



NCP250

NCT® Primer Surfacer NCP250 is a reddish gray, direct to metal, isocyanate free, two component surfacer designed for today's advanced technology finishes. High build, fast drying and easy sanding qualities make *NCT* Primer Surfacer a useful tool in refinish applications.



Features & Benefits

- Isocyanate-free
- Direct to metal
- High build
- Fast drying

Compatible Surfaces

NCP250 Primer Surfacer may be applied over:

- Properly cleaned and sanded bare steel, carbon steel, and aluminum
- 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® Plastic Adhesion Promoter*
- DPLF Epoxy Primer*
- DPLV 2.1 VOC Epoxy Primer*
- ONECHOICE® Plastic Adhesion Promoters

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

Required Products

Hardener

NCX255 *NCT* Primer Surfacer Activator

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Surface Preparation



NCT Primer Surfacer

- 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
- A two step metal treatment, or etch primer will improve the adhesion and performance properties of the finished system.
- A two step metal treatment is required over sanded clean galvanized steel substrate.
- Prime aluminum within 8 hours.
- Prime carbon steel immediately after cleaning.

Mix Ratio:



NCP250	:	NCX255
4	:	1



Pot Life: 1 hour at 70°F (21°C)

Pot life is shortened as temperatures increase

Additives:



DX814 Universal Flexibilizer:

SL814 Universal Flexibilizer:

NCP250	:	NCX255	:	DT8xx Reducer	:	DX814/SL814
4	:	1	:	2	:	1

Apply a maximum of 3 coats of flexibilized NCT Surfacer. Keep dry films below 5.0 mils before sanding.

Air Pressure and Spraygun Set-Up:



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: 2-4 coats

Dry film build per coat: 1.6-2.1

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Drying Times:



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



Air Dry to Sand*:
2-3 coats: 1-2 hours at 70°F (21°C)
4 coats: 4 hours at 70°F (21°C)

* Film should not exceed 8.0 mils before sanding.



Force Dry to Sand:
Purge Time: 10 minutes at 70°F (21°C)
Bake: 30 minutes at 140°F (60°C) and cool down



IR (Infrared):
Medium Wave: 20 minutes
Short Wave: 10 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 Sealers
 DPLF Epoxy Primer
 DPLV 2.1 VOC Epoxy Primer
 DX54 ROADGUARD® Chip Resistant coating
OneChoice Sealers
 CONCEPT® (DCC) Acrylic Urethane
 DELSTAR®/DELTHANE® (DAR/DXR80) Polyurethane
*Deltron 2000 (DBC) Basecoat**
Deltron (DBU) Universal Basecoat
 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 PPG general purpose solvent, lacquer thinner or DT Reducer.

Technical Data:

Ready to Spray (4:1)
 Intended Use: Primer Surfacer
 VOC Less Water Less Exempts (RTS): 4.64 lbs./US gal. (556 g/L)
 Total Solids by Weight (RTS): 53.2%
 Total Solids by Volume (RTS): 33.5%
 Sq. Ft. Coverage / US Gallon (RTS): 538 at 1 mil, 100% transfer efficiency

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See Safety Data Sheet/Material 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

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