

Low VOC Primer

DPHS52

DPHS52 is a 3.5 VOC epoxy primer or primer surfacer designed specifically for use in fleet refinishing operations. The product is lead and chrome free, and exhibits excellent filling and adhesion properties when applied over properly prepared steel, aluminum, fiberglass and most plastic substrates. DPHS52 requires the addition of DPHS521 non-isocyanate hardener. Pot life may be extended with the addition of DX89.

Features	Advantages	Benefits
• High Solids	• Better Fill	• Cost Effective
• Simple Mix Ratio	• User Friendly	• Better Productivity
• Sandable	• Use as primer or surfacer	• Reduced Inventory

Compatible Surfaces

DPHS52 may be applied over:

- Properly cleaned and sanded: steel, aluminum, *galvaneal and *galvanized steel
- Cured and sanded OEM finishes
- Properly cleaned and sanded fiberglass
- DX1793 Chrome Free Self Etching Primer
- DPU166 High Solids Chromate Primer 2.8 VOC Max.
- DPU174 High Solids Polyurethane Primer (Chrome Free)

If sanding bare metal areas prior to the application of DPHS52, use 180-240 grit wet or dry. Sand old finishes with 280-400 grit wet or dry.

Prime aluminum, stainless and carbonated steel immediately after cleaning and sanding.

*Galvanized and galvaneal steel must be primed with DX1793 before applying DPHS52

Hardener	
Low VOC Primer Hardener	DPHS521



APPLICATION GUIDE DPHS52

Mixing Ratio:

DPHS52 : DPHS521

2 parts : 1 part

Pot life:

1.5 hours @ 70°F and 50% RH

(High heat and humidity will shorten pot life.)

Additives:

Accelerator: No Recommendation

Extender: DX89 up to 10 oz. maximum/RTS gal.*

Fisheye: No Recommendation

Flex: No Recommendation

Flattening: No Recommendation

*DX89 extends pot life to 2 hours and results in slower dry times. Use of DX89 will not affect VOC of the mixed primer.

Spraygun set-up:**Fluid Tip**

1.0 - 1.4 mm for Pressure Feed/HVLP

1.4 - 1.6 mm for Conventional Feed/HVLP

Air Pressure

HVLP at air cap 10 PSI

Conventional at spray gun 50-60 PSI

Consult the Fleet Training Manual Spray Equipment Section for gun set-up requirements.

Minimum number of coats:

1 wet coat as a non sanding primer

2-3 wet coats as a primer surfacer

Total film build per coat:

	<u>Wet</u>	<u>Dry</u>
Minimum	2.8 mils	1.5 mils
Maximum	11.2 mils	6.0 mils

Note: Extreme film builds will significantly lengthen dry times to sand and topcoat

Flash Time at 70°F:

Between coats 10 minutes

Before force drying 20 minutes

Force dry 40 minutes at 140°F (60°C)

Drying times:

Dust: 20-60 minutes at 2.5 mils

Tack: 40-60 minutes

Dry Time to Sand:

3-5 hours at 70°F

Dry Time to Topcoat:

45 minutes at 70°F. Must be sanded after 3 days.

TEST PROPERTIES

Color	Gray
VOC Packaged	3.2 lbs. per U.S. gal.
VOC RTS Applied	3.5 lbs. per U.S. gal.
Volume Solids (RTS)	54.7%
Square Foot Coverage (RTS US Gallon 100% Transfer Efficiency)	877 sq. ft.

Compatible Topcoats:

DELTA® (DSS) Medium Solids Polyurethane
DELTA® (DFHS) Fast Dry High Solids Polyurethane
DELTA® (DUHS) High Solids Polyurethane
DELTA® (DUHS) Basecoat

DELTA® (DVHS) Fast Dry 2.8 VOC Polyurethane
DELTA® (DGHS) Chemical Resistant Polyurethane 3.5 VOC
DELTA® (DGHS) Chemical Resistant Polyurethane 4.4 VOC
DELTA® (DHS) 2.8 VOC Polyurethane



INSTRUCTIONS FOR USE

How to Mix:



Mix DPHS52

DPHS52 : DPHS521

2 : 1

Pot life: 1.5 hours at 70°F

Air Pressure:



HVLP: 10 PSI at the air cap

Conventional: 50-60 PSI at the gun

Fluid tip: 1.0 -1.4 mm for Pressure Feed/HVLP
1.4 -1.6 mm for Conventional Feed/HVLP

Application:



Apply: 1 wet coat as a non-sanding primer or
2-3 coats as a primer surfacer

Dry Time:



Between coats: 10 minutes

Dry to Topcoat: 45 minutes at 70°F

Dry to Sand: 3-5 hours at 70°F

Purge Time: 20 minutes

Force Dry: 40 minutes at 140°F

PRODUCTS NEEDED FOR JOB

For additional information,
refer back to the complete FL301

HEALTH AND SAFETY

See Material Safety Data Sheet and Labels for additional safety information and handling instructions.

Emergency Medical or Spill Control Information (304) 843-1300; 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 general public. Products mentioned may be hazardous and should only be used according to directions, 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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