

# NCP450

DELTRON® NXT™ NCP450 Iso-Free Primer Surfacer provides excellent bare metal adhesion and corrosion protection without the need of an etch primer or other metal treatment.

NCP450 builds quickly, sands easily, and has excellent color holdout. It is both rollable or sprayable.

NCP450 must be mixed with NCX455 Iso-Free Catalyst.



## Features & Benefits

- Isocyanate-free
- Direct to metal
- High build
- Fast drying
- Compliant for all markets

## Required Products

### Hardener

NCX455 Iso-Free Catalyst

### Reducers

- DT1565 Fast Thinner (55-65°F)
- DT1575 Medium Thinner (65-77°F)
- DT1585 Slow Thinner (77-90°F)
- DT1595 Very Slow Thinner (95+°F)
- DT1845 Compliant Reducer-Normal (60-70°F)
- DT1850 Compliant Reducer-Medium (65-80°F)
- DT1855 Compliant Reducer-Slow (75-90°F)

## Compatible Surfaces

NCP450 may be applied over:

- Properly cleaned and sanded bare steel, galvanized 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
- ONECHOICE® Etch Primers
- *Deltron NXT* Plastic Adhesion Promoter\*
- *OneChoice* Plastic Adhesion Promoter\*
- DPLF Epoxy Primer\*
- DPLV 2.1 VOC Epoxy Primer\*

\*Maintain a minimum dry film of 2.0 mils after sanding. Insufficient NCP450 film may result in lifting on color application.

## 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 carbon steel immediately after cleaning.**

**Mix Ratio  
& Pot Life:**



**Primer Surfacer**

NCP450 : NCX455 : DT Reducers  
4 : 1 : 1



**Primer Filler/Roll**

NCP450 : NCX455 : DT Reducers  
4 : 1 : 0 - 1/2



**Pot Life:** 2 hours at 70°F (21°C). Note: Pot life is shortened as temperatures increase.

**Additives:**



None

**Air Pressure  
& Gun Setup:**



**HVLP:** 8 - 10 psi at the air cap

**Compliant:** 35 - 45 psi at the gun

**As a primer surfacer As a spray filler**

**Fluid Tip:** 1.4 - 1.8 mm 1.6 - 2.0 mm

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

**Spray  
Application:**



**Apply:** 2 - 3 medium wet coats

Allow for full flash between coats depending on desired film

**Film build per coat:** Primer Surfacer: 1.5 - 2.0 mils

Primer Filler: 2.0 - 2.5 mils

**Roller  
Application:**



**Apply:** One medium-wet coat. Allow to flash completely between coats

Apply 1-3 coats depending on desired build

**Film build per coat:** 2.0 - 2.5 mils

**Drying Times:**



**Between Coats:** 5 - 10 minutes at 70°F (21°C)



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



**Force Dry to Sand: (Primer Surfacer only):**

Purge Time: 20 minutes at 70°F (21°C)

Bake: 30 minutes at 140°F (60°C)



**IR (Infrared):**

Short Wave: 10 minutes

Medium Wave: 20 minutes

**Note:**



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

**Sanding:**



**Sanding:**

**Grade Dry Machine:** 320-500 grit

**Compatible Topcoats:**

DELTRON® Sealers  
 DPLF Epoxy Primer  
 DPLV 2.1 VOC Epoxy Primer  
 ONECHOICE® Sealers  
 DELTRON® 2000 (DBC) Basecoat\*  
 DELTRON® NXT 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 appropriate PPG general purpose solvent.

**Technical Data:**

RTS Combinations	<u>NCP450 : NCX455 : DT15XX</u>	<u>NCP450 : NCX455 : DT15XX</u>	<u>NCP450 : NCX455 : DT18XX</u>	<u>NCP450 : NCX455 : DT18XX</u>
Mix Ratio	4:1:½	4:1:1	4:1:½	4:1:1
Applicable Use Category	Primer Filler	Primer Surfacer	Primer Filler	Primer Surfacer
VOC Actual (g/L)	192-229	211-280	160	174
VOC Actual (lbs./gal.)	1.60-1.91	1.76-2.34	1.45	1.33
VOC Regulatory (less water less exempt) (g/L)	292-330	326-388	250	250
VOC Regulatory (less water less exempt) (lbs./gal.)	2.44-2.75	2.72-3.24	2.1	2.1
Total Solids by Weight	62.9	59.5	62.9	59.5
Total Solids by Volume	40.5	37.1	40.5	37.1
Sq. Ft. Coverage/US Gal., 2.0 mil at 100% transfer efficiency	325	298	325	298

**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**

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PPG automotive refinish  
 19699 Progress Drive  
 Strongsville, OH 44149  
 800.647.6050

PPG Canada Inc.  
 2301 Royal Windsor Drive, Unit #6  
 Mississauga, Ontario L5J 1K5  
 888.310.4762



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Product Information Effective 11/25

P-250