

DELTA® Multi-Purpose Blending Clear

DCB100

DCB100 is designed for use with Delta® topcoats to help make invisible spot repairs. This durable clear may be used as a pre-blend clearcoat, as a “step out” clear and as a clearcoat over single stage or basecoat repairs. DCB100 may be used with Delta Basecoats as well as DFHS, DUHS, DVHS and DSS Single Stage topcoats.

Features	Advantages	Benefits
<ul style="list-style-type: none"> Prepares OEM finish to accept repair color 	<ul style="list-style-type: none"> Helps minimize overspray ring 	<ul style="list-style-type: none"> Hides high solids blend edge
<ul style="list-style-type: none"> Adds transparency to repair color 	<ul style="list-style-type: none"> Helps “step-out” repair color to OEM finish 	<ul style="list-style-type: none"> Repair is invisible to customer
<ul style="list-style-type: none"> Protects repair area 	<ul style="list-style-type: none"> Allows polishing and UV protection 	<ul style="list-style-type: none"> Longer-lasting repairs

Compatible Surfaces

DCB100 may be applied over:

- OEM Enamels
- Newly applied Delta topcoats
- Cured Air Dry Finishes
- Cured Delta topcoats

DRS Reducers	
Reducer - Fast (60-70°F)	DRS1460
Reducer - Medium (65-80°F)	DRS1470
Reducer - Slow (75-90°F)	DRS1485
Reducer - Hot Temperature (85°F and above)	DRS1495
Retarder/Reducer	DRS1498
Hardeners	
Urethane Hardener (60-85°F)	DDH525
Urethane Hardener (85°F and above)	DDH526



Mixing Ratio:



DCB100 : DRS Reducer* : DDH525/526
 2 parts : 1 part : 1 part

*Reduce with DRS1460, DRS1470, DRS1485, DRS1495 Reducer, best suited to shop temperatures.

NOTE: Mixing with DDH526 and DRS1485 Reducer and above will extend dry time of the DCB100 to allow for better wet edge control when applying repair color over DBC100.

Pot life:



4 hours @ 70°F and 50% RH
 (High heat and humidity will shorten pot life)

Additives:



Accelerator:	No Recommendation
Extender:	No Recommendation
Fisheye:	No Recommendation
Flex:	No Recommendation
Flattening:	No Recommendation

Spraygun set-up:



Fluid Tip

0.8 - 1.4 mm for Pressure Feed/HVLP
 1.0 - 1.6 mm for Conventional Feed/HVLP

Air Pressure

HVLP at air cap	8-10 PSI
Conventional at spray gun	40-55 PSI

Consult the Fleet Training Manual Spray Equipment Section for gun set-up requirements.

Usage Guide:

As a pre-blending clearcoat:

A pre-blending clearcoat allows repair color to be applied to a wet surface, which helps to "melt in" high solids overspray.

1. Prepare the repaired panel for blending by sanding with 400-500 grit wet or dry sandpaper prior to application of DCB100. Then clean with DX436 Wax and Grease Remover or DX437 Heavy Duty Wax and Grease Remover. DX438 Compliant Cleaner should be used in VOC restricted areas.
2. Apply one medium wet coat of ready to spray DCB100 to entire area to be blended, extending it just past where the blend is expected to end.
3. Allow 10-15 minutes flash time before application of the Delta color.
4. Apply sufficient coats of Delta Basecoats or DFHS, DUHS, DVHS and DSS Single Stage topcoats just to hide the primed area. If a "step out" is required to hide the blend, see next section.

DCB100

As a "step-out" clear:

A "step-out" clear is mixed in equal parts ready to spray DCB100 with the ready-to-spray color to add transparency. This method provides better results than the use of straight reducer when "stepping-out" high solids color.

1. RTS DCB100 : RTS Delta Color
(Delta B/C, DFHS, DUHS, DVHS and DSS)
1 part : 1 part

Starting 2-4 inches out from the freshly-painted repair area, apply 1 wet coat of the DCB100/Delta Color mix, spraying from the outside into the freshly-painted area.

2. Allow 10-15 minutes flash time between coats if more than one coat is required.
3. If additional "step-out" is required, more RTS DCB100 may be added to Step 1 mixture, making it more transparent. Simply, cut a few ounces of the DCB100/color mixture left in the gun 1:1 with additional RTS DCB100.

RTS DCB100/RTS Delta Color : RTS DCB100
(mix left in gun from Step 1)
1 part : 1 part

As a clearcoat:

A clearcoat protects the blend and allows for light compounding of the blend edge.

Note: Repairs with Delta basecoat color must be clearcoated with DCB100 or other Delta clearcoat.

- Allow entire repair and blend area to dry 30 minutes prior to applying a clearcoat.
- Apply 1-2 medium wet coats of DCB100 to entire repair, ending at the edge of the original pre-blend clearcoat. If desired, the entire panel may be clearcoated with DCB100. Melt in any dry spray at the final edge with a fine mist of DRS reducer.
- For optimum performance, PPG recommends clearcoating the entire repaired panel.

Drying times:



Air Dry @ 70°F

Dust 90 minutes
Tack 2.5 hours
Tape 16 hours

Force Dry

40 minutes @ 140°F

Recoat time:

16 hours minimum dry and up to 5 days maximum at 70°F before sanding is required.

Repair time:

16 hours @ 70°F

Polish:

16 hours @ 70°F

TEST PROPERTIES

	DCB100
VOC Packaged lbs. per U.S. gal.	4.2
VOC RTS Applied lbs. per U.S. gal. *(See Note)	4.8
Volume Solids (RTS)	33.3%
Square Foot Coverage (RTS US Gallon 100% Transfer Efficiency)	534 sq. ft. @ 1 mil
Pencil Hardness**	2B

*** Note:** When used as a pre-blend or “step-out” clear, DCB100 meets the requirements as set forth in the definition of a specialty coating.

In some states, VOC limits for commercial vehicle refinishing are lower than the “National Automotive Regulation VOC Limits”. Consult local regulations when using DCB100 as a clearcoat.

** Film properties, including pencil hardness, are given where ultimate air cure is reached, usually 7 days.

Compatible Clearcoats:

DCU2050 Graffiti Resistant Clear
DCU2070 Delta® Urethane Clear

HEALTH AND SAFETY

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

Emergency Medical or Spill Control Information  (4) 843-1300; 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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