

DPS3105

DPS3105 Quick Prime Urethane Surfacer is a speed primer designed for spot and panel repairs which offers outstanding film build, fast dry to sand times and excellent resistance to film shrinkage.

DPS3105 is easy to spray and can be applied to a wide range of substrates. DPS3105 is also rollable. This versatile surfacer is ideal for production-minded collision centers performing premium quality refinish work.



Features & Benefits

- Sand in as little as 30 minutes
- High build
- Highly productive
- Resistant to film shrinkage

Compatible Surfaces

DPS3105 may be applied over:

- Properly cleaned and sanded fiberglass
- Properly cleaned and sanded E-Coat
- Cured and sanded OEM finishes
- Properly prepared and treated bare steel, galvanized, and aluminum
- DELTRON® Plastic Adhesion Promoter
- *Deltron* Etch Primers
- *Deltron* 2K Primer Surfacers*
- DF Body Fillers
- DPLF Epoxy Primer*
- DPLV 2.1 VOC Epoxy Primer*
- ONECHOICE® Plastic Adhesion Promoters
- *OneChoice* Etch Primers

*Maintain a minimum dry film of 2.0 mils after sanding. Insufficient DPS3105 films may result in lifting on color application.

Required Products

Hardener

DCX3030 Undercoat Hardener
DCX3035 Undercoat Hardener - High Temp 90°F (32°C) and above

Reducer

DT1565 Fast Thinner (55 to 65°F)
DT1575 Medium Thinner (65 to 77°F)
DT1585 Slow Thinner (77 to 90°F)
DT1595 Very Slow Thinner (95+°F)

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 bare metal should be spot primed with a suitable bare metal primer
- Re-Clean with the appropriate PPG cleaner.
- Prime aluminum substrate within 8 hours
- Prime carbon steel immediately after cleaning.

Mix Ratio:



Standard:

DPS3105	:	DCX3030/DCX3035 Hardener	:	DT15xx Reducers
4	:	1	:	1

Rollable:



DPS3105	:	DCX3030/DCX3035 Hardener
4	:	1

Note: Reducer is not required for rollable application.



Pot Life: Standard with DCX3030:	25-30 minutes at 70°F (21°C)
High Temp with DCX3035:	15-20 minutes at 90°F (32°C)
Rollable:	20 minutes at 70°F (21°C)

Note: Pot Life may be considerably shorter when temperatures exceed 70°F (21°C). Clean equipment immediately after each use. **Best practice is to Mix, Shoot, Clean**



SL814 Universal Flexibilizer: 5% to RTS mix

Note: Allow increased flash time between coats. The use of SL814 will slow flash and overall dry times.

Application:



Apply: 2-3 medium wet coats

Dry film build per coat: 2.0-2.5 mils

Total dry film build:

Minimum after sanding	2.0 mils
Maximum after sanding	6.0 mils

Air Pressure and Gun Setup:



HVLP: 10 psi at the air cap
Compliant: 29 - 40 psi at the gun

Fluid Tip: 1.4 - 1.8 mm or equivalent



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

DPS3105 Quick Prime Urethane Surfacer

P-247

Drying Times:



Between Coats: 3-5 minutes at 70°F (21°C)

As temperatures increase above 70°F (21°C), the appropriate flash time will become shorter.
Back-to-back coats may be necessary with increased temperatures.



Air Dry to sand: 30-45 minutes at 70°F (21°C)

Note: Increased film builds will extend dry to sand times.



Force Dry to sand*: 10-15 minutes at 140°F (60°C)

IR:

Medium Wave: 10 minutes

Short Wave: 5 minutes

Sanding:



Sanding:

Grade Wet: 400-600 grit

Grade Dry Machine: 320-500 grit

Note:



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

Compatible Topcoats:



*Deltron NXT **

Deltron Sealers

DPLV 2.1 VOC Epoxy Primer

DPLF Epoxy Primer

OneChoice Sealers

ENVIROBASE® High Performance Sealers

Envirobase High Performance Basecoat

*Must be sealed before applying black DBC

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:

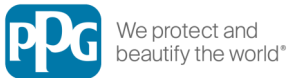
	DPS3105 : DCX3030/3035 : DT15xx	DPS3105 : DCX3030/3035 : DT8xx +SL814
Volume Ratio	4 : 1 : 1	4 : 1 : 1 +5%
Applicable Use Category	Primer Surfacer	Specialty
VOC Regulatory (less water less exempt) (g/L)	435-473	445-483
VOC Regulatory (less water less exempt) (lbs./gal)	3.63-3.95	3.71-4.03
Total Solids by Weight (RTS)	59.4-60.0	58.6-59.1
Total Solids by Volume (RTS)	41.1	40.5
Sq. ft. coverage / US gal. (1 mil. At 100% transfer efficiency)	659	650

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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