

DELSTAR® / DELTHANE® Polyurethane Acrylic Enamel

P-137

DAR

The DELSTAR® / DELTHANE® Ultra (DAR/DXR80) Polyurethane Acrylic Enamel system is a single stage system designed for panel repair, overall refinishing or as a fleet finish. It resists the elements and retains color and gloss.

Delstar / Delthane provides more durability and depth of gloss than the enamels of the past. When repairing or refinishing older vehicles, *Delstar / Delthane* can provide the texture and color of their original finishes.



Compatible Surfaces

Delstar / Delthane may be applied over

- OEM & Refinish Lacquers
- OEM Basecoat/Clearcoat
- OEM Enamels
- DPLF Epoxy Primer
- DELTRON® Self Etching Primers
- *Deltron* Plastics Adhesion Promoter
- *Deltron* Primer Surfacer and Sealers
- DZ KONDAR® Acrylic Primer Surfacer
- DX54 ROADGUARD® Chip Resistant Coating
- ONECHOICE® Plastic Adhesion Promoters
- *OneChoice* Primer Surfacer and Sealers

Required Products

Hardeners

DXR80 *Delthane* Ultra Urethane Hardener

DU5 Urethane Hardener

Acrylic Enamel Reducers

DTR600 Fast 65°F (18°C) and below

DTR601 Moderate Temperature 60-75°F (16-24°C)

DTR602 Medium Temperature 70-90°F (21-31°C)

DTR604 Hot Temperature 85°F (29°C) and above

DTR607 Retarder (may be used in place of up to 25% of the reducer in higher temperatures)

DAR

Surface Preparation:



DAR 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 280 grit sandpaper or equivalent.
- Re-Clean with the appropriate PPG cleaner.
- Prime or seal as needed.

Mix Ratio:



Standard Option

Reduce *Delstar* with the DTR Reducer best suited for shop conditions and add *Delthane* DXR80 Hardener using the following ratio:

DAR Color	:	DXR80	:	DTR Reducer
8	:	1	:	3



DU5 Option

DU5 may be used for fast dry and better buffing:

DAR Color	:	DU5	:	DTR or DT* Reducer
4	:	1	:	1

*DT Reducers may only be used with DU5 and only with the 4:1:1 ratio.



Pot Life: 8 hours at 70°F (21°C) for 8:1:3 mixture
8 hours at 70°F (21°C) for 4:1:1 mixture

Additives:



DX814 Universal Flexibilizer:

DAR Color	:	DXR80	:	DX814	:	DTR Reducer
8	:	1	:	2	:	4

DU5 may be used for fast dry and better buffing



Pot Life: 8 hours at 70°F (21°C) for 8:1:2:4 mixture

DX84 Accelerator: 0.5 oz. per RTS quart

DXR81 Accelerator: 0.5 oz. per RTS quart

DX87 Extender: 0.5 oz. per RTS quart

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

DAR color may be tinted up to 10% with DMR or another DAR color.

Air Pressure and Spraygun Set-Up:



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.

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Application:



Apply: 2-3 full wet coats or until proper color is achieved



Spray Viscosity: 20-29 seconds #2 Zahn

Dry film build per coat: 1.2-1.4 mils

Drying Times:



Between Coats:

w/DXR80

15-20 minutes at 70°F (21°C)

w/DU5

5-10 minutes at 70°F (21°C)



Air Dry:

Dust Free: 40-50 minutes at 70°F (21°C)

20-30 minutes at 70°F (21°C)

Tape Free: 6-8 hours at 70°F (21°C)

6-8 hours at 70°F (21°C)



Force Dry:

Purge Time: 0-10 minutes at 70°F (21°C)

Bake: 40 minutes at 140°F (60°C)



IR:

Medium Wave: 10-15 minutes depending on color

Short Wave: 7-9 minutes depending on color

Blending:

Option 1: A two gun system is recommended when performing a spot repair. After each coat of color, mist the overspray edge with the second gun containing DX840. **DO NOT** over wet the edge.

Option 2: Delstar Color may also be blended by mixing the RTS color in your gun cup with an equal amount of DX840. Apply this "over" reduced material to the dry edges. If additional blending is necessary, reduce the blend mixture with another equal part of DX840.

Polishing:



After 24 hours at 70°F (21°C) solid colors can be sanded with 1200-2000 grit sandpaper and compounded. In all cases, use a fine compound and polishing pad.

Recoat:



Recoat: After force dry and cool down or 4 hours air dry at 70°F (21°C)

Put in service: Overnight at 70°F or 8 hours after bake

Clearcoating:

If desired, a clearcoat can be applied to provide additional long term durability or wet-look appearance. The recommended clears are:

DCU2002	CONCEPT® Urethane Clear
DCU2021	Concept Urethane Clear
DCU2042	Low VOC Speed Clear
DC3000	Deltron High Velocity Clear

Note: The color must dry a minimum of 4 hours before clearcoating.

Equipment Cleaning:

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

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Technical Data:	DAR	
	VOC Package	4.75 maximum lbs./ US Gal.
	VOC RTS	5.0 maximum lbs./ US Gal.
	Total Solids by Volume (RTS)	31-38%
	Total Solids by Weight (RTS)	38.2-53.0
	Sq. Ft. Coverage / US Gallon	
	(1 mil at 100% transfer efficiency)	500-600
	Recommended dry film	2-3 mils

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

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