



May 2006

Product Information

DP40 D834

*Chromate-Free 2K Epoxy Surfacer
DP40 Surfacer D834
DP402 Hardener D835*

PRODUCT DESCRIPTION

DP40 is a versatile 2K Epoxy Surfacer. It is light grey in colour, chromate-free and has good corrosion resistance over bare metal.

DP40 has good adhesion to a wide variety of suitably prepared substrates. These include bare and galvanised steel, aluminium, GRP and fibreglass, painted surfaces and fillers, and a wide range of plastic substrates.

DP40 is ideally used as a wet-on-wet or non-sand surfacer, but may be stoved or air-dried if required. It may also be used as a one-coat sealer over flatted 2K primers and surfacers, when it fills sanding marks and promotes optimum gloss holdout in the topcoat.

DP40 is also an excellent sealer for use over TPA finishes.

PREPARATION OF SUBSTRATE



SUBSTRATE

Bare Steel
Galvanised steel
Zintec
Aluminium and alloys
Electropaint
Aged painted surfaces
GRP , Fibre - glass
Polyester filler

SAND

P80-P120
P400 (dry)
Fine sanding pad
P280-P320(dry)
P360(dry)/P800(wet)
P280/P360(dry)P400-P500(wet)
P320(dry)
P80-P120(dry)



Degrease all surfaces to be painted with appropriate PPG substrate cleaner before and after sanding operation.

Clean off residues and dry thoroughly before re-cleaning with appropriate PPG substrate cleaner. See Technical Data Sheet **Deltron Cleaners RLD63**.

MIXING RATIOS

1. Mixing Ratios with Non-Sand Surfacers:

	<u>By Volume</u>
D834	1 vol
D835	1 vol

2. Mixing Ratios with wet on wet surfacer:

	<u>By Volume</u>
D834	1 vol
D835	1 vol

3. Mixing Ratios with Sealer:

	<u>By Volume</u>
D834	1 vol
D835	1 vol
Thinner*	0.5 vol


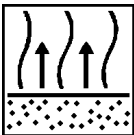
*Use GRS Thinner. D808 is recommended for most conditions.

Slower thinners (D807, D866, D812) may be used in application conditions above 30°C.

MIXED PRODUCT DETAILS



	<i>NON-SAND SURFACER</i>	<i>WET-ON-WET SURFACER</i>	<i>SEALER</i>
Pot-life 20°C	16 hours	16 hours	16 hours
Spray viscosity (DIN4 / 20°C)	15 secs	15 secs	12 secs

APPLICATION AND FLASH-OFF

	<i>NON-SAND SURFACER</i>	<i>WET-ON-WET SURFACER</i>	<i>SEALER</i>
 Spraygun set-up 1.4 - 1.8 mm	1.4 - 1.8 mm	1.4 - 1.8 mm	1.4 - 1.6 mm
	Number of coats 2 - 4	2	1 full
 Flash-off at 20°C -Between coats -Before topcoat	10 min	5 - 10 min	N/a
	45 min	15 min	10 min

These products are for professional use only

DRYING TIMES

	NON-SAND SURFACER	WET-ON-WET SURFACER	SEALER
	-Dust free at 20°C 15 min	15 min	N/a
	-Through dry at 20°C 4 hours	N/a	N/a
	-Through dry at 60°C 30 min	N/a	N/a
	-Through dry IR medium 10 min	N/a	N/a


** Stoving times are for quoted metal temperature. Additional time should be allowed in the stoving schedule to allow metal to reach recommended temperature

COVERAGE AND BUILD

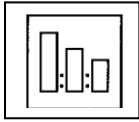
	<u>Non Sand Surfacers</u>	<u>Wet-on-Wet Surfacers</u>	<u>Sealer</u>
<i>Dry Film Build</i>	30 - 50 microns	25 - 35 microns	
<i>Theoretical Coverage*</i>	6 - 6.5 m ² /L	6.5 - 7 m ² /L	9 - 10 m ² /L

**Theoretical Coverage assumes 100% transfer efficiency & dry film build as indicated above.*

REPAIR & RECOATING

	Flattening:	Not necessary in normal use.
	Over TPA,	DP40 must be overcoated within 8 hours.
	Over other surfaces,	DP40 should be overcoated within 1 week. If not, follow the subsequent method : -Degrease (see technical datasheet) -Abrade lightly (sanding pad) -Degrease (see technical datasheet) -Apply 1 coat of DP40 overcoated within 45 minutes.
	Overcoat with:	Any Deltron 2K primer Deltron DG, Deltron BC Deltron UHS, Deltron Progress UHS DG *, Envirobase: see Technical Datasheet

DP40 2K EPOXY PRIMER D834

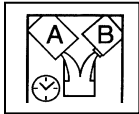


Mixing by volume

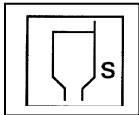
As Non sand Surfacer with D835 hardener - 1 : 1

As Sealer with D835 and thinner* - 1 : 1 : 0.5

*Use GRS thinner. D808 is recommended for most conditions, but slower thinner may be used above 30°C - e.g. D807



Pot Life at 20°C - 16 hours maximum.



Application viscosities

15 seconds DIN4 - as Non sand Surfacer

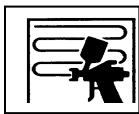
12 seconds DIN4 - as Sealer



Spraygun Sizes

1.4 - 1.8 mm Fluid Tip - Non sand Surfacer

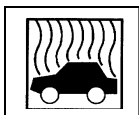
1.4 - 1.6 mm Fluid Tip - as Sealer



Number of Coats

2 - 4 as Non sand Surfacer

1 full coat as Sealer



Drying Times

Dust Free - 15 minutes

Through dry at 20°C - 4 hours

Through dry at 60°C - 30 minutes

Through dry IR - 10 minutes

Dry Film Thickness

30 - 35 microns as Non sand Surfacer

15 - 20 microns as Sealer

PERFORMANCE & LIMITATIONS



-DP40 should not be used at lower temperature than 10°C and humidity higher than 80%.

EQUIPMENT CLEANING

After use, clean all equipment thoroughly with cleaning solvent or thinner.

HEALTH & SAFETY

These products are for professional use only, and are not to be used for purposes other than those specified. The information on this TDS is based on present scientific and technical knowledge, and it is the responsibility of the user to take all necessary steps in order to ensure the suitability of the product for the intended purpose.

For Health and Safety information please refer to the material Safety Data Sheet, also available at:

http://www.ppg.com/PPG_MSDS

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