

DC92 High Solids Clear

Application Procedures



Products	DC92 High Solids Clear 851 Prep and Wash 900 Pre-Kleano 901 Pre-Paint Cleaner 910 Universal Prep Cleaner AM900 Aero-Max Pre-Kleano DF21 Flex Agent DH42 Rapid Hardener DH44 Medium Hardener DH46 Normal Hardener DH47 Slow Hardener UR Series Reducers
Cleaning	See Topcoat Section - "Cleaning & Preparing Vehicle for Topcoating" for vehicle prep.
Topcoating	See Topcoat Section - Diamont or ONYX HD Basecoat
Mixing Ratio	3:1:20% 3 parts DC92 1 part DH42, DH44, DH46 or DH47 20% UR Reducer
Application	2 to 3 medium wet coats 5 to 10 minutes flash between coats If it is not practical to clearcoat the entire panel and blending of the clear is necessary (e.g., roof pillar), remelt the clearcoat edge with UBR200 Blending Solvent (1 part clear/hardener/reducer + 5 parts UBR200) using reduced air pressure to the spray gun. The blending of clear into a panel is not covered under the R-M warranty.
Drying	20°C/68°F 4 to 5 hours 60°C/140°F 30 to 45 minutes Recoat 24 hours Compound 24 hours
Sanding/ Polishing	Wet Sand - 1200 grit or finer
Notes	



DC92 High Solids Clear

Technical Data



Characteristics

DC92 High Solids Clear is a two component, high build, acrylic urethane clear for topcoating Diamont or ONYX HD Basecoat Colors. DC92 produces a very glossy, durable and chemically resistant automotive finish.

Technical Data

Viscosity	18-20 sec. #4 Ford cup
Fluid Tip (HE Gravity)	1.3-1.5 mm
Fluid Tip (HVLP Gravity)	1.3-1.5 mm
Air Pressure (HVLP/HE)	9-10 psi at air cap
Number of Coats	2 to 3 medium wet coats
Thickness	2.0-2.5 mils
Pot Life	3 hours @ 20°C/68°F
Coverage	323 sq ft/gal @ 2.0 mils
VOC as Applied	503 gms/ltr (4.2 lbs/gal)

Things to DO:

- Do use the appropriate NIOSH/MSHA respirator. Consult product label for details.
- Do use 809 Fisheye Eliminator in DC92 if necessary.
- Do bake immediately for best results.
- Do measure amount of hardener and reducer - DO NOT ESTIMATE.
- Do use the DC92 mixture within one hour for best results.
- Do use up to 10% UR70 Reducer in extremely hot, humid weather to slow the drying time of DC92.
- Do use DH42 in cool weather to decrease dry times.
- Do add up to a maximum of 1 oz. per quart of HR5 JET 5 to the DC92/DH46 mixture to improve cure times in cool weather.
- Do use DF21 Flex Agent when painting flexible parts. See Flexible Parts section of manual.

Things NOT to DO:

- Do not attempt to recoat, sand or compound DC92 until the final coat has dried for a minimum of 24 hours.
- Do not use DC92 if the shop temperature is below 15°C/60°F.
- Do not use HR5 Jet 5 if DH42 Hardener is used.