

DP 40

CHROMATE-FREE 2K EPOXY SURFACER

DP40 SURFACER D834

DP402 HARDENER D835

PRODUCT DESCRIPTION

DP40 is a versatile 2K Epoxy Surfacer. It is light grey in colour, chromate-free and has good corrosion resistance over bare metal.

DP40 has good adhesion to a wide variety of suitably prepared substrates. These include bare and galvanised steel, aluminium, GRP and fibreglass, painted surfaces and fillers, and a wide range of plastic substrates.

DP40 is ideally used as a wet-on-wet or non-sand surfacer, but may be stoved or air-dried if required. It may also be used as a one-coat sealer over flatted 2K primers and surfacers, when it fills sanding marks and promotes optimum gloss holdout in the topcoat.

PREPARATION OF SUBSTRATE

In all cases, select the appropriate PPG cleaner(s) from the guide below, and ensure that the substrate is thoroughly cleaned both before and after preparation work.

Bare steel simply requires thorough degreasing before application of DP40.

Compatible plastic surfaces (see plastic system chart ref 13 for details) should be abraded with a Scotchbrite pad.

Existing paintwork, if sound and aged, should be abraded with P360 - 400 grade paper (wet) or P280 - 310 grade (dry). For use over thermoplastic acrylics (TPA), refer to 'Performance and Limitations' below.

Zinc-coated or galvanised steel should be abraded with a Scotchbrite pad.

Preparation of aluminium depends upon its hardness. Soft grade should be thoroughly abraded with a red Scotchbrite pad, while hard grade should be abraded with P240 grade paper. In both cases, overcoat with DP40 without delay in order to ensure optimum adhesion. For aluminium, use DX310 to degrease.

GRP and fibreglass should be abraded with P320 grade paper.

GUIDE TO SELECTION OF SUBSTRATE CLEANER

<i>Code</i>	<i>Product</i>	<i>Purpose</i>
D845	DX310 High-Strength Degreaser	For use as a pre-cleaner in the first stage of the repair process. Use before starting any repair work.
D837	DX330 Spirit Wipe	Suitable for removing dirt, grease or other contaminants before or during the painting process.
D842	DX380 Low-VOC Cleaner	Particularly designed to remove contaminants after sanding, and in areas where VOC emissions should be minimised.
D846	Degreasing Agent for Plastics	A fast, effective degreaser specially formulated to avoid adverse effects on plastic substrates.

APPLICATION GUIDE	NON-SAND SURFACER	WET-ON-WET SURFACER	SEALER
<i>Mixing Ratio</i>	D834 1 vol D835 1 vol	D834 1 vol D835 1 vol	D834 1 vol D835 1 vol D866* 0.5 vol
<i>* For exceptional conditions of temperature and humidity (>35°C / >70 %), the use of Very Slow Thinner D869 is recommended.</i>			
<i>Potlife</i>	16 hours / 20°C	16 hours / 20°C	16 hours / 20°C
<i>Spray viscosity at 20°C</i>	16 secs DIN4	16 secs DIN4	12 secs DIN4
<i>Spraygun setup gravity:</i>	1.4 mm	1.4 mm	1.4 mm
<i>suction:</i>	1.8 mm	1.8 mm	1.8 mm
<i>Spray pressure</i>	4 bar	4 bar	4 bar
<i>Number of coats</i>	2 - 4	2	1 full
<i>Flash off at 20°C: between coats before topcoat</i>	10 minutes 45 minutes	5 - 10 minutes 15 minutes	n/a 10 minutes

APPLICATION GUIDE	NON-SAND SURFACER	WET-ON-WET SURFACER	SEALER
<p><i>Drying times:</i> <i>dust-free at 20°C</i> <i>through dry at 20°C</i> <i>through dry at 70°C</i></p>	<p>15 minutes 4 hours 30 minutes</p>	<p>15 minutes n/a n/a</p>	<p>n/a n/a n/a</p>
<p><i>Total dry film build:</i> <i>minimum</i> <i>maximum</i></p>	<p>30µm 50µm</p>	<p>25µm 35µm</p>	<p>15µm 20µm</p>
<p><i>theoretical coverage **</i></p>	<p>6 - 6.5 m² / l</p>	<p>6.5 - 7 m² / l</p>	<p>9 - 10 m² / l</p>
<p><i>** Theoretical coverage in ready-to-spray litres, giving a dry film thickness between indicated minimum and maximum values.</i></p>			
<p><i>Flatting</i></p>	<p>In normal use it is not necessary to sand this product</p>		
<p><i>Overcoat with</i></p>	<p>any PPG 2K primer or Deltron topcoat</p>		<p>any Deltron topcoat</p>

PERFORMANCE AND LIMITATIONS

The use of HVLP spray equipment can give an increase in transfer efficiency of about 10% depending on the make and model of equipment used.

DP40 should be used only with the recommended hardener. DP402 Hardener should not be blended with any other hardener.

DP40 should not be used at temperatures lower than 10°C or humidity higher than 80%.

DP40 should be overcoated within one week of application. If left for longer, the paint film must be degreased with DX330 or DX380 and abraded with a medium-fine grade Scotchbrite pad. After a further degrease, apply 1 additional coat of DP40 and allow to dry for 45 minutes before application of primer and / or topcoat.

If used over TPA, DP40 must be overcoated with Deltron topcoat within 8 hours.

After use, clean spray equipment thoroughly with cleaning solvent or thinner.

HEALTH AND SAFETY

- Please refer to Material Safety Data Sheets for full Health and Safety details.
- Goggles must be worn when mixing and using to prevent accidental splashing into the eye. If contact occurs with eyes give prolonged irrigation with water and get medical attention immediately.
- Good ventilation and extraction must be provided in the working environment.
- Do not smoke whilst using this material.
- Do not breathe vapours or overspray. In cases of insufficient ventilation, wear appropriate respiratory equipment.

FLASH POINTS

Deltron Primer Thinner D866	21°C - 55°C
DP40 Surfacer D834 DP402 Hardener D835 DX310 High-Strength Degreaser D845 DX330 Spirit Wipe D837 Degreasing Agent for Plastics D846	} Below 21°C
DX380 Low-VOC Cleaner D842	No flash point - water-based

This product is for professional use only. The information given in this sheet is for guidance only. Any person using the product without first making further enquiries as to the suitability of the product for the intended purpose does so at his own risk and we can accept no liability for the performance of the product or for any loss or damage (other than death or personal injury resulting from our negligence) arising out of such use. The information contained in this sheet is liable to modification from time to time in the light of experience and our policy of continuous product development.

Drying times quoted are average times at 20°C. Film thickness, humidity and shop temperature can all affect drying times.



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