



# NCP270 / NCP271

NCP270 Red & NCP271 Gray are premium-quality, corrosion-resistant primers developed for today's advanced technology finishes such as the DELTRON® and CONCEPT® topcoat systems. Featuring a 3.5 VOC, these primers are free of chrome, lead and isocyanates.

NCP270 & NCP271 offer superior sanding characteristics and excellent gloss holdout. They can be used over sanded original finishes and properly prepared, clean bare metal.



### Features & Benefits

- Isocyanate free
- Excellent corrosion resistance
- High build and easy sanding
- Excellent gloss holdout

### Compatible Surfaces

NCP270 and NCP271 may be applied over

- Properly prepared and treated bare steel, galvanized steel and aluminum
- Properly cleaned and sanded gel coated fiberglass
- Proper cleaned and sanded OEM finishes
- Properly cleaned and sanded E-Coat
- *Deltron* Plastic Adhesion Promoter\*
- *Deltron* Self Etching Primers\*
- ONECHOICE® Etch Primers\*
- DPLF Epoxy Primer\*
- DPLV 2.1 VOC Epoxy Primer\*
- DF Body fillers

**Note:** When used with an adhesion promoters, sealing the NCP before basecoating and clearcoating is recommended.

\*Maintain a minimum dry film of 2.0 mils after sanding. Insufficient Primer Surfacer films may result in lifting on color applications.

### Required Products

#### Hardener

NCX275 Corrosion Resistant Primer Catalyst

DELTRON

# NCP270 / NCP271

## 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.
- Exposed metal should be spot primed with a suitable bare metal primer.
- Re-Clean with the appropriate PPG cleaner
- Two step metal treatments or the use of a wash primer coating will improve the adhesion and performance properties of the finished system.
- A two step metal treatment or etch primer is required over sanded clean galvanized steel substrate.
- Prime aluminum within 8 hours.
- Prime carbon steel immediately after cleaning.

## Mix Ratio:



<b>NCP270 or NCP271</b>	:	<b>NCX275</b>	:	<b>DT8xx Reducer</b>
<b>3</b>	:	<b>1</b>	:	<b>0-½</b>

A half part reducer may be added for non-sanding primer uses.



**Pot Life:** 1 hour at 70°F (21°C)  
Pot life is shortened as temperatures increase.

## Additives:



None

## 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:



	<b>Surfacer</b>	<b>Non Sanding Primer</b>
<b>Coats:</b>	2-4 wet coats	1 wet coat
<b>Dry film build per coat:</b>	<u><b>3:1</b></u> 2.0-2.5 mils	<u><b>3:1:½</b></u> 1.5-1.8 mils

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## Drying Times:



**Between Coats:** 5-10 minutes at 70°F (21°C)



**Air Dry to Sand:** 1-2 hours at 70°F (21°C)



**Force Dry to Sand:**

**Purge Time:** 10 minutes at 70°F (21°C)

**Force Bake:** 20-30 minutes at 140°F (60°C) and cool down



**IR (Infrared):**

**Medium Wave:** 20 minutes

**Short Wave:** 10 minutes



**Dry to Topcoat:** 30 minutes at 70°F (21°C) for 1 coat non sanding primer application

**Note:** NCP270/NCP271 must be sanded prior to topcoat application if allowed to dry more than 8 hours.

## Sanding:



**Sanding:**

**Grade Wet:** 400-600 grit

**Grade Dry Machine:** 320-500 grit

## Note:



Bake times are for metal temperature. Additional time should be allowed in the force drying schedule for metal to reach recommended temperature.

## Compatible Topcoats:

*Concept (DCC) Acrylic Urethane*  
*DPLF Epoxy Primer*  
*DPLV 2.1 VOC Epoxy Primer*  
*DELSTAR®/DELTHANE® (DAR/DXR80) Polyurethane*  
*Deltron 2000 (DBC) Basecoat\**  
*Deltron Sealers\**  
*Deltron (DBU) Universal Basecoat*  
*Deltron Primer Surfacer\**  
*DX54 ROADGUARD® Chip Resistant Coating*  
*OneChoice Surfacer*  
*OneChoice Sealers*  
*ENVIROBASE® High Performance Basecoat\**  
*Envirobase High Performance Sealers*

**\*Must be sealed before applying black DBC or Envirobase High Performance Basecoat**

## Equipment Cleaning:

Spray guns, gun cups, storage pots, etc., should be cleaned thoroughly after each use with any appropriate PPG general purpose solvent.

## Technical Data:

Ready to Spray Ratio	<b>3 : 1</b>	<b>3 : 1 : ½</b>
Intended Use	Primer Surfacer	Primer Surfacer
VOC Less Water Less Exempts (RTS) lbs./US Gal. (g/L)	3.50 (419)	3.90 (467)
Total solids by Weight (RTS)	72.8%	67.7%
Total solids by Volume (RTS)	54.2%	48.1%
Sq. Ft. Coverage / US Gallon (1 mil 100% transfer efficiency)	868	772

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**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**

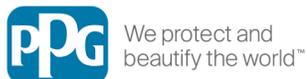
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