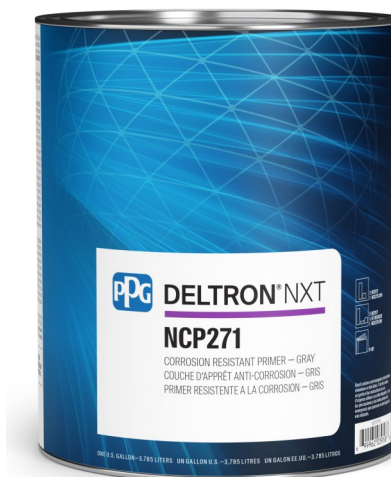


NCP271

NCP271 is a gray, premium-quality, corrosion-resistant primer developed for today's advanced technology finishes. NCP271 is free of chrome, lead and isocyanates.

NCP271 offers superior sanding characteristics and excellent gloss holdout. It can be used over sanded original finishes and properly-prepared, cleaned bare metal.

NCP271 must be mixed with NCX275 Corrosion Resistant Primer Catalyst.



Features & Benefits

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

Required Products

Hardener

NCX275 Corrosion Resistant Primer Catalyst

Compatible Surfaces

NCP271 may be applied over:

- Properly prepared and treated bare steel, galvanized steel and aluminum.
- Properly cleaned and sanded gel coated fiberglass
- Properly cleaned and sanded OEM finishes
- Properly cleaned and sanded E-Coat
- DELTRON® NXT™ Self Etching Primers*
- ONECHOICE® Etch Primers
- DPLF Epoxy Primer
- DPLV 2.1 VOC Epoxy Primer
- DF Body Fillers

Note: Not recommended over plastic substrates.

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

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.
- Reclean 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
& Pot Life:**



NCP271	:	NCX275	:	DT15xx Reducer
3	:	1	:	0-½



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

Pot Life: 1 hour at 70°F (21°C)

Additives:



None

**Air Pressure
& Gun Setup:**



HVLP: 8 - 10 psi at the air cap

Compliant: 29 - 40 psi at the gun

Fluid Tip: 1.3 - 1.6 mm or equivalent

Note: For best overall results, refer to spray gun manufacturer's recommendations for inlet air pressures.

Application:



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

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)

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

Note:



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

Sanding:



Sanding:

Grade Wet: 400-600 grit

Grade Dry Machine: 320-500 grit

Compatible Topcoats:

DPLF Epoxy Primer
 DPLV 2.1 VOC Epoxy Primer
 Deltron (DBC) Basecoat*
 Deltron NXT Basecoat*
 Deltron NXT Sealers*
 Deltron NXT Primer Surfacer*
 OneChoice Surfacer
 OneChoice Sealers
 ENVIROBASE® High Performance Basecoat*
 Envirobase High Performance Sealers

***Must be sealed before applying black DBC or NXT 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:	NCP271 : NCX275	NCP271 : NCP275 : DT15XX
RTS Combinations:	3 : 1	3 : 1 : 1/2
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

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

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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