



DELTRON®



Product Information

DELTRON DG with LVH-320

Direct Gloss 2-Pack Acrylic Colour

Tinter line number – 401

Mixed colour line number - 402

PRODUCTS

Deltron Direct Gloss Tinters	D7xx
UHS Hardener	LVH-320
Thinners	LVT-405, LVT-410, LVT-420, LVT-430, LVT-440, LVT-444
Deltron DG Fade-out Thinner	DT880 or SXA-860 Aerosol Blending Thinner

For painting of very flexible substrates:

Deltron Flexibiliser	DA210
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PRODUCT DESCRIPTION

Deltron DG is a high-performance two-pack acrylic urethane topcoat designed for the direct gloss repair and respray of all motor vehicles.

The performance of Deltron DG in a recommended PPG repair system meets or exceeds motor manufacturer warranty requirements and the Deltron system carries many OEM approvals.

PREPARATION OF SUBSTRATE



SUBSTRATE

PPG 2K primers
Electrocoat
Sound 2K finishes
TPA

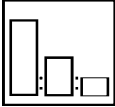
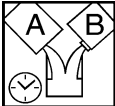
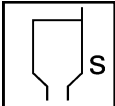


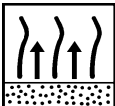


PREPARATION

P600 - wet / P400 - dry
Pre-prime - Do not topcoat direct
P600 - wet / P400 - dry
Must be sealed (e.g. DP614)

Before and after any sanding operation, the substrate must be thoroughly degreased using SWX250 followed by D845 or D837. Use D837 only prior to any painting.

Application Guide

		MS System	Accelerated System
Mixing Ratio			
		DG LVH-320 LVT-4XX**	4 vols 1 vol 1.5 vol*
			DG Hardener Thinner
			4 vol 1 vol 1.5 vol
* Choose MS Hardener and Thinner according to application temperature and the size of the area being painted (see section 3 of the product manual)			
		<i>Hardener</i>	<i>Thinner</i>
Up to 18°C		LVH-320	LVT-430
18°C – 25°C			LVT-420
Over 25°C			LVT-410
		<i>Hardener</i>	<i>Thinner</i>
		LVH-320	LVT-444
For exceptional conditions of temperature and humidity (>35°C and >70%) the use of Extra Slow Thinner LVT-405 is recommended.			
LVT-440 and LVT-410 can also be used 50/50 as an Accelerated System.			
** All mix ratios are available RFU on paint manager			
Potlife			
		1 hour at 20°C	1 hours at 20°C
Spray Viscosity			
		16 – 19 secs DIN4 at 20°C	16-19 secs DIN4 at 20°C
Spraygun Setup			
		1.2 – 1.3 – 1.4mm or equivalent	
Spray Pressure	<i>HVLP / RP</i>	2 – 2.2 bar	
	<i>Conventional</i>	45 – 55 PSI / 300-380 KPA	
Number of Coats			
	<i>Standard mode:</i>	Apply 2 full wet coats	
	<i>Express mode:</i>	Apply 1 medium & 1 full wet coat	
Flash Off at 20°C			
	<i>Between coats</i>	5 minutes	0 – 2 minutes
	<i>Before stoving</i>	Bake immediately	Bake immediately

Application Guide

MS System

Accelerated System

Drying Times**



Dust-free
20°C dry to handle
Through-dry 20°C

30 minutes
4 hours minimum
20 hours

10 minutes
3 hours
5 hours



Through-dry 60°C

25 minutes*

15 minutes*



IR Short Wave

12-15 minutes
depending on colour

8–12 minutes
depending on colour

* Bake times are for quoted metal temperature. Additional time should be allowed in the baking schedule to allow metal to reach recommended temperature.

Technical Data

Total Dry Film Build

Minimum	50 µm
Maximum	60 µm
	6–7 m ² /L

Theoretical Coverage*

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

Flash Points

DG Colour, LVH-320	See PPG MSDS
Hardener	
LVT-Thinners	See PPG MSDS

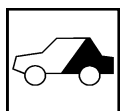
Sanding



Grade wet
Grade dry

Essential before recoating to ensure good adhesion.
P600
P500

Overcoat/Recoat Time



After surface has cooled if baked, or after 8 hours minimum at 20°C.
Recoat times will be extended at lower temperatures.

Overcoat with

Any PPG 2K primer or Global topcoat.



POLISHING

*Low bake or IR force
drying:*

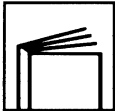
Air drying at 20°C:

After cooling

Minimum 12 hours after application

EQUIPMENT CLEANING

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



HEALTH AND SAFETY

Health and Safety

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

- Global Hardeners and activated DG Colour 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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