2K Primer Surfacer

Delta® DPS306

DPS306 2K Primer Surfacer is a fast-dry surfacer intended for use in the fleet market, where spot repairs are common. DPS306 may be applied directly to most substrates and is chrome and lead free.



Features

- High Solids
- User Friendly
- Easy to Sand

Advantages

- Fast Build
- Fast Dry

Benefits

- Increased Productivity
- Saves Labor

Compatible Surfaces

Delta® DPS306 may be applied over:

- Cured and sanded OEM finishes
- Properly cleaned and sanded fiberglass
- Properly cleaned and sanded: steel, aluminum and stainless
- Galvanized and Galvaneal steel must be primed with DX1787 or DX1793 before applying DPS306
- DEP351 3.5 Epoxy Primer
- DPU217 2.1 VOC Polyurethane
- DX1793 Chrome-Free, Self-Etching Primer
- DPHS52 Low VOC Primer
- DPU166 High Solids Chromate Primer 2.8 VOC Max.
- DPU174 High Solids Polyurethane Primer (Chrome-Free)
- DX1787 Etching Filler

If sanding bare metal areas prior to the application of DPS306, use 180-240 grit wet or dry.
Sand old finishes with 240-280 grit wet or dry.

Prime aluminum, stainless and carbonated steel immediately after cleaning and sanding.

Catalyst

Catalyst for DPS306	DPS307

DPS306

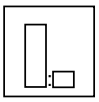
Application Guide

Preparation:



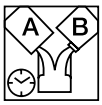
- Wash the area to be painted with soap and water, and then clean with DX436 or DX437 wax and grease remover. DX438 Low VOC Cleaner should be used in VOC restricted areas.
- Aluminum and steel substrates need to be sanded with 80 - 180 grit wet or dry. Re-clean with DX436, DX437 or DX438.
- Sand harder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

Mixing Ratio:



DPS306	DPS307
3 parts	1 part

Pot life:



1½ 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 45 - 50 PSI

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

Number of coats:

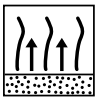


1 - 3 wet coats

Total film build per coat:

	Wet	Dry
Minimum	2.8 mils	2.0 mils
Maximum	8.3 mils	6.0 mils

Flash Time at 70°F (21°C):



Between coats	5 - 10 minute

Drying times:



	Air Dry @ 70°F	Force Dry**
Dust:	10 minutes	10 minutes
Tack:	20-30 minutes	20 minutes @ 130°F
Tape:	1-2 hours	10 minutes @ 160°F
Dry to Sand:	1-2 hours	After cool down
Dry to Topcoat:	30 minutes	

Note: After 8 hours, DPS306 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	Yellow Oxide
VOC DPS306 Packaged	3.4 lbs. per U.S. gal
VOC DPS307 Packaged	2.8 lbs. per U.S. gal. (1.5 less exempt solvents)
VOC RTS Applied	3.3 lbs. per U.S. gal. (2.9 less exempt solvents)
Volume Solids (RTS)	53.8%
Square Foot Coverage	864 sq. ft.

(RTS US Gallon 100% Transfer Efficiency)

Compatible Topcoats:

DPHS52 Low VOC Primer
DELTA® (DSS) Medium Solids Polyurethane
DELTA® (DFHS) Fast Dry High Solids Polyurethane
DELTA® (DUHS) High Solids Polyurethane
DELTA® (DUHS) Basecoat
DELTA® (DVHS) Fast Dry 2.8 VOC Polyurethane
DELTA® (DGHS) Chemical Resistant Polyurethane 3.5 VOC
DELTA® (DGHS) Chemical Resistant Polyurethane 4.4 VOC
DELTA® (DHS) 2.8 VOC Polyurethane
DEP351 DELTA® 3.5 Epoxy Primer
DPU174 High Solids Polyurethane Primer
DPU217 DELTA® 2.1 VOC Polyurethane Primer

Health and Safety

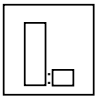
See Material Safety Data Sheet and Labels for additional safety information and handling instructions.
Emergency Medical or Spill Control Information
(304) 843-1300; In Canada (514) 645-1320

Delta® DPS306

2K Primer Surfacer

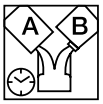
Instant Reference

How to Mix:



DPS306	DPS307
3 parts	1 part

Pot life:



Pot life @ 70°F and 50% RH: 1½ hours

Additives:



Not Recommended

Gun set-up:



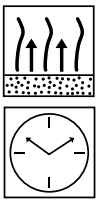
HVLP:	10 PSI at the air cap
Conventional:	45 - 50 PSI at the gun
Fluid Tip:	1.2 - 1.4 mm for Pressure Feed/HVLP 1.4 - 1.6 mm for Conventional Feed/HVLP

Application:



Apply:	1 - 3 wet coats	
Film build per coat:	*Wet*	*Dry*
Minimum	2.8 mils	2.0 mils
Maximum	8.3 mils	6.0 mils

Drying times:



	Air Dry @ 70°F	Force Dry
		Purge 20 minutes @ 70° F
Between Coats:	5-10 minutes	
Dust:	10 minutes	
Tack:	20-30 minutes	20 minutes @ 130°F
Tape:	1-2 hours	10 minutes @ 160°F
Dry to Sand:	1-2 hours	After cool down
Dry to Topcoat:	30 minutes	

For additional information, refer back to the complete FL306 bulletin.

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