

V-PRIME™ Acrylic Urethane Surfacer

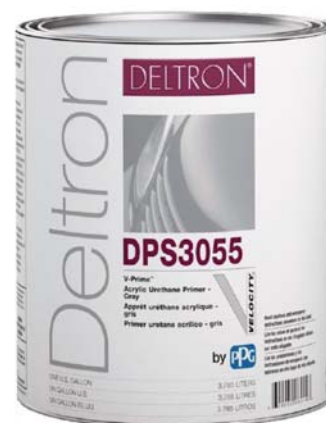
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DPS3051 White / DPS3055 Gray / DPS3057 Dark Gray

V-PRIME® DPS305x are premium quality primer surfacers available in white, gray and dark gray. The surfacers are suitable for the wide range of day-to-day repair work done in today's refinish body shops.

DPS305x offers excellent adhesion, film build, surface leveling and gloss holdout over a wide range of substrates.

This versatile, quick drying, easy to apply and sand primer may be applied as a conventional spray filler or primer surfacer.



Features & Benefits

- Fast dry
- Easy to sand
- Superior holdout
- Faster process times

Compatible Surfaces

V-Prime DPS305x may be applied over:

- Properly prepared and treated bare steel, galvanized steel and aluminum
- Properly cleaned and sanded gel coated fiberglass
- Properly cleaned and sanded OEM finishes
- Properly cleaned and sanded E-Coat
- DELTRON® Plastic Adhesion Promoter
- DF Body Fillers
- *Deltron* 2K Primer Surfacer*
- DPLF Epoxy Primer*
- DPLV 2.1 VOC Epoxy Primer*
- *Deltron* Self Etching Primers*
- ONECHOICE® Plastic Adhesion Promoters
- *OneChoice* Etch Primers

*Maintain a minimum dry film of 2.0 mils after sanding. Insufficient DPS305x films may result in lifting on color application.

Required Products

Hardener

DCX3030 Undercoat Hardener

Reducer

DT860 Cool Temperature 60-70°F (16-21°C)
DT870 Medium Temperature 65-80°F (18-27°C)
DT885 Warm Temperature 75-90°F (24-32°C)
DT895 Hot Temperature 85°F (29°C) and above
DT898 Hot Temperature 95°F (35°C) and above

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Surface Preparation:



- Wash the area to be painted with soap and water, then clean with appropriate PPG Cleaner.
- Sand the bare metal areas completely with 80-180 grit abrasive. Sand old finishes with 320-400 grit dry by hand or machine or 600 grit wet.
- Exposed bare metal should be spot primed with a suitable bare metal primer
- Re-Clean with the appropriate PPG cleaner.
- Prime aluminum substrates within 8 hours
- Prime carbon steel immediately after cleaning.



Mix Ratio:



As a spray filler:

DPS305x	:	DCX3030 Hardener
4	:	1



As a primer surfer:

DPS305x	:	DCX3030 Hardener	:	DT Reducer
4	:	1	:	1/2 - 1



Pot Life:

30 minutes at 70°F (21°C) as a Spray Filler
1 hour at 70°F (21°C) as a Primer Surfer

Tinting of DPS305x is not recommended

Additives:



SL814 Universal Flexibilizer

10% to RTS mix

Air Pressure and Gun Set-up:



HVLP:

8-10 psi at the air cap

Compliant:

29-40 psi at the gun

Fluid Tip:

As a spray filler

1.7-2.0 mm or equivalent

As a primer surfer

1.6-1.8 mm or equivalent

Note: For best overall results, refer to spraygun manufacturer's recommendations for inlet air pressures.

Application:



Coats:

As a spray filler

Up to a maximum of 4 wet coats

As a primer surfer

2-3 wet coats

Dry film build per coat:

1.7-2.0 mils

1.5-1.8 mils

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Drying Times:



Between Coats:

As a spray filler

5-10 minutes at 70°F (21°C)

As a primer surfacer

5-10 minutes at 70°F (21°C)



Air Dry :

Dust Free:

15 minutes at 70°F (21°C)

15 minutes at 70°F (21°C)

To Sand:

6 hours/overnight at 70°F (21°C)

1½ hours at 70°F (21°C)



Force Dry to Sand:

Purge:

N/A

10 minutes at 70°F (21°C)

Bake:

Do not force dry

30 minutes at 140°F (60°C)
and cool down

IR:

Medium Wave:

Do not IR force dry

20 minutes

Short Wave:

Do not IR force dry

10 minutes

Sanding:



Sanding:

Grade Wet:

400-600 grit

Grade Dry Machine:

320-500 grit

Note:



Bake times are for metal temperature. Additional time should be allowed in the force drying schedule for metal to reach recommended temperature.

Compatible Topcoats:

May be topcoated with:
Deltron Sealers
 DPLF Epoxy Primer
 DPLV 2.1 VOC Epoxy Primer
OneChoice Sealers
 CONCEPT® (DCC) Acrylic Urethane
Deltron 2000 (DBC) Basecoat*
 ENVIROBASE® High Performance Sealers
Envirobase High Performance Basecoat

*Must be sealed before applying black DBC

Equipment Cleaning:

Spray guns, gun cups, storage pots, etc. should be cleaned thoroughly after each use with any PPG general purpose solvent, lacquer thinner or DT Reducer.

Technical Data:

	As a spray filler	As a primer surfacer
Volume Ratio	4 : 1	4 : 1 : 1
Intended Use	Primer Surfacers	Primer Surfacers
VOC RTS lbs./ per US Gallon	4.21	4.68
Total Solids by Weight (RTS)	63.8%	56.8%
Total Solids by Volume (RTS)	42.0%	35.1%
Sq. Ft. Coverage / US Gallon / 100% Transfer Efficiency (RTS)	675	562
Recommended wet film build per coat	5.0 mils	4.0 mils
Recommended dry film build per coat	2.0 mils	1.5 mils

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*A*Chromatic Gray Mixing Chart

V-Prime Acrylic Urethane Surfacers

Use this chart as a guide to mix the G1-G7 ratios to achieve better hiding when mixing the V-Prime Acrylic Urethane Surfacers.

Mix Ratio By Volume			Mix Ratio By Cumulative Weight Parts			
	Mix Ratio		¼ Pint	½ Pint	Pint	Quart
G1	DPS3051	4	136	271	546	1101
	DCX3030	1	157	314	633	1276
	DT8xx	1	176	351	708	1428
G3	DPS3051	3	102	203	409	825
	DPS3055	1	134	269	542	1095
	DCX3030	1	156	312	629	1270
	DT8xx	1	175	350	705	1423
G5	DPS3055	4	133	265	536	1078
	DCX3030	1	155	308	621	1253
	DT8xx	1	173	346	697	1406
G6	DPS3055	N/A	45	89	178	359
	DPS3057		129	257	516	1041
	DCX3030		150	299	602	1216
	DT8xx		168	337	679	1368
G7	DPS3057	4	125	251	506	1020
	DCX3030	1	147	295	593	1195
	DT8xx	1	166	332	669	1348

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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

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