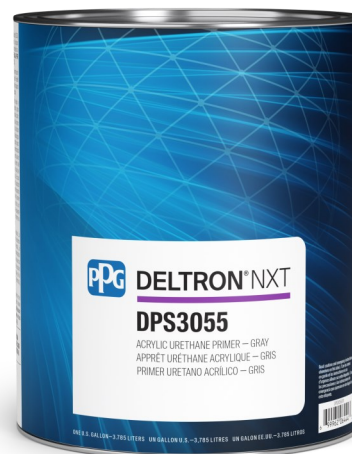


# DPS3055

DPS3055 is a premium quality primer surfacer suitable for the wide range of day-to-day repair work done in today's refinish body shops.

DPS3055 offers excellent adhesion, film build, surface leveling and gloss holdout over a wide range of substrates.

This versatile, quick drying, easy to apply and sand primer may be applied as a conventional spray filler or primer surfacer.



## Features & Benefits

- Fast dry
- Easy to sand
- Superior holdout
- Faster process times

## Required Products

### Hardener

DCX3030 Undercoat Hardener

### Reducers

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)

## Compatible Surfaces

DPS3055 may be applied over:

- 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
- DF Body Fillers
- *Deltron* 2K Primer Surfacers\*
- DPLF Epoxy Primer\*
- DPLV 2.1 VOC Epoxy Primer\*
- *Deltron* Self Etching Primers\*
- ONECHOICE® Plastic Adhesion Promoters
- *OneChoice* Etch Primers

\*Maintain a minimum dry film of 2.0 mils after sanding. Insufficient DPS3055 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.
- Exposed bare metal should be spot primed with a suitable bare metal primer
- Re-Clean with the appropriate PPG cleaner.
- Prime aluminum substrates within 8 hours
- Prime carbon steel immediately after cleaning.

### Mix Ratio & Pot Life:



As a spray filler:

<b>DPS3055</b>	:	<b>DCX3030 Hardener</b>
4	:	1

As a primer surfacer:



<b>DPS3055</b>	:	<b>DCX3030 Hardener</b>	:	<b>DT Reducer</b>
4	:	1	:	1/2 - 1



**Pot Life:** 30 minutes at 70°F (21°C) as a Spray Filler  
1 hour at 70°F (21°C) as a Primer Surfer

**Tinting of DPS3055 is not recommended**

### Additives:



**SL814 Universal Flexibilizer** 10% to RTS mix

### Air Pressure and Gun Setup:



**HVLP:** 8-10 psi at the air cap  
**Compliant:** 29-40 psi at the gun

	<u>As a spray filler</u>	<u>As a primer surfacer</u>
<b>Fluid Tip:</b>	1.7-2.0 mm or equivalent	1.6-1.8 mm or equivalent

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

### Application:



	<u>As a spray filler</u>	<u>As a primer surfacer</u>
<b>Coats:</b>	Up to a maximum of 4 wet coats	2-3 wet coats
<b>Dry film build per coat:</b>	1.7-2.0 mils	1.5-1.8 mils

### Drying Times:



	<u>As a spray filler</u>	<u>As a primer surfacer</u>
<b>Between Coats:</b>	5-10 minutes at 70°F (21°C)	5-10 minutes at 70°F (21°C)



**Air Dry :**

<b>Dust Free:</b>	15 minutes at 70°F (21°C)	15 minutes at 70°F (21°C)
<b>To Sand:</b>	6 hours/overnight at 70°F (21°C)	1½ hours at 70°F (21°C)



**Force Dry to Sand:**

<b>Purge:</b>	N/A	10 minutes at 70°F (21C)
<b>Bake:</b>	Do not force dry	30 minutes at 140°F (60C) and cool down



**IR:**

<b>Medium Wave:</b>	Do not IR force dry	20 minutes
<b>Short Wave:</b>	Do not IR force dry	10 minutes

### Sanding:



**Sanding:**

<b>Grade Wet:</b>	400-600 grit
<b>Grade Dry Machine:</b>	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:

May be topcoated with:  
*Deltron NXT Sealers*  
*DPLF Epoxy Primer*  
*DPLV 2.1 VOC Epoxy Primer*  
*OneChoice Sealers*  
*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 PPG general purpose solvent, lacquer thinner or DT Reducer.

## Technical Data:

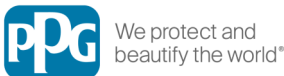
	As a spray filler	As a primer surfacer
Volume Ratio	4 : 1	4 : 1 : 1
Intended Use	Primer Surfacer	Primer Surfacer
VOC RTS lbs./ per US Gallon	4.21	4.68
Total Solids by Weight (RTS)	63.8%	56.8%
Total Solids by Volume (RTS)	42.0%	35.1%
Sq. Ft. Coverage / US Gallon / 100% Transfer Efficiency (RTS)	675	562
Recommended wet film build per coat	5.0 mils	4.0 mils
Recommended dry film build per coat	2.0 mils	1.5 mils

**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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