

Deltron

FLEXED “N” FLAT™ Clear

P-217

DCU2060

DCU2060 FLEXED “N’ FLAT™ Clear offers a pre-flattened and pre-flexed clear coat in one product. It can be used with a variety of PPG clears to achieve increased gloss levels if desired.



Features & Benefits

- One product to flatten and flex
- Air dry or bake
- Easy mixing
- Fits many conditions

Compatible Surfaces

DCU2060 may be applied over:

- DELTRON® 2000 (DBC) Basecoat
- *Deltron* (DBU) Universal Basecoat
- CONCEPT® (DCC) Acrylic Urethane
- ENVIROBASE® High Performance (EHP)

Required Products

Hardeners

DCX9	High Solids Hardener Hot Temperature/Force Dry
DCX61	High Solids Hardener General Purpose
DCH3070	Low Temperature Hardener
DCH3085	Medium Temperature Hardener
DCH3095	Hi Temperature Hardener

Reducers

DT860	Cool Temperature Reducer 60-70°F (16-21°C)
DT870	Medium Temperature Reducer 65-80°F (18-27°C)
DT885	Warm Temperature Reducer 75-90°F (24-32°C)
DT895	Hot Temperature Reducer 85°F (29°C) and above
DT898	Hot Temperature Reducer 85°F (29°C) and above

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Surface Preparation: Refer to the Product Information Bulletin of the color system for its application, dry times, and blend recommendations.

Mix Ratio:



DCU2060	:	DCX9 or DCX61	:	DT Reducer
6	:	1	:	1



Pot Life: 2 hours at 70°F (21°C)

Note: For optimum performance and to maintain consistent gloss levels, mixed product should be thoroughly agitated and kept agitated periodically during the application.

* To achieve higher gloss finishes, blend DCU2060 with the clears listed on the tables found below. The blend must then be mixed using the blended ratio following the tables:

DCU2060 Blending by Weight:

	DCU Clear	Hardener/ Activator	Gloss	Parts by Weight of DCU2060	Parts by Weight of DCU/DC Clear	RTS VOC Less Water, Less Exempts lbs./gal (g/L)
Eggshell (20%-30% Gloss)	2002, 2021, 2042, 2082	DCX9	Eggshell	90	10	4.91 (588)
	2002, 2021, 2042, 2082	DCX61	Eggshell	95	5	4.95 (593)
	DC3000	DCH30xx	Eggshell	92	8	5.14 (616)
	DC4000	DCH30xx	Eggshell	92	8	5.16 (618)
Semigloss (50%60% Gloss)	2002, 2021, 2042, 2082	DCX9	Semi gloss	80	20	4.83 (579)
	2002, 2021, 2042, 2082	DCX61	Semi gloss	85	15	4.87 (584)
	DC3000	DCH30xx	Semi gloss	84	16	5.09 (610)
	DC4000	DCH30xx	Semi gloss	90	10	5.09 (610)

DCU2060 Blending by Volume:

	DCU Clear	Hardener/ Activator	Gloss	Parts by Volume of DCU2060	Parts by Volume of DCU/DC Clear	RTS VOC Less Water, Less Exempts lbs./gal (g/L)
Eggshell (20%-30% Gloss)	2002, 2021, 2042, 2082	DCX9	Eggshell	9½	1	4.91 (588)
	2002, 2021, 2042, 2082	DCX61	Eggshell	10	½	4.95 (593)
	DC3000	DCH30xx	Eggshell	7⅓	⅔	5.14 (616)
	DC4000	DCH30xx	Eggshell	7	¼	5.16 (618)
Semigloss (50%60% Gloss)	2002, 2021, 2042, 2082	DCX9	Semi gloss	8½	2	4.83 (579)
	2002, 2021, 2042, 2082	DCX61	Semi gloss	9	1½	4.87 (584)
	DC3000	DCH30xx	Semi gloss	6⅔	1⅓	5.09 (610)
	DC4000	DCH30xx	Semi gloss	6½	¾	5.09 (610)

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Mix Ratio:

Blended DCU2060/DCU or DC Clear	:	Appropriate Hardener for Chosen DCU or DC Clear	:	DT Reducer
4	:	1	:	1

Pot Life: 4-5 hours at 70°F (21°C)

Additives:

SL84 Accelerator: up to 0.5 oz. RTS per quart
SL87 Extender: up to 0.5 oz. RTS per quart*

***DO NOT USE IN** DC3000, DC3010, DC4000 and DC4010.
DCU2060 **cannot** be tinted

Application:

Apply: 2 coats

Total Recommended Dry Film: 2.0-2.5 mils

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.

Drying Times:

Between Coats: 5-10 minutes

Dust: 10-15 minutes at 70°F (21°C)
Tape: 6-7 hours at 70°F (21°C)

Air Dry: 8 hours at 70°F (21°C)

Force Dry:
Purge: 0-15 minutes
Bake: 15-20 minutes

IR:
Medium Wave: 5 minutes half bake, 9 minutes full
Short Wave: 5 minutes

Polishing: Buffing or polishing *Flexed "N" Flat* clear **is not** recommended as it will raise the gloss level.

Recoat and Repair:
Recoat: Recoat after force dry and cool down or 4-6 hours at 70°F (21°C)

Repair: Repair after force dry and cool down or 6-8 hours at 70°F (21°C)

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.

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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:

RTS (6:1:1)

VOC less exempt solvents (RTS) lbs./ US gal.	5.07
Total Solids by Weight (RTS)	36.7%
Total Solids by Volume (RTS)	29.4%
Sq. Ft. Coverage Per US Gallon (Applied (RTS) (1 mil at 100% transfer efficiency)	471

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.

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