

DPLF Epoxy Primer

# DPLF

DPLF Epoxy Primer mixed 2:1 with DP401LF or DP402LF Catalyst provides an excellent corrosion-resistant primer. This primer provides excellent adhesion to many types of properly prepared metal, fiberglass and aluminum substrates, as well as plastic fillers. DPLF Epoxy Primer may also be used as a sealer and topcoated with most PPG Refinish products.

DPLF Epoxy Primer comes in 6 colors; DP40LF (Gray-Green), DP48LF (White), DP50LF (Gray), DP60LF (Blue), DP74LF (Red Oxide), and DP90LF (Black).



**Features**

- Direct to Metal
- Primer / Sealer
- 6 Colors

**Advantages**

- Anti-Corrosion
- Multi-Purpose
- Mix and Match

**Benefits**

- Excellent Adhesion
- Fewer Products to Stock
- Faster Hiding of Topcoat

**Compatible Surfaces**

**DPLF may be applied over:**

- Properly cleaned and sanded steel +
- Properly cleaned and sand blasted steel +
- Properly cleaned and sanded galvanized steel +
- Properly cleaned and sanded aluminum +
- Properly cleaned and sanded fiberglass
- Properly cleaned (unsanded) E-Coat with DP401LF catalyst only
- Various cleaned and sanded Rigid Plastics: ABS, Nylon, Polycarbonate, Noryl, PBT SMC, with DP401LF catalyst only
- Properly cleaned and sanded OE finishes, for OE lacquer see ++ **Caution** statement
- DELTRON® (DBU) Basecoat \*
- DF Body Fillers\*
- DPX801 Universal Plastics Adhesion Promoter
- DX54 ROADGUARD® Chip Resistant Coating
- DX Metal Treatments
- DZ KONDAR® Acrylic Primer Surfacers \*
- K36 PRIMA™ Acrylic Urethane Primer Surfacer\*
- K38 High Build Primer Surfacer \*
- K93 Tintable Primer Surfacer Sealer\*
- NCS2000 Series Sealers
- NCP250 NCT® Primer Surfacer\*
- NCP270/NCP271 Corrosion Resistant Primer\*
- CONCEPT® (DCC) Acrylic Urethane\*
- DELSTAR® (DAR) Acrylic Enamel\*
- Delstar/DELTHANE® (DAR/DXR80) Acrylic Enamel\*
- Deltron 2000 (DBC) Basecoat\* ++
- DURACRYL® (DDL) Acrylic Lacquer\* ++
- SX1044/SXA1044 High Build Flexible Surfacer
- All PPG Clearcoats\*
- SX1047 High Build WB Flexible Surfacer
- SX1050 /SXA1050 Plastic Adhesion Promoter

**NOTE: DPLF must NOT be applied over DPX170 or DPX171.**

+ **Film build of 1.2 – 1.5 mils of DPLF is required** or the surface must be treated with Metal Cleaner/Conditioner.

\* **Must** be cured and sanded

++ **Caution:** When DPLF is sprayed over lacquer substrates or basecoat that is not crosslinked, and then allowed to set overnight before applying another coat of primer or a topcoat, lifting can occur. This can be avoided by applying the DPLF Epoxy Primer, color and clear coat in the same day or by adding 5% of DX57 RTS DBC.



# DPLF

## Directions for Use

### Surface Preparation:



- Wash the area to be painted with soap and water, then clean with DX330 ACRYLI-CLEAN® Wax and Grease Remover, DX393 0.6 Low VOC Cleaner or DX394 1.4 Low VOC Cleaner.
- Sand the bare metal areas completely with 80180 grit abrasive. Sand old finishes with 320 – 400 grit dry by hand or machine or 600 grit wet.
- Re-clean with DX320, DX330, DX393 or DX394. Final wipe with a clean damp cloth to remove any DX393 or DX394 cleaner residue.
- Chemical treatment or the use of a conversion coating will enhance the adhesion and performance properties of the finished system.
- Prime aluminum substrate within 8 hours.  
Prime carbon steel immediately after cleaning.

### Mix Ratio:



<b>DPLF Epoxy Primer</b>	:	<b>DPLF Catalyst</b>	:	<b>Acetone*</b> (Optional)
2	:	1	:	1/2

Pot life of DPLF/DP401LF is 72 hours @ 70°F (21°C)  
 Pot life of DPLF/DP402LF is 8 hours @ 70°F (21°C).

**Note:** Thoroughly mix primer and catalyst (5 minute mechanical agitation recommended).

- Allow 30 minutes induction period to obtain maximum performance properties prior to use of DPLF/DP401LF.
- No induction period is necessary when using DPLF/DP402LF.
- **Do not blend DP401LF and DP402LF together.**

**Note:** In **non-automotive applications** where higher VOC primers are allowed, one half part of DT reducer may be added. This 2:1:1/2 blend ratio will result in a 4.90 VOC sealer.

\* The use of acetone is optional, however when used, the minimum recommended film build **must** be maintained.

### Spraygun Set-up:



	<b>DP401LF</b>	<b>DP402LF</b>
Apply:	1 – 2 wet coats	1 – 2 wet coats
Fluid Tip:	1.4 – 1.6 mm	1.4 – 1.6 mm
Air Pressure:	8 – 10 PSI at the cap for HVLP 40 – 50 PSI at the gun for conventional gun	8 – 10 PSI at the cap for HVLP 40 – 50 PSI at the gun for conventional gun

### Dry Times:



	<b>DP401LF</b>	<b>DP402LF</b>
Between Coats:	10 – 15 minutes	10 – 15 minutes
To Topcoat:		
1 Coat	60 minutes	30 minutes
2 Coats	90 minutes	60 minutes
To Apply Body Filler:		
1 Coat	1 hour	1 hour
2 Coats	Overnight Dry	Overnight Dry

**Note:** DPLF Epoxy Primer may be recoated any time up to 1 week.

**After 1 week**, it must be cleaned, sanded and recleaned.

- Reapply 1 additional coat of DPLF Epoxy Primer.
- Allow 30 minutes dry time with DP402LF @ 70°F (21°C)
- Allow 60 minutes dry time with DP401LF @ 70°F (21°C) before applying additional primer surfacers and/or topcoats.

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## Directions for Use

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### Painting Flexible Parts:

DPLF Epoxy Primer may be used as a primer sealer on flexible parts over DPX801 Universal Plastics Adhesion Promoter, SX1044/SXA1044, SX1047, SX1050/SXA1050 if reduced and sprayed as follows:

<b>DPLF Epoxy Primer</b>	<b>:</b>	<b>DPLF401LF</b>	<b>:</b>	<b>Acetone</b>
2	:	1	:	1/2

Apply: 1 wet coat  
Recommended Film build: .5 – .75 mil  
Topcoat: After 30 minutes

**Note:** Do Not Use DP402LF Fast Catalyst on flexible parts

Reductions other than 2:1:1/2 or more than 1 coat will not result in a flexible coating

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### Tinting:

DPLF Epoxy Primer cannot be tinted.  
DPLF Epoxy colors may be blended together.  
**Note:** Do not blend DP and DPLF together.

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### Additives:

None

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### Compatible Topcoats:

#### **DPLF Epoxy Primer may be topcoated with:**

DF Body Fillers  
DX54 *Roadguard* Chip Resistant Coating  
DZ *Kondar* Acrylic Primer Surfacer  
K36 *Prima* Acrylic Urethane Primer Surfacer  
K38 High Build Primer Surfacer  
K93 Tintable Primer Surfacer Sealer  
NCP250 *NCT*® Primer Surfacer  
NCP270/NCP271 Corrosion Resistant Primer+  
NCP272 Tintable Corrosion Resistant Primer+  
NCS2000 Series Primer Sealers  
*Concept* (DCC) Acrylic Urethane  
*Delstar/Delthane* (DAR/DXR80) Acrylic Enamel  
*Deltron* (DBU) Basecoat  
*Deltron* 2000 (DBC) Basecoat  
*Duracryl* (DDL) Acrylic Lacquer

+ Under these primers use DPLF **catalyzed with DP402LF only**.  
Avoid excessive film builds.

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### Equipment Cleaning:

Thoroughly clean after each use with DX590 All Purpose Clean Up Solvent or Reducers.

### Technical Data:

DPLF Epoxy Primer	DP401LF	DP402LF
VOC (Ready to Spray) 2:1	4.52 lb. / US Gal	4.54 lb. / US Gal
Total Solids by Weight (RTS)	55.6%	56.0%
Total Solids by Volume (RTS)	36.2%	36.4%
Sq. Ft. Coverage/US Gal. (1 mil 100% transfer efficiency)	580	583
Recommended Dry film	.75 – 1.5 mils	.75 – 1.5 mils

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DPLF Epoxy Sealer on Flexible Parts (use DP401LF only)		
	DP401LF w/ DT reducer	DP401LF w/ Acetone
VOC (Ready to Spray) 2:1:1/2	4.88 lb. / US Gal	4.52 lb. / US Gal
Total Solids by Weight (RTS)	48.8%	50.1%
Total Solids by Volume (RTS)	29.9%	31.0%
Sq. Ft. Coverage/US Gal. (1 mil 100% transfer efficiency)	480	480
Recommended Dry film	.5 – .75 mils	.5 – .75 mils

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DPLF Epoxy Sealer with Acetone	DP401LF	DP402LF
VOC (Ready to Spray) 2:1:1/2	4.52 lb. / US Gal	4.54 lb. / US Gal
Total Solids by Weight (RTS)	50.1%	50.6%
Total Solids by Volume (RTS)	31.0%	31.2%
Sq. Ft Coverage/US Gal (1 mil 100% transfer efficiency)	480	480
Recommended Dry film	.75 – 1.5 mils	.75 – 1.5 mils

### Important:

The contents of this package may have to 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.

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

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 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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