



DELTRON[®]



GLOBAL REFINISH SYSTEM[™]

Product Information

DC527

DC527

SprintCLEAR

With LV

PRODUCTS

Deltron Clear	DC527
Envirobase UHS Hardener	LVH-320
Envirobase Thinners	LVT-405, LVT-410, LVT-420, LVT-440, LVT-444
Deltron DG Fade-out Thinner	DT880 or SXA-860 Aerosol Blending Thinner

Product Description

Deltron DC527 SprintCLEAR is a premium quality High Solids polyurethane clearcoat specifically formulated to give an optimum cure while retaining excellent gloss and durability when low-baked for 15 minutes. DC527 can be used in a single visit or a conventional 2 coat mode. By utilising the single visit mode and 15 minute low bake makes this clearcoat the perfect solution for highly productive body shops.

DC527 SprintCLEAR can be easily polished after suitable baking or air drying conditions.



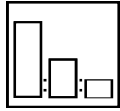
Preparation of Substrate

- Deltron DC527 Clear must be applied on top of a clean and dust-free PPG basecoat (the use of a clean tack rag is recommended to remove dust from the basecoat film).
- Fully cured PPG refinish clearcoats that have been degreased and sanded.
- Sound OEM clearcoats that have been degreased and sanded.

Substrates other than those stated should be tested before use, to ensure that the performance of the product is suitable for its intended use.

Application Guide

Mixing Ratio



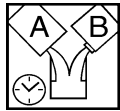
DC527	4 vols
LVH-320	1 vol
Thinner - single visit mode*	1 vol
Thinner – 2 coat mode*	1 vol (no accelerator)

*Choose Thinner according to application temperature and the size of the area being painted

Temperature range	Number of panels	Hardener	Thinner
Up to 18°C	1 panel	LVH-320	LVT-444 or mix below
18°C – 25°C	2-3 panels		LVT-440/LVT-410
Over 25°C	Over 3 panels		LVT-440/LVT-405

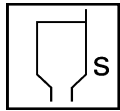
For exceptional conditions of temperature and humidity (>35°C and >70%) the use of Extra Slow Thinner LVT-405 is recommended.

Potlife



1 hour at 20°C

Spray Viscosity



13 – 15 secs DIN4 at 20°C

Spraygun Setup



1.3 – 1.4 mm

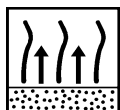
Spray Pressure	HVLP / RP	2 – 2.2 bar
	Conventional	30 – 45 PSI / 200-300 KPA

Number of Coats



Single visit mode	1 light coat followed directly by 1 full coat
2 coat mode	1 medium coat (Flash off) 1 full wet coat

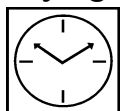
Flash Off at 20°C



Between coats	3 -5 minutes
Before Baking	Bake immediately

Application Guide

Drying Times



Dust-free	15 minutes
Air Dry to handle 20°C	6 hours minimum
Air Through-dry 20°C	20 hours



Bake Through-dry 65°C	15 minutes
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IR Short wave	10–15 minutes depending on colour
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* Bake times are for quoted metal temperature. Additional time should be allowed in the baking schedule to allow metal to reach recommended temperature.

* Use slow thinner (LVT-410) when curing with IR equipment.

Technical Data

Total Dry Film Build

Minimum	50 µm
Maximum	60 µm

Theoretical Coverage* 7–7.5 m²/L

* Theoretical coverage in m²/L ready-to-spray, giving 50 µm dry film thickness.

Flash Points

LVH-320,	See PPG MSDS
LVT-Thinners,	See PPG MSDS

Overcoat/Recoat Time



Sanding:	Essential before recoating to ensure good adhesion P500 (dry) P800 (wet) P800 (dry) if re-clearing / flowcoating
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Overcoat / recoat time:

- Force dry 60°C or IR	After cooling
- Air dry at 20°C	Minimum 12 hours

Overcoat/Repair with:

Any PPG 2K primer or Deltron topcoat.



POLISHING

*Low bake or IR force
drying:*

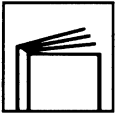
Air drying at 20°C:

Minimum 30 minutes after cooling

Minimum 10 hours after application

EQUIPMENT CLEANING

After use, clean all equipment thoroughly with cleaning solvent or thinner.



HEALTH AND SAFETY

Please refer to Material Safety Data Sheets for full Health and Safety details and product can labels.

- Global Hardeners and activated DC527 contain isocyanate and therefore particular safety precautions must be taken.
- Goggles must be worn when mixing and using to prevent accidental splashing into the eye. If contact occurs with eyes give prolonged irrigation with water and get medical attention immediately.
- Good ventilation and extraction must be provided in the working environment.
- Wear suitable protective equipment to prevent skin contact with this material.
- When spraying this product the operator (and persons in vicinity) must wear suitable air-fed breathing apparatus.
- Do not smoke whilst using this material.

This product is for professional use only.

The information given in this sheet is for guidance only. Any person using the product without first making further inquiries as to the suitability of the product for the intended purpose does so at his own risk and we can accept no liability for the performance of the product or for any loss or damage (other than death or personal injury resulting from our negligence) arising out of such use. The information contained in this sheet is liable to modification from time to time in the light of experience and our policy of continuous product development.

Drying times quoted are average times at 20°C/68°F. Film thickness, humidity and shop temperature can all affect drying times.



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