



DELTRON®



Product Information

Deltron DG

Direct Gloss 2-Pack Acrylic Colour

Tinter line number – 401

Mixed colour line number - 402

PRODUCTS

Deltron Direct Gloss Tinters	D7xx
Deltron Hardeners	DH710, DH720, DH730
Deltron Thinners	DT810, DT820, DT830, DT840
Deltron Accelerator	DT850
Deltron Fade-out Thinner	DT880

For painting of very flexible substrates:

Deltron Flexibilser	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

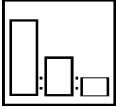
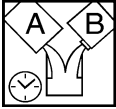
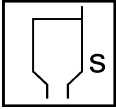


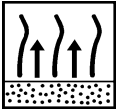


PREPARATION




P600 - wet / P400 - dry
 Pre-prime - Do not topcoat direct
 P600 - wet / P400 - dry
 Must be sealed (e.g. D834)

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

Application Guide

		MS System		Accelerated System	
Mixing Ratio					
		DG	2 vols	DG	2 vol
		Hardener**	1 vol	Hardener	1 vol
		Thinner**	0.5 vol	Thinner	0.5 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>MS Hardener</i>	<i>Thinner</i>	<i>Hardener</i>	<i>Thinner</i>
Up to 18°C		DH710	DT810	DHXXX	DT850
18°C – 25°C		DH720	DT820		
Over 25°C		DH730	DT830		
For exceptional conditions of temperature and humidity (>35°C and >70%) the use of Extra Slow Thinner DT840 is recommended.					
Potlife					
		3 hours at 25°C		1 hours at 25°C	
Spray Viscosity					
		19 – 22secs DIN4 at 25°C		19-22 secs DIN4 at 25°C	
Spraygun Setup					
		1.3 – 1.4 mm or equivalent			
Spray Pressure	HVLP / RP	2 – 3 bar			
	Conventional	45 – 55 PSI / 300-380 KPA			
Number of Coats					
		1 normal, 1 – 2 full			
Flash Off at 25°C					
	<i>Between coats</i>	5-10 minutes		3-5 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	30 minutes*	20 minutes*
	IR medium	10–15 minutes depending on colour	10–15 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
Theoretical Coverage*	6–7 m ² /L

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

Flash Points

DG Colour, DH Hardeners	See PPG MSDS
DT Thinners	See PPG MSDS

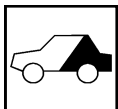
Sanding



Grade wet
Grade dry

Essential before recoating to ensure good adhesion.
P600
P400

Overcoat/Recoat Time



After surface has cooled if baked, or after 8 hours minimum at 25°C.
Recoat times will be extended at lower temperatures.

Overcoat with

Deltron Primers or Deltron topcoat.

PAINTING OF Rigid or FLEXIBLE SUBSTRATES

Please note:

The positioning of some plastic components on motor vehicles, e.g. bumpers, means they are more likely to be subjected to bumps and knocks from outside sources, such as other motor vehicles, gutters, curbs, etc. On soft and or extremely flexible plastics, PPG recommends flexibilising Deltron DG. This process may also improve impact resistance, particularly bumper bars.

To obtain matt finishes it is recommended that D8115 and D8117 are used.

To obtain a textured finish with Deltron DG, it is necessary to include texture additives in the mix. Refer to the Texture Additive data sheet.

Additives are also required when applying Deltron DG over very flexible substrates (typically plastics). The additives required and the appropriate volume and weight mix ratios are indicated in the tables below and **also available on Paint manager.**

Note : **RIGID** substrates include all metals, fibreglass and GRP
FLEXIBLE substrates are all plastic types except GRP

Substrate	Appearance	DG	DA210	DH710	DT820
RIGID	Gloss	2 vol	-	1 vol	0.5 vol
FLEXIBLE	Gloss	3 vol	1 vol	2 vol	0.6 vol



POLISHING

*Low bake or IR force
drying:*

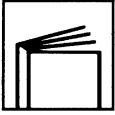
Air drying at 25°C:

Minimum 1 hour after cooling

Minimum 20 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.

- Deltron 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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