

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) | D870 Fast Thinner - up to 65°F (18°C) |
| Low VOC Epoxy Hardener | P850-1693 | Thinner-Mid Temperature 70-80°F (21-26°C) | D871 Medium Thinner 65-77°F (18-25°C) |
| | P850-1694 | Thinner-High Temperature 80-95°F (27-35°C) | D872 Slow Thinner 77-95°F (25-35°C) |
| | P850-1695 | Thinner-Very High Temperature 90°F (32°C) and above | D873 Very Slow Thinner 95°F (35°C) and over |
| | P850-1696 | Thinner-Ultra High Temperature 95°F (35°C) and above | DT860 Cool Temperature 60-70°F (16-21°C) |
| | ECR65 | Low Temp Reducer | DT870 Medium Temperature 65-80°F (18-27°C) |
| | ECR75 | Mid Temp Reducer | DT885 Warm Temperature 75-90°F (24-32°C) |
| | ECR85 | High Temp Reducer | 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**

2

**DP401LV Low VOC
Epoxy Hardener**

1

**P850-169x, D87x
DT8xx or ECR
Reducers**

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

1 - 2 wet coats

Flexible Parts*

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 | | | | | | | |
|---------------------|--------------------------------|-----|--------------------------------|--------|------|-------|--------|--------|------|-------|
| | | | Grams | | | | Parts | | | |
| | Mix Ratio | | 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 |

DPLV

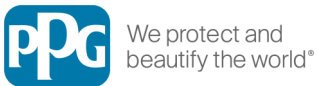
| RTS Combinations: | DPxxLV : DP401LV : P850-169x / D87x / DT8xx / ECR |
|--|--|
| Volume Ratio: | 2 : 1 : 1 |
| Applicable Use Category | Primer |
| VOC Actual (g/L) | 246-353 |
| VOC Actual (lbs/Gal) | 2.05-2.95 |
| VOC Regulatory (less water less exempt) (g/L) | 342-430 |
| VOC Regulatory (less water 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

Materials described are designed for application by professional, trained personnel using proper equipment and are not intended for sale to the public. Products mentioned may be hazardous and should only be used according to direction, while observing precautions and warning statements listed on label. Statements and methods described are based upon the best information and practices known to PPG Industries. Procedures for applications mentioned are suggestions only and are not to be construed as representations or warranties as to performance, results, or fitness for any intended use, nor does PPG Industries warrant freedom from patent infringement in the use of any formula or process set forth herein.



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