

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
- SX 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 Epoxy Primer	:	DPLF Catalyst	:	(optional) 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 may be used as a primer sealer on flexible parts over DELTRON® or ONECHOICE® Plastic Adhesion Promoters.



DPLF Epoxy Primer	:	DP401LF	:	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:



	DP401LF	DP402LF
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:



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



		DP401LF	DP402LF
Dry to topcoat: At 70°F (21°C)	**1 coat**	60 minutes	30 minutes
	2 coats	90 minutes	60 minutes
	Flexibilized:	30 minutes	NA



		DP401LF	DP402LF
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 recleaned. 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 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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