GLOBAL REFINISH
SYSTEM

February 2024

Product Information

DP3500 Primer

D8551 White
D8555 Grey
D8557 Dark Grey
D8242/D8243/D8244 UHS hardener
D8237/D8238/D8239 HS Hardeners
D8717/18/19/20 Low VOC Thinners
D808/D807/D812 Thinners

PRODUCT DESCRIPTION

DP3500 Primers are a range of 2K primer-fillers. Formulated to high solids with high in-can structure and build - they are particularly suitable for spot repair & panel repair work in the refinish bodyshop.

DP3500 primers are compatible with a range of PPG DELTRON® hardeners & thinners
DP3500 primers offer excellent film build, fast drying and good sag resistance.
After drying, DP3500 primers sand easily and have good holdout over a wide range of substrates such as sound original paintwork, bare steel, polyester body fillers and suitable adhesion primers.

These primers may be directly over coated with DELTRON UHS Progress or ENVIROBASE® High Performance basecoat.

DP3500 is a VOC Compliant primer that conforms to the European VOC directive and it provides Spectral Grey capability.

This new PPG primer uses existing hardeners and thinners in order to suit a wide range of repair sizes and temperature With characteristics like this, DP3500 is the easy to use, flexible and productive sandable primer.

A fast and easy repair and a high quality finish ensure the bodyshop remains profitable.

PREPARATION OF SUBSTRATE – DEGREASING

Before any preparation work, wash all surfaces to be painted with soap and water. Rinse and allow to dry before degreasing with a suitable PPG substrate cleaner: Ensure all substrates are thoroughly cleaned and dried before and after each stage of the preparation work. Always wipe substrate cleaner off the panel surface immediately, using a clean, dry cloth.

Please see ***Deltron*** **Cleaners (RLD63V)** Technical Data Sheet for appropriate substrate cleaning and degreasing products.

PREPARATION OF SUBSTRATE - PRIMING & SANDING

Bare Steel should be lightly abraded and completely rust free before application. DP3500 primer may be applied directly to small areas of bare steel, but Universal or Epoxy Primers, are recommended on large areas or where optimum adhesion and corrosion resistance is required.

Other bare metals should be pre-primed with either Universel or an Epoxy Primer.

Electropaint should be sanded with P360 grade paper (dry) or P800 grade (wet).

Original Paintwork or Primers should be sanded using P280-P320 grade paper (dry) or P400-P500 grade paper (wet). Spot prime any exposed bare metal with bare metal primer Universel or an Epoxy Primer.

GRP or Fibreglass should be sanded using P320 grade paper (dry).

Polyester Fillers should be dry sanded using a sequence of grade of paper grades P80-P120-P240

HARDENER & THINNER SELECTION

Temperature	**UHS Hardeners 5:1**	**HS Hardeners 4:1**	**Thinner**
Below 20°C	D8242	D8237	D808/D8717
Up to 25°C	D8243	D8237/D8238	D807/D8717/D8718
25-35°C	D8244	D8238/D8239	D812/D8718/D8719
Above 35°C	D8244	D8239/	D812/D8719

MIXING HS HARDENER

Product is thixotropic - Hand stir before use.

Mixing Ratio:	DP3500	4 vol
	D823x	1 vol
	Thinner	0,5-1 vol

MIXING UHS HARDENER

Mixing Ratio:	DP3500	5 vol
	D824x	1 vol
	Thinner	0,5-1,5 vol

Note: For accurate activation and thinning, weight mixing is recommended
(See tables on Pages 5 and 6)

MIXED PRODUCT DETAILS

Pot-life at 20°C: 30-40 min at 20°C.
Clean gun immediately after use.

Spray viscosity
DIN4/20°C: 18 - 27 seconds or higher pending on dilution ratio

SPRAYGUN SETUP

Gravity gun recommended.

Fluid Tip, 1.6 - 1.8 mm
Pressure: Follow spraygun manufacturer's recommendations (normally 2 bar / 30 psi)

APPLICATION GUIDE

Number of coats: Normally 3 coats (1st light coat for isolation can be recommended.)

Flash off/20°C:

- Between coats	Until fully matt – normally 3-5 mins
- Before stoving	Until fully matt (Minimum 5 mins before IR drying)

DRYING TIME

		Sandable / 20°C	*Bake / 60°C
Using Fast	D8237/D8242	1.5 hours	15 mins
Using Standard	D8238/D8243	2.5 hours	20 mins
Using Slow	D8239/D8244	3 hours	30 mins
Infra Red Drying		Guide time 10-15 minutes	

Infrared drying times given require the short wave infrared lamp to be positioned 70-100 cm away from the panel. Allow the primer surfacer to flash off for 5 minutes before drying with the infrared lamp. Drying times will depend on the type of infrared lamp used.

Notes:
* Drying time once substrate reaches 60°C metal temperature.
- Drying times depend on the film thickness.
- Allow panels to cool fully after bake or IR drying cycle before attempting to sand.

FILM PROPERTIES

Dry film build depends on the application technique and spraygun used.

- 3 Coats expected build	170-200 microns

SANDING

Finish with the following grades: - P360 or finer: Single layer solid colours (Direct Gloss)
P400 or finer: Basecoats

Finish with the following grades: - P600 or finer: Single layer solid colours (Direct Gloss)
P800 or finer: Basecoat

TOPCOATING

After sanding, DP3500 primer may be overcoated directly with the following topcoats:

Deltron GRS BC, Deltron GRS DG, DELTRON UHS Progress or ENVIROBASE® High Performance basecoat.

GREYMATICS

The mixtures below should be activated and thinned in the normal way before spraying.

For each of the DP3500 primer variants specified the following weight mix ratios apply:

	G1	***G3***	***G5***	***G6***	***G7***
D8551 White	***100***	**75**	**--**	**--**	**--**
D8555 Grey	**--**	**25**	***100***	**30**	**--**
D8557 Dark Grey	**--**	**--**	**--**	**70**	***100***

WEIGHT MIXING

Weight Activations for use with HS hardeners (D8237/D8238/D8239) **Ratio 4 : 1 : 1**			
	Please note the weights are cumulative. Do not tare or zero scale between additions		
RFU Sprayable Volume (4 : 1 : 1 ratio)	Wt. Primer Grams (4 Parts)	Wt. Hardener **D823x** Grams (1 Part)	Wt. Thinner Grams (1 Part)
0.25 L	270,2	311,0	347,3
0.5 L	540,3	622,0	694,5
0.75 L	810,5	933,0	1041,8
1.0 L	1080,7	1244,0	1389,0
1.5 L	1621,0	1866,0	2083,5

Weight Activations for use with UHS hardeners (D8242/D8243/D8244) Ratio 5 : 1 : 1			
	The weights are cumulative. Do not tare or zero scale between additions		
RFU Sprayable (5 : 1 : 1 Vol)	Wt Primer Grams (5 Parts)	Wt Hardener **D824x** Grams (1 Part)	Wt. Thinner Grams (1 Parts)
0.25L	292,0	327,3	358,4
0.5L	583,9	654,6	716,8
0,75L	875,9	982,0	1075,2
1L	1167,9	1309,3	1433,6
1,5L	1751,8	1963,9	2150,4

FLEXIBLE SUBSTRATES

Deltron Plasticiser D814 can be used when DP3500 Primer is being used on a very flexible substrate.

Weight Activations for use with HS hardeners (D8237 / D8238 / D8239)

	Mixing Ratio:
DP3500 Primer	3.2 vol
D814	0.8 vol
Hardener	1 vol
Thinner	0.5 vol

Weight Activations for use with UHS hardeners (D8242 / D8243 / D8244)

	Mixing Ratio:
DP3500 Primer	4 vol
D814	1 vol
Hardener	1 vol
Thinner	0.5/1,5 vol

LIMITATIONS

Part used cans of hardener must be carefully closed immediately after use.
All equipment must be perfectly dry and clean.

Clean sprayguns immediately after use.

VOC INFORMATION

The EU limit value for this product (product category: IIB.c) in ready to use form is max. 540g/litre of VOC. The VOC content of this product in ready to use form is max. 540g/litre.
Depending on the chosen mode of use, the actual ready to use VOC of this product may be lower than that specified by the EU Directive code.

HEALTH AND 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: **www.ppgrefinish.com**