

V-Prime™ Acrylic Urethane Surfacer

DPS3051 White
 DPS3055 Gray
 DPS3057 Dark Gray

V-Prime™ DPS305x are premium quality primer surfacers available in white, gray and dark gray. The surfacers are suitable for the wide range of day-to-day repair work done in today's refinish body shops.

DPS305x 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

- Fast Dry
- Superior Holdout

Advantages

- Fast to Topcoat
- Less Solvent Penetration

Benefits

- Faster Process Times
- Excellent Gloss Retention

Compatible Surfaces

V-Prime™ DPS305x may be applied over:

- Properly cleaned and sanded fiberglass
- Properly cleaned and sanded E-Coat
- Cured and sanded OEM finishes
- Properly prepared and treated bare steel and aluminum
- Deltron® Plastic Adhesion Promoter or Etch Primer*
- Deltron® 2K Primer Surfacer*
- DP Epoxy Primer LF*

*Prime complete panels or extend DPS305x surfacer application well beyond the first primer (or exposed substrate) and maintain a minimum dry film of 2.0 mils after sanding. Insufficient DPS305x films may result in lifting on color applications.

Required Products

	Hardener
Undercoat Hardener	DCX3030
	Thinner
Cool Temperature (60 – 70°F)	DT860
Medium Temperature (65 – 80°F)	DT870
Warm Temperature (75 – 90°F)	DT885
Hot Temperature (85°F and above)	DT895
Hot Temperature (95°F and above)	DT898

DPS3051 / DPS3055 / DPS3057

Directions for Use

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 substrate within 8 hours.
- Prime carbon steel immediately after cleaning.

Mixing Ratio:



As a spray filler

DPS305x : DCX3030 Hardener
4 : 1



As a primer surfacer

DPS305x : DCX3030 Hardener : DT Reducers
4 : 1 : 1



Pot Life @ 70°F / 21°C 30 minutes as a Spray Filler
1 hour as a Primer Surfacers

Tinting:

Not recommended

Additives:



DX814 Universal Flexibilizer may be added with 10% DX814 to the ready-to-spray *V-Prime™* Acrylic Urethane Surfacers

Ready-To-Spray DPS305x : DX814 Flexibilizer
10 : 1

Application:



Apply:

As a spray filler

Up to a maximum of 4 wet coats

As a primer surfacer

2 to 3 wet coats

Air Pressure:

HVLP at air cap

10 PSI

Conventional at spray gun

40 – 45 PSI

Spray Gun Set-up:



Fluid Tip:

As a spray filler

1.7 – 2.0 mm or equiv.

As a primer surfacer

1.6 – 1.8 mm or equiv.

Spray Viscosity:

20 – 25 seconds

20 – 25 seconds

#2 Zahn @ 70°F / 21°C

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Film build per wet coat

5.0 mils

4.0 mils





Dried film build per coat

2.0 mils

1.5 mils

Directions for Use

Drying times:

		<i>As a spray filler</i>	<i>As a primer surfacer</i>
	Between coats	5 – 10 minutes	5 – 10 minutes
	Before Baking	N/A	10 minutes
	Dust-free 70° F / 21° C	15 minutes	15 minutes
	Dry to handle 70° F / 21° C	60 minutes	60 minutes
	Dry to Sand 70° F / 21° C 140° F / 60° C	6 hour dry, preferably overnight Do not force dry	1 1/2 hours 30 minutes
	IR (Infrared)		
	IR medium wave	Do not force dry	20 minutes
	IR short wave	Do not force dry	10 minutes
	Overcoat with	The application of a compatible sealer is the preferred recommendation prior to topcoating DPS305x with color.	

Compatible Topcoats:

DAS3025 *V-Seal™* Acrylic Urethane Sealer
 DPLF Epoxy Primer
 DX54 *ROADGUARD®* Chip Resistant Coating
 K36 *PRIMA™* Acrylic Urethane Wet-on-Wet Sealer
 K93 Tintable Primer (as a sealer)
 NCS2000 Series Sealers
 NCS1990 Compliant Wet-On-Wet Sealer
CONCEPT® (DCC) Acrylic Urethane
CONCEPT® LV (CLV) Acrylic Urethane Color
DELSTAR® / *DELTHANE®* (DAR/DXR80) Polyurethane
DELTRON® 2000 (DBC) Basecoat*
DELTRON® (DBU) Universal Basecoat
 SX1056 Flexible 2K Sealer (Specialty Performance Products)

*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:

DPS305x *V-Prime™* Acrylic Urethane Surfacer

	<i>As a spray filler</i>	<i>As a primer surfacer</i>
VOC (PKG) per US Gal	4.20 lbs	4.20 lbs
VOC (RTS) per US Gal (4:1)	4.21 lbs	4.68 lbs
Total Solids by Weight (RTS)	63.78%	56.89%
Total Solids by Volume (RTS)	42.07%	35.06%
Sq. Ft Coverage / US Gal (RTS)	Approx. 675 sq. ft.	Approx. 562 sq. ft.
Recommended wet film build per coat	5.0 mils	4.0 mils
Recommended dry film build per coat	2.0. mils	1.5. mils

Use this chart as a guide to mix the G1– G7 ratios to achieve better hiding when mixing the V- Prime™ Acrylic Urethane Surfacer.

Mix Ratio By Volume			Mix Ratio By Cumulative Weight Parts			
	Mix Ratio		¼ Pint	½ Pint	Pint	Quart
G1	DPS3051	4	136	271	546	1101
	DCX3030	1	157	314	633	1276
	DT870	1	176	351	708	199
G2	DPS3051	N/A	129	258	520	1047
	DPS3055		134	271	546	1099
	DCX3030		156	314	633	1275
	DT870		175	351	708	1427
G3	DPS3051	3	102	203	409	825
	DPS3055	1	134	269	542	1095
	DCX3030	1	156	312	629	1270
	DT870	1	175	350	705	1423
G4	DPS3051	N/A	45	90	182	367
	DPS3055		133	268	539	1086
	DCX3030		156	311	625	1261
	DT870		174	702	702	1415
G5	DPS3055	4	133	265	536	1078
	DCX3030	1	155	308	621	1253
	DT870	1	173	346	697	1406
G6	DPS3055	N/A	45	89	178	359
	DPS3057		129	257	516	1041
	DCX3030		150	299	602	1216
	DT870		168	337	679	1368
G7	DPS3057	4	125	251	506	1020
	DCX3030	1	147	295	593	1195
	DT870	1	166	332	669	1348

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**V-PRIME™ Acrylic
Urethane Surfacers**

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.

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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