DPLF Epoxy Primer

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
- DX1791 Wash Primer
- _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 *
- NCP270/271 Corrosion Resistant Primer *
- NCP272 Tintable Corrosion Resistant Primer *
- _CONCEPT_® (DCC) Acrylic Urethane *
- _CONCEPT_® (CLV) Acrylic Urethane *
- _DELSTAR_® (DAR) Acrylic Enamel *
- _DELSTAR_®/ _DELTHANE_® (DAR/ DMR 80) 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 or coated with DX 1791/1792.
* 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.

* Product Information Effective 1/02
## Directions for Use

### 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 80–180 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.

### Mixing:

<table>
<thead>
<tr>
<th>DPLF Epoxy Primer</th>
<th>DPLF Catalyst</th>
<th>DTV Reducer * (Optional)</th>
</tr>
</thead>
<tbody>
<tr>
<td>2</td>
<td>1</td>
<td>1/2</td>
</tr>
</tbody>
</table>

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 5.0 VOC sealer.

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

### Spraygun Set-up:

<table>
<thead>
<tr>
<th>Fluid Tip</th>
<th>Air Pressure for HVLP</th>
<th>Air Pressure for conventional gun</th>
</tr>
</thead>
<tbody>
<tr>
<td>1.4–1.6 mm</td>
<td>8–10 PSI at the cap</td>
<td>40–50 PSI at the gun</td>
</tr>
</tbody>
</table>

### Dry Times:

<table>
<thead>
<tr>
<th>Between Coats</th>
<th>To Topcoat 1 Coat</th>
<th>To Topcoat 2 Coats</th>
<th>To Apply Body Filler 1 Coat</th>
<th>To Apply Body Filler 2 Coats</th>
</tr>
</thead>
<tbody>
<tr>
<td>DP401LF</td>
<td>10–15 minutes</td>
<td>60 minutes</td>
<td>1 hour</td>
<td>Overnight Dry</td>
</tr>
<tr>
<td>DP402LF</td>
<td>10–15 minutes</td>
<td>30 minutes</td>
<td>1 hour</td>
<td>Overnight Dry</td>
</tr>
</tbody>
</table>

**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.
### Technical Data:

<table>
<thead>
<tr>
<th>DPLF Epoxy Primer</th>
<th>DP401LF</th>
<th>DP402LF</th>
</tr>
</thead>
<tbody>
<tr>
<td>VOC (Ready to Spray) 2:1</td>
<td>4.6 lb./ US Gal</td>
<td>4.6 lb./ US Gal</td>
</tr>
<tr>
<td>Total Solids by Weight (RTS)</td>
<td>55.6%</td>
<td>56.0%</td>
</tr>
<tr>
<td>Total Solids by Volume (RTS)</td>
<td>36.2%</td>
<td>36.4%</td>
</tr>
<tr>
<td>Sq. Ft. Coverage/US Gal. (1 mil 100% transfer efficiency)</td>
<td>580</td>
<td>583</td>
</tr>
<tr>
<td>Recommended Dry film</td>
<td>.75–1.5 mils</td>
<td>.75–1.5 mils</td>
</tr>
</tbody>
</table>

**DPLF Epoxy Sealer on Flexible Parts (use DP401LF only)**

<table>
<thead>
<tr>
<th>DP401LF w/ DT reducer</th>
<th>DP401LF w/ DTV reducer</th>
</tr>
</thead>
<tbody>
<tr>
<td>VOC (Ready to Spray) 2:1:1/2</td>
<td>5.0 lb./ US Gal</td>
</tr>
<tr>
<td>Total Solids by Weight (RTS)</td>
<td>48.8%</td>
</tr>
<tr>
<td>Total Solids by Volume (RTS)</td>
<td>29.9%</td>
</tr>
<tr>
<td>Sq. Ft. Coverage/US Gal. (1 mil 100% transfer efficiency)</td>
<td>480</td>
</tr>
<tr>
<td>Recommended Dry film</td>
<td>.5–.75 mils</td>
</tr>
</tbody>
</table>

**DPLF Epoxy Sealer with DTV Reducer**

<table>
<thead>
<tr>
<th>DP401LF</th>
<th>DP402LF</th>
</tr>
</thead>
<tbody>
<tr>
<td>VOC (Ready to Spray) 2:1:1/2</td>
<td>4.6 lb./ US Gal</td>
</tr>
<tr>
<td>Total Solids by Weight (RTS)</td>
<td>50.1%</td>
</tr>
<tr>
<td>Total Solids by Volume (RTS)</td>
<td>31.0%</td>
</tr>
<tr>
<td>Sq. Ft Coverage/US Gal (1 mil 100% transfer efficiency)</td>
<td>480</td>
</tr>
<tr>
<td>Recommended Dry film</td>
<td>.75–1.5 mils</td>
</tr>
</tbody>
</table>

---

**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 (304) 843-1300; 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.