

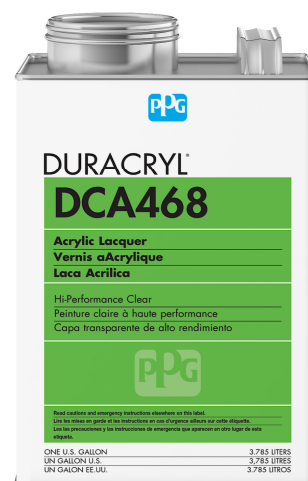


DURACRYL® Hi-Performance Clear

P-248

# DCA468

DCA468 DURACRYL® Hi-Performance Clear is a clearcoat that has been formulated for use with *Duracryl* DDL Basecoat Lacquer and Single Stage.



## Compatible Surfaces

DCA468 may be applied over:

- *Duracryl* DDL Basecoat Lacquer
- *Duracryl* Single Stage

## 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)

## DCA468

Surface  
Preparation

Refer to DDL *Duracryl* Single Stage and Basecoat Lacquer product bulletin (P-148) for the specific application, dry times, and blend recommendations.

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

Allow the final coat of color to dry 30 minutes but no longer than 24 hours before applying DCA468.

## Mix Ratio:



DCA468	:	DTL Thinner
1	:	2

**Note:** Reduced DCA468 may be added to reduced DDL for Blending Out.



**Pot Life:** Indefinite

## Additives:



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

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:** 3-4 coats

**Film build per dry coat:** 0.4-0.5 mils dry

## Drying Times:



**Between Coats:** 5-10 minutes at 70°F (21°C)

**Dust:** 5-10 minutes at 70°F (21°C)

**Tape:** 1-2 hours at 70°F (21°C)



**Air Dry:** 12-16 hours or overnight at 70°F (21°C)



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



**IR (Infrared):** N/A



**Polishing:**  
**Air Dry:** Overnight  
**Force Dry:** After cool down

DCA468 must be polished to a full gloss.

# DCA468

## Recoat and Repair:



### Recoat and Repair:

#### Recoat:

After force dry and cool down or 24 hours air dry  
70°F (21°C).

#### Repair:

After force dry and cool down or 24 hours air dry  
70°F (21°C)

After 3 days DCA468 must be dry sanded prior to recoating.



**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.

## 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:

Ready To Spray (1:2) VOC Less Water Less Exempts: 6.00-6.31 lbs./gal  
Ready To Spray (1:2) VOC Less Water Less Exempts (719-756 g/L)  
Total Solids by Weight (RTS): 12.4%  
Total Solids by Volume (RTS): 9.4%

Sq. Ft. Coverage / US Gallon (RTS)/ 100% Transfer Efficiency @1 mil: 150  
Recommended Film Build: 2 mils dry after sanding and polishing

### 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:  

## PPG Automotive Refinish

Bringing innovation to the surface.™

The PPG Logo, Bringing innovation to the surface and Duracryl are trademarks of PPG Industries Ohio, Inc.

© 2015 PPG Industries, Inc. All rights reserved.

Product Information Effective 6/15

