



DPLV Low VOC Epoxy Primer (National Rule)

P-245NR

DPLV

DPLV Low VOC Epoxy Primer provides excellent adhesion and corrosion resistance to many types of properly prepared steel, aluminum, and fiberglass substrates. DPLV Epoxy Primer may also be used as a sealer and top coated with many of PPG's two component urethane undercoats and topcoats as well as both solvent and waterborne basecoats.

DPLV Low VOC Epoxy Primer is available in 3 colors - DP48LV White, DP50LV Gray and DP90LV Black - that can be blended together to achieve the full range of gray shades, G1-G7.

This Product Information Sheet for use in National Rule areas.



Features & Benefits

- Direct to metal
- Excellent adhesion and corrosion resistance
- Primer / Sealer
- Three colors available

Compatible Surfaces

DPLV may be applied over

- Properly cleaned and sanded, steel, galvanized steel, sand blasted steel and aluminum
- Properly cleaned and sanded gel coated fiberglass
- Properly cleaned (unsanded) E-Coat
- Various cleaned and sanded rigid plastic*: ABS, Nylon, Polycarbonate, Noryl, PBT or SMC.
- Properly cleaned and sanded OEM Finishes - for OE lacquer see ++Caution statement
- Cured and sanded refinish coatings
- DF Body Fillers
- SX Metal Treatments
- DURACRYL® (DDL) Acrylic Lacquer++

NOTE: DPLV is direct to metal and MUST NOT be applied over etch or wash primers. Film build of 1.2-1.5 mils of DPLV is required or the surface must be treated with metal treatment/conditioner.

*Unprimed plastics require the use of a plastic adhesion promoter prior to the application of DPLV epoxy primer.

++**Caution** when DPLV is sprayed over lacquer substrates or basecoat that is not cross linked, allow to set overnight before applying another coat of primer or topcoat as lifting may occur. This can be avoided by applying the DPLV Epoxy Primer, color and clear coating the same day or by catalyzing the basecoat.

Required Products

Hardener	Reducer		
DP401LV	P850-1692	Thinner-Low Temperature	65-75°F (18-24°C)
Low VOC Epoxy Hardener	P850-1693	Thinner-Mid Temperature	70-80°F (21-26°C)
	P850-1694	Thinner-High Temperature	80-95°F (27-35°C)
	P850-1695	Thinner-Very High Temperature	90°F (32°C) and above
	P850-1696	Thinner-Ultra High Temperature	95°F (35°C) and above
	ECR65	Low Temp Reducer	
	ECR75	Mid Temp Reducer	
	ECR85	High Temp Reducer	
	D870	Fast Thinner - up to 65°F (18°C)	
	D871	Medium Thinner 65-77°F (18-25°C)	
	D872	Slow Thinner 77-95°F (25-35°C)	
	D873	Very Slow Thinner 95°F (35°C) and over	
	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.
- Re-clean with the appropriate PPG cleaner
- Prime aluminum substrate within 8 hours
- Prime carbon steel immediately after cleaning

Mix Ratio:



DPLV Low VOC Epoxy Primer	DP401LV Low VOC Epoxy Hardener	P850-169x, D87x DT8xx or ECR Reducers
2	1	1

Pot Life: 8 hours at 70°F (21°C)



Note: Thoroughly mix primer, hardener and reducer. Mechanical agitation is recommended.



No induction period is necessary.

DPLV Epoxy Primer cannot be tinted
 DPLV Epoxy colors may be blended together
 Note: Do Not Blend DPLV and DPLF together

Additives:



None

Air Pressure and Gun Setup:



HVLP: 8 - 10 psi at the air cap
Compliant: 29 - 40 psi at the gun
Gun Setup: 1.3 - 1.6 mm or equivalent

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

Application:



Apply:	Standard	Flexible Parts*
	1 - 2 wet coats	1 full wet coat
Dry film build per coat:	.75 - 1.5 mils.	

*Note: Unprimed plastics will require the use of a Plastic Adhesion Promoter prior to the application of DPLV Low VOC Epoxy Primer.

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Drying Times:



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



To Topcoat:
1 Coat 30 minutes at 70°F (21°C)
2 Coats 60 minutes at 70°F (21°C)



To Apply Body Filler:
2 Coats Overnight dry

Note: DPLV Epoxy Primer may be recoated any time up to 1 week. After 1 week surface must be cleaned, sanded and re-cleaned. Reapply 1 additional coat of DPLV Epoxy Primer only if applying basecoat directly to DP.

Compatible Topcoats:

DPLV Low VOC Epoxy Primer may be topcoated with:
 DF Body Fillers
 DELTRON® NXT(DCC) Acrylic Urethane
Deltron NXT (DBU) Basecoat
Deltron NXT 2000 (DBC) Basecoat
Deltron NXT primers, surfacers, and sealers
 ONECHOICE® surfacers and sealers
Duracryl (DLL) Acrylic Lacquer
 GLOBAL REFINISH SYSTEM™ primers, surfacers, and sealers
Global Refinish System Basecoat
 NEXA AUTOCOLOR® primers, surfacers, and sealers
Nexa Autocolor Basecoat
 ENVIROBASE® High Performance Basecoat
Envirobase High Performance primers, surfacers, and sealers
 AQUABASE® Plus Basecoat
Aquabase Plus primers, surfacers, and sealers

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.

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DPLV Gray Mixing Chart

This chart can be used to mix the DPLV Low VOC Epoxy Primer. The G1-G7 ratios will help to achieve better hiding when used as a guide for mixing the DPLV Low VOC Epoxy Primer

Mix Ratio By Volume			Mix Ratio By Cumulative Weight							
Mix Ratio			Grams				Parts			
			¼ Pint	½ Pint	Pint	Quart	¼ Pint	½ Pint	Pint	Quart
G1	DP48LV	2	90	180	360	720	102	203	406	812
	DP401LV	1	122	243	486	971	137	274	548	1095
	D87x / DT8xx / P850-169x / ECR	1	157	314	628	1256	177	354	708	1416
G3	DP48LV	1.5	92	185	270	540	76	152	304	609
	DP50LV	.5	88	176	353	706	99	199	398	796
	DP401LV	1	120	239	478	957	134	269	539	1076
	D87x / DT8xx / P850-169x / ECR	1	155	310	621	1242	175	350	700	1401
G5	DP50LV	2	83	166	331	662	93	186	373	746
	DP401LV	1	114	228	456	913	129	258	515	1030
	D87x / DT8xx / P850-169x / ECR	1	150	300	599	1198	169	338	676	1351
G6	DP50LV	1	42	83	166	331	46	93	186	373
	DP90LV	1	82	164	328	656	92	185	370	740
	DP401LV	1	114	227	454	907	128	256	512	1023
	D87x / DT8xx / P850-169x / ECR	1	149	298	596	1192	168	336	672	1344
G7	DP90LV	2	81	162	325	650	92	183	366	733
	DP401LV	1	112	225	450	901	127	254	508	1016
	D87x / DT8xx / P850-169x / ECR	1	148	296	593	1186	167	334	669	1338

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RTS Combinations:	DPxxLV : DP401LV : P850-169x / D87x / DT8xx / ECR
Volume Ratio:	2 : 1 : 1
Applicable Use Category	Primer
VOC Actual (g/L)	246-353
VOC Actual (lbs/Gal)	2.05-2.95
VOC Regulatory (less water less exempt) (g/L)	342-430
VOC Regulatory (less water less exempt) (lbs./gal)	2.85-3.59
RTS Solids wt. %	50.7--58.3
RTS Solids vol. %	39.9-42.0
Sq. Ft. Coverage at 1 mil. at 100% transfer efficiency	640-674

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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