

DTM High Build Primer

VP2050

VP2050 DTM High Build Primer is a two component, gray, direct to metal high build primer that is easy to apply and sand, and offers excellent adhesion and corrosion protection. VP2050 may be applied over properly prepared steel, aluminum, fiberglass, and existing coatings in good condition.

This bulletin for VP2050 is for use in low VOC compliant refinish markets. For use in National Rule refinish markets, see bulletin VB-18NR.

For procedures relating to custom and/or restoration work refer to PPG's Custom Restoration Guide available at ppgrefinish.com under Training.



Compatible Products and Systems

VP2050 DTM High Build Primer may be applied over the following:

- Fully cured, cleaned and sanded OEM and refinish paints, properly prepared and treated bare steel, aluminum and fiberglass substrates. **Note:** 1K Lacquer finishes must be removed prior to application.

Compatible Topcoats

- DELTRON® Low VOC surfacers
- ENVIROBASE® High Performance surfacers or sealers
- Envirobase High Performance Refinish Systems - Follow EB-143 *Envirobase* High Performance Waterborne Basecoat recommendations for proper preparation
- VIBRANCE COLLECTION® topcoat system

Note: Custom or exotic finishes are excluded from coverage under the PPG Paint Performance Guarantee.

Required Products

Hardener

VH7050 DTM Primer Hardener

Reducer

DT1845	Compliant Reducer Normal	up to 65°F (18°C)
DT1850	Compliant Reducer Medium	65 - 77°F (18 - 25°C)
DT1855	Compliant Reducer Slow	77 - 95°F (25 - 35°C)

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Surface Preparation



- Wash the area to be painted with soap and water, then clean with an 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 an appropriate PPG cleaner.
- Prime aluminum substrate within 8 hours of sanding and cleaning.
- Prime carbon steel immediately after sanding and cleaning.

Mixing Ratio:



VP2050	:	VH7050 Hardener	:	DT18xx Reducer
2	:	1	:	½



Pot Life: 2 hours at 70°F (21°C)

Additives:



None

Air Pressure
And Gun Setup:

HVLP: 8 - 10 psi at the air cap
Compliant: 29 - 40 psi at the gun
Gun Setup: 1.4 - 1.8 mm or equivalent

Refer to spraygun manufacturer's recommendations for inlet air pressures.

Application:



Apply: 1 - 4 medium wet coats

Dried Film Build Per Coat: 2.0 - 2.5 mils

Note: Do not exceed 8 mils dry after sanding.

Drying Times



Between Coats: 10 - 15 minutes at 70°F (21°C)*

* Be sure the prior coat has completely flashed before applying additional coats.

**Air Dry:**

Dust Free: 1 hour at 70°F (21°C)
Tape Time: 8 - 12 hours at 70°F (21°C)
Air Dry: 16 - 24 hours / overnight at 70°F (21°C)



Topcoat: 1 hour to 4 days at 70°F (21°C)

**Force Dry:**

Purge: 15 minutes at 70°F (21°C)
Bake: 40 minutes at 140°F (60°C)

**IR (Infrared):**

N/A

VP2050

Topcoat, Recoat and Repair



Recoat:

Air Dry:

1 hour to 4 days at 70°F (21°C)

Force Dry:

After cool down

Repair:

16 - 24 hours / overnight or after force dry and cool down

Body Filler may be applied over VP2050 after an overnight dry and a light sanding. If applying body filler, two coats of VP2050 must first be applied.

If preferred, VP2050 may be directly topcoated or sealed with a compatible PPG sealer.

VP2050 may be recoated without sanding up to 4 days. After 4 days, VP2050 must be lightly sanded and cleaned before top coating.



Note: All force dry times are quoted for surface temperature. Additional time must be allowed during force dry to allow surface to reach recommended temperature.

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	VP2050 : VH7050 : DT18xx
Volume Ratio:	2 : 1 : ½
Applicable Use Category	Primer
VOC Actual (g/L)	175
VOC Actual (lbs./ US gal.)	1.46
VOC Regulatory (g/L) (Less Water, Less Exempt)	234
VOC Regulatory (lbs./ US gal.) (Less Water, Less Exempt)	1.95
Density (g/L)	1266 - 1305
Density (lbs./ US gal.)	10.56 - 10.89
Volatiles wt.%	38.3
Water wt.%	0.5
Exempt wt.%	22.0 - 24.4
Water vol.%	0.7
Exempt vol.%	24.2
Solids vol.%	53.39
Solids wt.%	64.67 - 65.76
Sq. Ft. Coverage / US gal. (1 mil. At 100% transfer efficiency)	863

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.

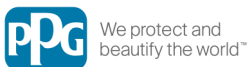
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