

**Deltron® Velocity Premium Clearcoat LV**

# DC4010

DC4010 is a high velocity, premium clearcoat, specifically developed to enhance productivity in air-dry and low bake collision repair facilities.

Deltron® DC4010 high velocity premium clearcoat offers ease of application, outstanding flow and leveling, superior clarity and a deep rich gloss. DC4010 is extremely versatile and can be used for multi-panel and overall refinishing.

While offering good air-dry performance, DC4010 is best suited for low bake or force dry conditions. DC4010 has an extremely short bake cycle, which reduces in-booth time, energy cost and can improve paint shop productivity.

DC4010 is designed to meet the most stringent VOC laws in Southern California.



**Features**

- Low temperature, fast bake
- Easy application

**Advantages**

- Process time savings
- Less rework

**Benefits**

- Customer satisfaction

**Compatible Surfaces**

**DC4010 may be applied over:**

- *DELTRON*® (DBU) Universal Basecoat
- *DELTRON*® 2000 (DBC) Basecoat

**Required Products**

	<b>Hardener</b>
Low Temperature	DCH3610 (55° – 75°F / 13° – 24°C)
Medium Temperature	DCH3620 (75° – 95°F / 24° – 35°C)
High Temperature	DCH3630 (95°F & above / 35°C & above)

# DC4010

## Directions for Use

### Preparation:

Where VOC limits allow a maximum of 3.5 lbs./US Gal. for multi-stage systems, reduce DBU Color 100% with DRR Reducer or DBC Color 100% with DT Reducer. Refer to the Product Information Bulletin of the color system for its application, dry times, and blend recommendations. (See P-175CA for DBC and P-152 for DBU Color).

### Mixing Ratio:



#### Standard Mix

DC4010 : DCH3610/DCH3620/DCH3630  
4 : 1



Pot life is 2½ – 3 hours at 70°F (21°C) for standard mix

### Additives:



#### With DX814 Flexibilizer

DC4010 : DCH3610/DCH3620/DCH3630 : DX814  
3 : 1 : ½

### Application:



Apply: 2 wet coats

### Air Pressure:

HVLP: 10 PSI at the air cap  
Conventional: 45 – 55 PSI at the gun

### Spraygun Set-up:



Fluid Tip: 1.3 – 1.5 mm or equivalent  
Film build per wet coat: 3.0 – 3.5 mils  
Dried film build per coat: 1.2 – 1.4 mils

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### Drying times:



Between coats:	5 – 7 minutes
Dust-free: 70°F / 21°C	15 – 25 minutes
Tack Free: 70°F / 21°C	30 – 45 minutes
Tape Time: 70°F / 21°C	12 – 16 hours



Air Dry: 70°F / 21°C	4 – 6 hours
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Force Dry:	None
Purge	10 minutes @140°F (60°C)
Bake w/DCH3610	20 minutes @140°F (60°C)
Bake w/DCH3620 or DCH3630	



IR (Infrared):	5 minutes half bake, 10 minutes full
Medium wave	5 minutes
Short wave	



Polishing:	4 – 6 hours @ 70° F (21°C)
Air Dry	Immediately after cool down
Force Dry	DC4010 can be lightly sanded with 1500 – 2000 grit sandpaper and compounded. Use a foam pad with a minor cutting compound to remove any minor imperfections.
Repair and Recoat:	Recoat after force dry and cooling cycle or 4 – 6 hours air dry 70°F (21°C). Repair after force dry and cooling cycle or 4 – 6 hours air dry 70°F (21°C). DC4010 must be sanded before recoating with primer, color or clear.



Repair and Recoat:

**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.

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**Technical Data:**

<b>RTS Combinations:</b>	<b>DC4010 : DCH36XX</b>	<b>DC4010 : DCH36XX : DX814</b>
Volume Ratio:	4:1	3:1:1/2
Applicable Use Category	Clear Coating	Clear Coating
VOC Actual	129 (g/L) 1.08 (lbs/gal)	178 (g/L) 1.49 (lbs/gal)
VOC Regulatory (less water less exempt)	244 (g/L) 2.04 (lbs/gal)	297 (g/L) 2.48 (lbs/gal)
Density	1100 (g/L) 9.18 (lbs/gal)	1083 (g/L) 9.04 (lbs/gal)
Volatiles wt. %	60.8	59.2
Water wt. %	0.0	0.0
Exempt wt. %	49.0	42.7
Water vol. %	0.0	0.0
Exempt vol. %	46.7	40.0
Solids vol. %	38.2	39.4
Sq Ft. Coverage / U.S.gal. (1 mil. @ 100% transfer efficiency)	613	632

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**Resistance Testing:**

Treated steel panels used for evaluation were primed with Original Equipment *UNIPRIME®*, *DELTRON®* Sealer and topcoated with *DELTRON®* Basecoat prior to DC4010 Clearcoat. All resistance results were obtained after DC4010 Clearcoat had been allowed to dry approximately 72 hours at moderate temperatures (70°F/21°C).

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**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.

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**See Material Safety Data Sheet and Labels for additional safety information and handling instructions.**

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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 general public. Products mentioned may be hazardous and should only be used according to directions, 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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