

Velocity Premium Clearcoat

P-241

# DC4000

DELTRON® NXT™ DC4000 is a high-velocity, premium clearcoat, specifically developed to enhance productivity in air-dry and bake booth collision repair facilities.

DC4000 is offers ease of application along with excellent gloss and hold out.



**Features & Benefits**

- Short bake
- Easy application
- Process time savings
- Excellent gloss and hold out

**Compatible Surfaces**

DC4000 may be applied over:

- *Deltron* (DBC) Basecoat
- *Deltron NXT* Basecoat
- *Envirobase* High Performance (EHP) Basecoat

**Required Products**

**Hardeners**

- DCH3070 Low Temp Hardener 60-75°F (16-24°C)
- DCH3085 Medium Temp Hardener 75-95°F (24-35°C)
- DCH3095 Hi Temp Hardener 95°F (35°C) and above
- DCH3098 Ultra Hi Temp Hardener 95°F (35°C) and above

**Surface Preparation:**



- Wash all surfaces to be painted with soap and water, then apply the appropriate ONECHOICE® or *Deltron NXT* cleaner. Ensure the substrate is thoroughly cleaned and dried both before and after application work.



- Wet sand with US 500-600 / European P800-P1200 grade paper or dry sand with US 400-500 / European P600-P800 grade paper.



- Wash off residue and dry thoroughly before recleaning with appropriate cleaner. The use of a SX1070 *OneChoice* tack rag is recommended.

- Refer to the Product Information Bulletin of the color system for its application, dry times, and blend recommendations

## Mix Ratio & Pot Life:



Standard Mix:

DC4000 : DCH30xx Hardener  
4 : 1

Mixing DC4000 as a Cut-in Clear:

Add 1 part DBC/NXT Color to 1 part DC4000 then:



DBC/NXT/DC4000 Mix : DCH30xx Hardener : DT Reducer  
4 : 1 : 1/2

**Note:** Cut-in clear method can only be done using a solventborne basecoat. Do not mix with ENVIROBASE® High Performance products.



**Pot Life :** 1½-2 hours at 70°F (21°C)

## Additives:



**SL814 Universal Flexibilizer:**

DC4000 : DCH30xx : SL814  
3 : 1 : 1/2

**SU4985 Universal Matting Agent** See *OneChoice* bulletin OC-2

## Air Pressure & Spray 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 spray gun manufacturer's recommendations for inlet air pressures.

*Refer to Document DOX44NXT for optimized gun setting for the most popular spray guns in the field.*

## Application:



**Apply:** 2 wet coats  
**Total recommended dry film:** 2.0-2.5 mils

## Drying Times:



**Between Coats:** 5-7 minutes at 70°F (21°C)  
**Dust Free:** 15-25 minutes at 70°F (21°C)  
**Tape Time:** 12-16 hours at 70°F (21°C)



**Air Dry:** 4-6 hours at 70°F (21°C)



**Force Dry:**  
**Purge:** None  
**DCH3070:** 10 minutes at 140°F (60°C)  
**DCH3085/3095/3098:** 20 minutes at 140°F (60°C)



**IR (Infrared):**  
**Medium Wave:** 5 minutes half bake, 9 minutes full  
**Short Wave:** 5 minutes

## Polishing:



**Air Dry:** 4-6 hours at 70°F (21°C)

**Force Dry:** After cool down



DC4000 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.

## Overcoat / Recoat:



### Recoat and Repair:

#### Recoat:

Recoat after force dry and cool down or 4-6 hours air dry 70°F (21°C).



DC4000 must be sanded before recoating with primer, color or Clear.

#### Repair:

Repair after force dry and cool down or 4-6 hours air dry 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

## 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:

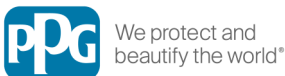
VOC less exempt solvents (Applied 4:1)	4.11 lbs./gal. (492 g/L)
VOC less exempt solvents as a Cut-in Clear (Applied 4:1:1/2)	5.03 lbs./gal. (603 g/L)
VOC less exempt solvents w. SL814 (Applied 3:1:1/2)	4.17 lbs./gal. (500 g/L)
Total Solids by Volume (Applied 4:1)	40.8-41.4%
Total Solids by Weight (Applied 4:1)	47.1-47.4%
Sq. Ft. Coverage / US Gal (Applied 4:1) 1 mil, 100% transfer efficiency	654-664

**See 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

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