

# DC5775 Ultra Flat Clear

## Application Procedures - Low VOC



### Pre-flexed for use over flexible parts

<b>Products</b>	DC5775 Ultra Flat Clear 851 Prep and Wash 909 Final Wipe AM900 Aero-Max Pre-Kleano DC5800 2.0 CTR Clear	DH99 Low VOC Fast Hardener DH100 Low VOC Hardener RMR15 Low VOC Reducer VR Series Reducers
<b>Cleaning</b>	See Topcoat Section - "Cleaning & Preparing Vehicle for Topcoating" for vehicle prep.	
<b>Topcoating</b>	See Topcoat Section - ONYX HD Basecoat	
<b>Mixing Ratio</b>	<b>Low VOC 2.0</b> <b>4:1:1</b> 4 parts DC5775 1 part DH99 or DH100* 1 part VR Reducer or RMR15	
<b>Application</b>	<b>Low VOC 2.0 Steps</b> 1) Over reduce clear by mixing DC5800 4:1:2 with proper DH hardener (DH99 or DH100) and VR reducer or RMR15. 2) After basecoat has been applied and flashed off completely, apply 2 medium wet coats of DC5800 clearcoat allowing proper flash time between coats. • If possible, use formula found at SmartTrak, SmartColor or www.basrefinish.com. 3) <b>Very Important!</b> Use calibrated scale to mix exact amounts by weight at a ratio of 4:1:1 of DC5775 with proper DH hardener (DH99 or DH100) and VR reducer or RMR15. 4) After 2 <sup>nd</sup> coat of DC5800 is flashed, apply first coat of DC5775 medium wet making sure to apply evenly. <b>Very Important!</b> Allow first coat of DC5775 to flash approximately 15 minutes. (This will be affected by air temperature and air movement). If you apply the second coat before the first coat has become uniformly dull, the second coat will trap too much solvent making it dry mottled and inconsistent in the "puddle areas" or wetter areas. 5) Apply 2 <sup>nd</sup> coat of DC5775 medium wet evenly over area.	
<b>Drying</b>	<b>20°C/68°F</b> 2 to 4 hours <b>60°C/140°F</b> 30 to 45 minutes * The slower the drying (DH100) the higher the gloss will be.	
<b>Sanding/ Polishing</b>	See "Things NOT to DO" on next page.	
<b>Notes</b>	Must follow application steps closely and observe proper flash times for proper matte appearance. Does not require flex agent on flexible parts. 20° gloss < 10 It's a good idea to make notes of hardeners, reducers, flash times, tip size and booth temp. The more you adhere to the original "set-up" the more consistency in matching sheen you will have down the road when you find yourself in a touch up or redo situation. Always weigh your Clear, Hardener and Reducer to exact measure to ensure consistency and rematch for future problems.	



# DC5775 Ultra Flat Clear

## Technical Data - Low VOC



### Characteristics

DC5775 Ultra Flat Clear is a two-component acrylic urethane clear for topcoating ONYX HD Basecoat colors. DC5775 Clear produces an ultra flat, durable, and chemically resistant automotive finish. For proper gloss appearance, follow the application steps carefully.

### Technical Data

<b>Viscosity</b>	16-18 sec. #4 Ford cup
<b>Fluid Tip (HE Gravity)</b>	1.3 mm
<b>Fluid Tip (HVLP Gravity)</b>	1.3 mm
<b>Air Pressure (HVLP/HE)</b>	9-10 psi cap (see MFG gun recommendations)
<b>Number of Coats</b>	2 medium wet coats per step (see application steps)
<b>Thickness</b>	2.5-3.0 mils
<b>Pot Life</b>	3 hours @ 20°C/68°F
<b>Coverage</b>	542 sq ft/gal @ 2.0 mils
<b>VOC as Applied</b>	240 gms/ltr (2.0 lbs/gal)

### Things to DO:

- Do use the appropriate NIOSH/MSHA respirator. Consult product label for details.
- Do bake immediately for best results.
- Do measure amount of hardener and reducer - DO NOT ESTIMATE.
- Do observe flash times for proper matte appearance.
- Do apply medium wet coats. Heavy wet coats will increase the gloss level.
- Do agitate product before use.

### Things NOT to DO:

- Do not use DC5775 if the shop temperature is below 15°C/60°F.
- Do not use Jet95 or Jet5 in DC5775 Clear.
- Do not attempt to buff/polish DC5775, gloss level will increase.
- Do not flex DC5775.