DPLV Low VOC Epoxy Primer P-245

DPLV

DPLV Low VOC Epoxy Primer provides excellent adhesion and corrosion resistance to many types of properly prepared steel, aluminum, and fiberglass substrates. DPLV Epoxy Primer may also be used as a sealer and top coated with many of PPG's two component urethane undercoats and topcoats as well as both solvent and waterborne basecoats.

DPLV Low VOC Epoxy Primer is available in 3 colors - DP48LV White, DP50LV Gray and DP90LV Black - that can be blended together to achieve the full range of gray shades, G1-G7.

Features & Benefits

- Direct to metal
- Excellent adhesion and corrosion resistance
- Primer / Sealer
- Three colors available

Compatible Surfaces

DPLV 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
- Various cleaned and sanded rigid plastic*: ABS, Nylon, Polycarbonate, Noryl, PBT or SMC.
- Properly cleaned and sanded OEM Finishes - for OE lacquer see ++Caution statement
- Cured and sanded refinish coatings
- DF Body Fillers
- SX Metal Treatments

NOTE: DPLV is direct to metal and MUST NOT be applied over etch or wash primers. Film build of 1.2-1.5 mils of DPLV 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 DPLV epoxy primer.

Required Products

Hardener

DP401LV Low VOC Epoxy Hardener

Reducer

DT1845	Compliant Reducer Normal
DT1850	Compliant Reducer Medium
DT1855	Compliant Reducer Slow

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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 with 320-400 grit dry by hand or machine or 600 grit wet.
- Re-clean with the appropriate PPG cleaner
- Prime aluminum substrate within 8 hours
- Prime carbon steel immediately after cleaning

Mix Ratio:

DPLV Low VOC Epoxy Primer	:	DP401LV Low VOC Epoxy Hardener	:	DT18xx Reducers
2	:	1	:	1

Pot Life: 8 hours at 70°F (21°C)

Note: Thoroughly mix primer, hardener and reducer. Mechanical agitation is recommended. No induction period is necessary.

DPLV Epoxy Primer cannot be tinted
DPLV Epoxy colors may be blended together
Note: Do Not Blend DPLV and DPLF together

Additives:

None

Air Pressure and Gun 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:

Apply:	Standard	Flexible Parts*
	1 - 2 wet coats	1 full wet coat

Dry film build per coat: .75 - 1.5 mils.

*Note: Un-primed plastics will require the use of a Plastic Adhesion Promoter prior to the application of DPLV Low VOC Epoxy Primer.

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Drying Times:

Between Coats: 10-15 minutes at 70°F (21°C)

To Topcoat:

1 Coat	30 minutes at 70°F (21°C)
2 Coats	60 minutes at 70°F (21°C)

To Apply Body Filler:

2 Coats	Overnight dry

Note: DPLV Epoxy Primer may be recoated any time up to 1 week.
After 1 week surface must be cleaned, sanded and re-cleaned. Reapply 1 additional coat of DPLV Epoxy Primer only if applying basecoat directly to DP.

Compatible Topcoats:

DPLV Low VOC Epoxy Primer may be topcoated with:
DF Body Fillers
DELTRON® (NXT) Basecoat
Deltron 2000 (DBC) Basecoat
Deltron primers, surfacers, and sealers
ONECHOICE® surfacers and sealers
ENVIROBASE® High Performance Basecoat
Envirobase High Performance primers, surfacers, and sealers

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.

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DPLV Gray Mixing Chart

This chart can be used to mix the DPLV Low VOC Epoxy Primer. The G1-G7 ratios will help to achieve better hiding when used as a guide for mixing the DPLV Low VOC Epoxy Primer

Mix Ratio By Volume			Mix Ratio By Cumulative Weight							
			Grams				Parts			
	Mix Ratio		¼ Pint	½ Pint	Pint	Quart	¼ Pint	½ Pint	Pint	Quart
G1	DP48LV	2	90	180	360	720	102	203	406	812
	DP401LV	1	122	243	486	971	137	274	548	1095
	DT18xx	1	157	314	628	1256	177	354	708	1416
G3	DP48LV	1.5	92	185	270	540	76	152	304	609
	DP50LV	.5	88	176	353	706	99	199	398	796
	DP401LV	1	120	239	478	957	134	269	539	1076
	DT18xx	1	155	310	621	1242	175	350	700	1401
G5	DP50LV	2	83	166	331	662	93	186	373	746
	DP401LV	1	114	228	456	913	129	258	515	1030
	DT18xx	1	150	300	599	1198	169	338	676	1351
G6	DP50LV	1	42	83	166	331	46	93	186	373
	DP90LV	1	82	164	328	656	92	185	370	740
	DP401LV	1	114	227	454	907	128	256	512	1023
	DT18xx	1	149	298	596	1192	168	336	672	1344
G7	DP90LV	2	81	162	325	650	92	183	366	733
	DP401LV	1	112	225	450	901	127	254	508	1016
	DT18xx	1	148	296	593	1186	167	334	669	1338

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RTS Combinations:	DPxxLV : DP401LV : DT18xx
Volume Ratio:	2 : 1 : 1
Applicable Use Category	Primer
VOC Actual (g/L)	139-141
VOC Actual (lbs/Gal)	1.16-1.18
VOC Regulatory (less water less exempt) (g/L)	238-246
VOC Regulatory (less water less exempt) (lbs./gal)	1.99-2.05
Density (g/L)	1207-1366
Density (lbs/Gal)	10.07-11.40
Volatiles wt. %	44.8-52.0
Water wt. %	0.0
Exempt wt. %	33.8-41.1
Water vol. %	0.0
Exempt vol. %	40.7-43.3
RTS Solids wt. %	48.0-55.3
RTS Solids vol. %	39.9-42.0
Sq. Ft. Coverage at 1 mil. at 100% transfer efficiency	640-674

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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