VB-25NR

DITZLER® Satin Clear *(National Rule)*

DSC5250 *Ditzler* Satin Clear Kit

VC5250 *Ditzler* Satin Clear
VH7250 *Ditzler* Satin Clear Hardener

DITZLER® brand Satin Clear is a low gloss custom clear providing a uniform, low gloss finish. It provides superior mar resistance and outstanding color retention. It can be used on accent stripes, hoods or the entire vehicle.

The DSC5250 *Ditzler* Satin Clear Kit provides a durable two-component low gloss finish with a smooth even appearance.

This bulletin is for use in National Rule refinish markets. For use in low VOC compliant refinish markets, see bulletin VB-25.

For procedures relating to custom and/or restoration work refer to PPG's Custom Restoration Guide available at ppgrefinish.com under Training.

Compatible Products and Systems

VC5250 *Ditzler* Satin Clear can be used over the systems shown below:

- DELTRON® DBC 2000 Refinish System - Follow P-175 *Deltron* DBC recommendation for proper preparation and compatible primers.
- DELTRON® NXT Refinish System - Follow P-251 *Deltron* NXT recommendation for proper preparation and compatible primers.
- ENVIROBASE® High Performance Refinish System - Follow EB-143 *Envirobase* High Performance recommendations for proper preparation and compatible primers.
- VIBRANCE COLLECTION® topcoat systems - Follow specific product bulletin recommendations for proper preparation and compatible undercoats.

Note: Custom or exotic finishes are excluded from coverage under the PPG Paint Performance Guarantee.

Required Products

Hardener

VH7250	*Ditzler* Satin Clear Hardener

Reducer

DT1565	Fast Thinner	55 - 65°F (13 - 18°C)
DT1575	Medium Thinner	65 - 77°F (18 - 25°C)
DT1585	Warm Thinner	77 - 90°F (25 - 32°C)
DT1595	Hot Thinner	over 95°F (32+°C)

DSC5250

Mixing Ratio:

Note: Thoroughly shake VC5250 prior to first use

VC5250	:	VH7250	:	DT15xx
4	:	1	:	1½ - 2

Pot Life: 1 hour at 70°F (21°C)

Air Pressure And Gun Setup:

HVLP: 8 - 10 psi at the air cap
Compliant: 35 - 44 psi at the gun
Gun Setup: 1.2 - 1.4 mm or equivalent

Refer to spraygun manufacturer's recommendations for inlet air pressures.

Application:

Apply: Apply one medium wet coat and allow to flash until matte.
Be sure the first coat has completely flashed before applying the second and final coat.
Apply second coat full wet.

An immediate optional third drop-coat may be applied to ensure a uniform finish.

Dried Film Build Per Coat: 1.0 - 1.5 mils

Note: Variations in temperature and gun set up can affect the final gloss of *Ditzler* Satin Clear. Before spraying the vehicle, it is recommended that a test panel be sprayed to determine the overall final appearance.

Drying Times

Between Coats: 10 - 15 minutes at 70°F (21°C)*

Note: Be sure each coat has completely flashed before applying additional coats.

Air Dry*:
Full Air Dry: 16 - 24 hours / overnight at 70°F (21°C) (preferred)

Force Dry*:
Purge: 45 minutes prior to baking
Bake: 30 minutes at 120°F (49°C)

IR (Infrared):
Not Recommended

Polishing:
Do not wax, buff or polish. When washing is necessary, use a mild soap and dry immediately with a soft cloth or chamois.

Recoat and Repair:
Recoat: After force dry and cool down or air dry for 16 - 24 hours. VC5250 must be lightly sanded with 320 - 400 grit sandpaper before recoating.
Repair: After force dry and cool down or air dry for 16 - 24 hours.

Note: All force dry times are quoted for metal temperature. Additional time must be included during force dry to allow metal to reach recommended metal temperature.

*To achieve optimal mar resistance, it is recommended that after being forced dried, the vehicle should not be put into service for an additional 4 - 6 hours. If air dried, the vehicle should not be put into use for an additional 24 - 48 hours. See care of the low gloss finish on page 3.

DSC5250

Equipment Cleaning: Spray guns, gun cups, storage pots, etc. should be cleaned thoroughly after each use with any approved PPG general purpose solvent.

General Care and Maintenance of the Low Gloss Finish

Low gloss finishes can be relatively easily marked with general handling and day to day use (door/hood/deck lid opening, shoe scuffing on entry or exit of vehicle etc.) care should be taken with these operations because marking or changing of the low gloss effect could result.

Care should be taken to avoid spillage of fuel onto the low gloss finishes. Fuel spills should be removed as soon as possible using the washing guidelines below, to avoid permanent damage or altering of the low gloss effect.

1. In order to keep the low gloss surface effect, the use of paint cleaners, abrasives, polishes or waxes **must** be avoided. The vehicle **must not** be polished. Polishing will lead to a higher, uneven gloss effect.
2. Cleaning with unsuitable materials could alter the low gloss effect (generally increasing gloss).
3. Automated car washing should be avoided. The preferred car washing method is by hand with a soft sponge, mild soap and lots of water. Frequent car washing over a period of time could lead to increased and inconsistent gloss levels across a panel. Washing under direct sunlight should also be avoided.
4. Insects and bird droppings should be removed immediately. These residues should be soaked in water to soften and/or remove carefully with high pressure cleaning equipment. In the case of strongly adhered residues, a spray on insect remover should be used prior to washing.
5. Whenever using any type of cleaning fluids with soft sponges or cloths, it is essential not to apply pressure or rub the low gloss finish. A gentle wipe/spray on, wipe off technique should be used. Applying pressure will alter the low gloss effect and result in an uneven appearance.

Technical Data:

RTS Combinations	VC5250 : VH7250 : DT15xx	VC5250 : VH7250 : DT15xx
Volume Ratio:	4 : 1 : 1½	4 : 1 : 2
Coating Category	Clearcoat	Clearcoat
VOC Actual (g/L)	197 - 292	213 - 332
VOC Actual (lbs./gal.)	1.64 - 2.44	1.78 - 2.77
VOC Regulatory (g/L) (less water, less exempt)	346 - 435	376 - 477
VOC Regulatory (lbs./gal.) (less water, less exempt)	2.89 - 3.63	3.14 - 3.98
Solids wt.%	34.7 - 35.9	32.7 - 33.2
Solids vol.%	32.8	30.4
Sq. Ft. Coverage / US gal. (1 mil. At 100% transfer efficiency)	525	488

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

Materials described are designed for application by professional, trained personnel using proper equipment and are not intended for sale to the public. Products mentioned may be hazardous and should only be used according to direction, 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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