

3.5 Epoxy Primer

Delta® DEP351

DEP351 is a 3.5 Epoxy Primer designed for use in fleet applications requiring excellent adhesion and corrosion protection. The chrome and lead-free primer also has exceptional topcoat characteristics and re-coat times.



Features

- Direct to metal
- User Friendly
- High Solids

Advantages

- Corrosion Protection
- VOC Compliant

Benefits

- Excellent Adhesion
- Increased Productivity
- Reduced Inventory

Compatible Surfaces

Delta® DEP351 may be applied over:

- Cured and sanded OEM finishes
- Properly cleaned and sanded fiberglass
- Properly cleaned and sanded: steel, aluminum and stainless
- Properly cleaned and sanded Galvanized and Galvaneal steel
- DPS306 2K Primer Sufacer
- DPHS52 Low VOC Primer
- DPU166 High Solids Chromate Primer 2.8 VOC Max.
- DPU174 High Solids Polyurethane Primer (Chrome-Free)
- DPU217 2.1 VOC Polyurethane

Catalyst

Epoxy Primer Catalyst

DEP352

DEP351

Application Guide

Preparation:



- Wash the area to be painted with soap and water, and then clean with DX436 or DX437 wax and grease remover. DX438 Low VOC Cleaner should be used in VOC restricted areas.
- All metal substrates need to be sanded with 80-180 grit wet or dry. Re-clean with DX436, DX437 or DX438.
- Prime aluminum, stainless and carbon steel immediately after cleaning.
- Sand old finishes with 240-280 grit wet or dry.

Mixing Ratio:



DEP351

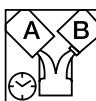
DEP352

2 parts

1 part

The addition of 10 - 20% Acetone or DES1570 Exempt Solvent Blend should be used for sealer applications.

Pot life:



4 hours @ 70°F and 50% RH
(High heat and humidity will shorten pot life)

Additives:



Not Recommended

Spraygun set-up:



Fluid Tip: 1.2 - 1.4 mm Pressure Feed/HVLP
1.4 - 1.6 mm Conventional Feed/HVLP

Air Pressure: HVLP at air cap 10 PSI
Conventional at spray gun 55 - 65 PSI

Consult the Fleet Training Manual Spray Equipment section for gun set-up requirements.

Number of coats:



1 - 2 coats

Total film build per coat:

	Wet	Dry
Minimum	2 mils	1 mils
Maximum	4 mils	2 mils

Flash Time at 70°F (21°C):

Between coats

5 minutes

Drying times:

	Air Dry @ 70°F	Force Dry**
Dust:	20 minutes	Flash 10 minutes
Tack:	3 hours	20 minutes @ 130°F
Tape:	4 hours	10 minutes @ 160°F
Dry to Topcoat:	60 minutes	

Note: After 2 weeks, DEP351 must be sanded before additional primer or topcoat can be applied.

**Force drying times are for quoted surface temperature. Additional time should be allowed in the force-drying schedule to allow surface to reach recommended temperature.

Test Properties:

Color	Gray
VOC DEP351 Packaged	3.3 lbs. per U.S. gal.
VOC DEP352 Packaged	4.0 lbs. per U.S. gal.
VOC RTS Applied	3.5 lbs. per U.S. gal.
Volume Solids (RTS)	49.5%
Square Foot Coverage	990 sq. ft.
(RTS US Gallon 100% Transfer Efficiency)	

Compatible Topcoats:

DPHS52 Low VOC Primer
DPU166 High Solids Chromate Primer (2.8 VOC)
DPU174 High Solids Polyurethane Primer
DPU217 DELTA® 2.1 VOC Polyurethane Primer
DPS306 DELTA® 2K Primer Surfacer
DELTA® (DFHS) Fast Dry High Solids Polyurethane
DELTA® (DUHS) High Solids Polyurethane
DELTA® (DVHS) Fast Dry 2.8 VOC Polyurethane
DELTA® (DGHS) Chemical Resistant 3.5 VOC
DELTA® (DGHS) Chemical Resistant 4.4 VOC
DELTA® (DSS) Medium Solids Polyurethane
DELTA® (DHS) 2.8 VOC Polyurethane

Health and Safety

See Material Safety Data Sheet and Labels for additional safety information and handling instructions.
Emergency Medical or Spill Control Information
(304) 843-1300; In Canada (514) 645-1320

Delta[®] DEP351

3.5 Epoxy Primer

Instant Reference

How to Mix:



DEP351

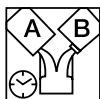
DEP352

2 parts

1 part

The addition of 10 - 20% Acetone or DES1570 Exempt Solvent Blend should be used for sealer applications.

Pot life:



Pot life @ 70°F and 50% RH: 4 hours
(High heat and humidity will shorten pot life)

Gun set-up:



HVLP:

10 PSI at the air cap

Conventional:

55 - 65 PSI at the gun

Fluid Tip:

1.2 - 1.4 mm for Pressure Feed/HVLP

1.4 - 1.6 mm for Conventional Feed/HVLP

Application:



Apply:

1 - 2 coats

Between Coats:

5 minutes

Film build per coat:

Wet

Dry

Minimum

2 mils

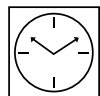
1 mils

Maximum

4 mils

2 mils

Drying times:



Air Dry @ 70°F

Force Dry*

Dust:

20 minutes

Flash 10 minutes

Tack:

3 hours

20 minutes @ 130°F

Tape:

4 hours

10 minutes @ 160°F

Dry to Topcoat:

60 minutes

Note: After 2 weeks, DEP351 must be sanded before additional primer or topcoat can be applied.

*Force Drying times are for quoted surface temperature. Additional time should be allowed in the force-drying schedule to allow surface to reach recommended temperature.

For additional information, refer back to the complete FL305 bulletin.

EMERGENCY MEDICAL OR SPILL CONTROL INFORMATION (304) 843-1300. 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 directions, 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.



PPG Automotive Refinish

World Leaders in Automotive Finishes

PPG Industries
19699 Progress Drive
Strongsville, OH 44149

PPG Canada Inc.
1330 Castlefield Avenue
Toronto, Ontario M6B 4B3