DDL DURACRYL® is a fast dry, acrylic based lacquer system designed for repair of motor vehicles. This repair system is useful in spot or section repairs as well as overall finishing.

DDL single stage colors can be polished to a full gloss. DURACRYL® basecoat colors have formula comments that tell when the clearcoat is required.

### Compatible Surfaces

DDL may be applied over:
- Cleaned, sanded and primed OEM or Refinish topcoat
- DPLF Epoxy Primer
- DPX801 Universal Plastic Adhesion Promoter
- DSX1900 Bonding Clear
- DX54 ROADGUARD® Chip Resistant Coating
- DZ Kondar® Acrylic Primer Surfacer

### Required Products

<table>
<thead>
<tr>
<th>Requirement</th>
<th>DTL Thinners</th>
</tr>
</thead>
<tbody>
<tr>
<td>Cold Temperature (below 50°F)</td>
<td>DTL10</td>
</tr>
<tr>
<td>Cool Temperature (50 – 65°F)</td>
<td>DTL16</td>
</tr>
<tr>
<td>Medium Temperature (65 - 85° F)</td>
<td>DTL876</td>
</tr>
<tr>
<td>Warm/Hot Temperatures (85 – 110°F)</td>
<td>DTL105</td>
</tr>
<tr>
<td>Retarder (over 85°F) up to 25% of thinner</td>
<td>DTX114</td>
</tr>
</tbody>
</table>

**Clear**

**DURACRYL® Hi-Performance Clear** DCA468
**Directions for Use**

**Preparation:**
DDL colors are designed to be applied over properly cleaned, sanded and primed surfaces.
- Wash painted surfaces thoroughly with soap and water to remove water-soluble contaminants, then clean with the appropriate PPG Cleaner.
- Sand with 320 grit sandpaper or equivalent. *Note: When doing a spot repair, sand with 1200 grit, 12 inches beyond where color will end. Re-clean and apply DSX1900 to the sanded area.*
- Re-clean with the appropriate PPG Cleaner. Prime or seal as needed.

**Mixing Ratio:**

**Standard Option**

<table>
<thead>
<tr>
<th>DDL Color : DTL Thinner</th>
<th>1 : 1 1/2</th>
</tr>
</thead>
</table>
There is no Pot life for this mixture

**Painting Flexible parts**
Prepare and prime the flexible part with the appropriate flexible primer. Mix color as follows:

| DDL Color : DTL Thinner : DX369 |
|------------------:|:|:|
| 4 : 6 : 1 |

If clear is needed, mix as follows:

| DCA468 : DTL Thinner : DX369 |
|------------------:|:|:|
| 4 : 8 : 1 |

Pot life is 2 hours at 70°F with DX369

**Additives:**

DX73 Fisheye Eliminator, when necessary, can be used in DDL or DCA468 up to 1/2 oz per RTS qt. Surface to be painted must be thoroughly cleaned. *Silicone additives should never be used unless absolutely necessary because the flow-out of paint is decreased in direct relation to the amount used.*

**Application:**

<table>
<thead>
<tr>
<th>Apply:</th>
<th>4 – 6 coats or to hiding for Single Stage</th>
</tr>
</thead>
<tbody>
<tr>
<td>2 – 4 coats or until hiding for Basecoats</td>
<td></td>
</tr>
<tr>
<td>Film build per wet coat</td>
<td>2.0 – 3.0 mils</td>
</tr>
<tr>
<td>Dry film build per coat</td>
<td>0.4 – 0.5 mils</td>
</tr>
</tbody>
</table>

**Air Pressure:**

| HVLP at air cap | 10 PSI |
| Conventional at the gun | 35 - 45 PSI |

**Spray Gun Set-up:**

| Fluid Tip | 1.2 – 1.5 mils |
| Spray Viscosity | 14 – 21 seconds #2 Zahn |
Directions for Use

Drying Times:

- **Between Coats:** 5 – 10 minutes
- **Dust Free:** 5 – 10 minutes
- **Tack Free:** 15 – 30 minutes
- **Tape Free:** 1 – 2 hours
- **Before Clearcoat (If needed):** Allow the final coat of color to dry 30 minutes, but no longer than 24 hours before clearcoating. After 24 hours the DDL Color must be sanded and additional color applied. *See note below.*

**Blending:**
- Reduced DCA468 may be added to reduced DDL for Blending out.

**Polishing DDL:**
- Air dry overnight or bake 40 minutes at 140°F

*Note: To avoid the risk of crazing it is best to apply all coats of lacquer in the same day.*

Clearcoating:

DCA468 *DURACRYL*® Hi-Performance Clear is required over basecoat *DURACRYL*® and is optional over single stage *DURACRYL*®.

Apply 3 – 4 coats using the ratio below:

<table>
<thead>
<tr>
<th>DCA468</th>
<th>DTL Thinner</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>2</td>
</tr>
</tbody>
</table>

DCA468 must be polished to a full gloss

**Blending:**
- Reduced DCA468 may be added to reduced DDL for Blending out.

**Polishing DCA468:**
- Air dry overnight or bake 40 minutes at 140°F

Technical Data:

**DDL**
- VOC (PKG) 4.8 – 6.0 lbs. per US Gal
- VOC (RTS) 5.9 – 6.7 lbs. per US Gal

**DCA468**
- VOC (PKG) 5.1 lbs. per US Gal
- VOC (RTS) 6.2 – 6.5 lbs. per US Gal

- **Total Solids by Volume (RTS):** 7 – 12%
- **Sq. Ft Coverage / US Gal**
  - (1mil @ 100% Transfer Efficiency): 112 - 192
  - Film build per wet coat: 2 – 3 mils
  - Dry film build per coat: 0.4 – 0.5 mils
  - Recommended dry film after polishing: Single stage: 1.8 – 3.0 mils
  - Basecoat color: 0.5 – 2.0 mils (Plus 2 mils of clearcoat)
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.

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

EMERGENCY MEDICAL OR SPILL CONTROL INFORMATION (304) 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.