



# DPLF

DPLF Epoxy Primer is an excellent corrosion-resistant primer and provides excellent adhesion to many types of properly prepared metal, fiberglass and aluminum substrates, as well as plastic fillers.

DPLF Epoxy Primer may also be used as a sealer and topcoated with most PPG Refinish products.

DPLF Epoxy Primers come in 6 colors:

DP40LF (Gray-Green), DP48LF (White), DP50LF (Gray), DP60LF (Blue), DP74LF (Red Oxide), and DP90LF (Black).



## Features & Benefits

- Direct to metal
- Primer / Sealer
- Strong corrosion protection
- Excellent adhesion

## Compatible Surfaces

### DPLF 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 with DP401LF catalyst only
- Various cleaned and sanded rigid plastic\*: ABS, Nylon, Polycarbonate, Noryl, PBT SMC, with DP401LF Catalyst only
- Properly cleaned and sanded OEM Finishes - for OE lacquer see ++Caution statement
- Cured and sanded refinish coatings
- DF Body Fillers
- DX54 ROADGUARD® Chip Resistant coating
- DX Metal Treatments
- DURACRYL® (DDL) Acrylic Lacquer++

**NOTE:** DPLF is direct to metal and MUST NOT be applied over etch or wash primers. Film build of 1.2-1.5 mils of DPLF 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 DPLF epoxy primer.

++Caution when DPLF 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 DPLF Epoxy Primer, color and clear coating the same day or by catalyzing the basecoat.

## Required Products

### Catalyst

DP401LF Epoxy Primer Catalyst

DP402LF Epoxy Primer Catalyst

Acetone\*

\*Optional

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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 by hand or machine with 320-400 grit dry or 600 grit wet.
- Re-clean with appropriate PPG cleaner
- Chemical treatment or the use of a conversion coating will enhance the adhesion and performance properties of the finished system.
- Prime aluminum within 8 hours.

Prime carbon steel immediately after cleaning.

## Mix Ratio:



DPLF				(optional)
Epoxy Primer	:	DPLF Catalyst	:	Acetone*
2	:	1	:	½



**Note:** Thoroughly mix primer and catalyst (5 minutes mechanical agitation recommended).

**Allow 30 minutes induction period to obtain maximum performance properties prior to use of DPLF/DP401LF.**

No induction period is necessary when using DPLF/DP402LF

**Do not blend DP401LF and DP402LF together**



**Pot Life:** DPLF/DP401LF is 72 hours at 70°F (21°C)  
DPLF/DP402LF is 8 hours at 70°F (21°C)

**Note:** In non-automotive applications where higher VOC primers are allowed, one half part of DT reducer may be added. This 2:1:½ blend ratio will result in a 4.90 VOC sealer.

\*The use of acetone is optional, however when used, the minimum recommended film build must be maintained.

DPLF Epoxy Primer cannot be tinted.

DPLF Epoxy colors may be blended together.

## Painting Flexible Parts:



DPLF				
Epoxy Primer	:	DPLF401LF	:	Acetone*
2	:	1	:	½

**Note: Do not use DP402LF Fast Catalyst on flexible parts.**



Apply 1 wet coat.

**Recommended Dry Film build:** .5-.75 mils

Reductions other than 2:1:½ or more than 1 coat will not result in a flexible coating.

## Additives:



None

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## Air Pressure and Spraygun 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 spraygun manufacturer's recommendations for inlet air pressures.

## Application:



	<u>DP401LF</u>	<u>DP402LF</u>
Apply:	1-2 wet coats	1-2 wet coats
Recommended Dry Film Build		
DPLF Epoxy Primer:	0.75-1.5 mils	0.75-1.5 mils
DPLF Epoxy Primer on Flexible parts:	0.5-0.75 mils	not recommended
DPLF Epoxy Primer with Acetone:	0.75-1.5 mils	0.75-1.5 mils

## Drying Times:



	<u>DP401LF</u>	<u>DP402LF</u>
Between Coats: At 70°F (21°C)	10-15 minutes	10-15 minutes



Dry to topcoat: At 70°F (21°C)		
1 coat	60 minutes	30 minutes
2 coats	90 minutes	60 minutes
Flexibilized:	30 minutes	NA



To apply body filler: At 70°F (21°C)		
1 coat	60 minutes	60 minutes
2 coats	overnight dry	overnight dry

**Note:** DPLF Epoxy Primer may be recoated any time up to 1 week.

After 1 week, it must be cleaned, sanded and re-cleaned. Reapply 1 additional coat of DPLF Epoxy Primer only if applying basecoat directly to DPLF

## Compatible Topcoats:

DPLF Epoxy Primer may be topcoated with:

- DF Body Fillers
- DX54 *Roadguard* Chip Resistant Coating
- CONCEPT® (DCC) Acrylic Urethane
- DELSTAR®/DELTHANE® (DAR/DXR80) Acrylic Enamel
- Deltron* (DBU) Basecoat
- Deltron* 2000 (DBC) Basecoat
- Deltron* primers, surfacers, and sealers
- Duracryl* (DLL) Acrylic Lacquer
- OneChoice* surfacers and sealers
- GLOBAL REFINISH SYSTEM™ Basecoat
- Global Refinish System* primers, surfacers, and sealers
- NEXA AUTOCOLOR® Basecoat
- Nexa Autocolor* primers, surfacers, and sealers
- ENVIROBASE® High Performance Basecoat
- Envirobase* High Performance primers, surfacers, and sealers
- AQUABASE® Plus Basecoat
- Aquabase* Plus primers, surfacers, and sealers

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**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:			
DPLF Epoxy Primer			
	DP401LF	DP402LF	
VOC (RTS) 2:1	4.52 lbs./ US gal.	4.54 lbs./ US gal.	
Total Solids by Weight (RTS)	55.6%	56.0%	
Total Solids by Volume (RTS)	36.2%	36.4%	
Sq. Ft. Coverage US Gal.			
(1 mil 100% transfer efficiency)	580	583	
DPLF Epoxy Primer on Flexible Parts (use DP401LF only)			
	DP401LF w/ DT Reducer	DP401LF w/ Acetone	
VOC (RTS) 2:1:½	4.88 lbs./ US gal.	4.52 lbs./ US gal.	
Total Solids by Weight (RTS)	48.8%	50.1%	
Total Solids by Volume (RTS)	29.9%	31.0%	
Sq. Ft. Coverage US Gal.			
(1 mil 100% transfer efficiency)	480	480	
DPLF Epoxy Primer with Acetone			
	DP401LF w/ Acetone	DP402LF w/ Acetone	
VOC (RTS) 2:1:½	4.52 lbs./ US gal.	4.54 lbs./ US gal.	
Total Solids by Weight (RTS)	50.1%	50.6%	
Total Solids by Volume (RTS)	31.0%	31.2%	
Sq. Ft. Coverage US Gal.			
(1 mil 100% transfer efficiency)	480	480	

## See Material 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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