F (21°C)

Force Dry: After cool down



Recoat and Repair:

Recoat: Recoat after force dry and cool down or 30 minutes air dry 70°F (21°C).

Repair: Repair after force dry and cool down or 30 minutes air dry 70°F (21°C).

After 24 hours the DDL Color must be sanded and additional color applied.



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.

Compatible Clearcoats:

May be clearcoated with:

DCA468	*Duracryl* Hi-Performance Clear
DAU75	DELCLEAR® Acrylic Urethane Clear

DCA468 *Duracryl* Hi-Performance Clear is required over basecoat *Duracryl* and is optional over single stage *Duracryl.*

Equipment Cleaning:

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

DDL

Technical Data:

DDL (color)* & DCA468*	
VOC Package:	4.8-6.0 lbs./ US Gal. (575-720 g/L)
VOC RTS (1:1½):	5.9-6.7 lbs./ US Gal. (707-803 g/L)
Total Solids by Volume RTS:	7.0-12.0%
Total Solids by Weight RTS:	13.4-26.0%
Recommended dry film after polishing:	1.8-3.0 mils for Single Stage color
	0.5-2.0 mils for Basecoat color (must be clearcoated)
	2.0-3.0 mils for DCA468 Clearcoat
Sq. ft. Coverage/US Gallon	
(1 mil at 100% transfer efficiency):	112-192

****Lacquer systems only allowed where exempted under the US national rule. Local and state regulations may supersede national rule exemptions and restrict use. If in doubt consult applicable regulatory text.***

See Material 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

Materials described are designed for application by professional, trained personnel using proper equipment and are not intended for sale to the public. Products mentioned may be hazardous and should only be used according to direction, while observing precautions and warning statements listed on label. Statements and methods described are based upon the best information and practices known to PPG Industries. Procedures for applications mentioned are suggestions only and are not to be construed as representations or warranties as to performance, results, or fitness for any intended use, nor does PPG Industries warrant freedom from patent infringement in the use of any formula or process set forth herein.

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

PPG Automotive Refinish
Bringing innovation to the surface.™

The *PPG* Logo, *Bringing innovation to the surface, Duracryl, Roadguard, Delclear,* and *Kondar* are trademarks of PPG Industries Ohio, Inc.
© 2015 PPG Industries, Inc. All rights reserved.