
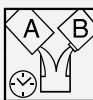








Technical Bulletin TB-013

DPS3055 V-PRIME® Acrylic Urethane Surfacer Speed Air Dry Ratio

Mix:		Primer Surfacer Optimum Drying Speed DPS3055 Surfacer: 4 parts DCX3030 Hardener: 1 part DT Reducer: ½ - 1 part DXR81 Accelerator: 1 oz. per RTS Mix Ratio by Cumulative Weight in Parts (Grams) 4 : 1 : 1 +1 oz. <table><tr><th>Code:</th><th>4 oz.</th><th>8 oz.</th><th>16 oz.</th><th>32 oz.</th></tr><tr><td>DPS3055</td><td>133 (118)</td><td>267 (237)</td><td>534 (474)</td><td>1067 (948)</td></tr><tr><td>DCX3030</td><td>155 (138)</td><td>310 (275)</td><td>620 (511)</td><td>1241 (1101)</td></tr><tr><td>DT885</td><td>174 (154)</td><td>348 (309)</td><td>696 (617)</td><td>1391 (1235)</td></tr><tr><td>DXR81</td><td>178 (158)</td><td>355 (315)</td><td>710 (630)</td><td>1420 (1260)</td></tr></table>	Code:	4 oz.	8 oz.	16 oz.	32 oz.	DPS3055	133 (118)	267 (237)	534 (474)	1067 (948)	DCX3030	155 (138)	310 (275)	620 (511)	1241 (1101)	DT885	174 (154)	348 (309)	696 (617)	1391 (1235)	DXR81	178 (158)	355 (315)	710 (630)	1420 (1260)
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		Reducer Selection: Refer to TB-014 Deltron Reducer Selection Guide																									
Pot Life:		Accelerated Surfacer: 30 minutes at 70°F (21°C)																									
Additives:		DXR81 Accelerator: 1 oz. to RTS quart																									
Spraygun Set up:		HVLP: 8-10 psi at the air cap Compliant: 29-40 psi at the gun Fluid Tip: 1.6-1.8 mm or equivalent Note: For best overall results, refer to spraygun manufacturer's recommendations for inlet air pressure.																									
Application:		Primer Surfacer with DXR81 Apply: 2 to 3 wet coats Film build per wet coat: 3.0 mils Dried film build per coat: 1.0 mil Between Coats: 0 minutes																									
Dry Times:		Dust Free: 5 minutes at 70°F (21°C) Dry to Handle: 10 minutes at 70°F (21°C) Dry to Sand: 20 - 30 minutes at 70°F (21°C) Dry to Topcoat: 30 minutes after sanding at 70°F (21°C)																									
VOC:		<table><tr><td>Volume Ratio</td><td>4 : 1 : 1/2 + 1oz.</td><td>4 : 1 : 1 + 1 oz.</td></tr><tr><td>VOC RTS lbs./ per US Gallon</td><td>4.55 (545)</td><td>4.76 (570)</td></tr></table>	Volume Ratio	4 : 1 : 1/2 + 1oz.	4 : 1 : 1 + 1 oz.	VOC RTS lbs./ per US Gallon	4.55 (545)	4.76 (570)																			
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