

**DELTA® 2.1 VOC
Polyurethane Primer**

DPU217

DPU217 is a gray, 2.1 VOC, chrome-free polyurethane primer which exhibits superior adhesion and corrosion resistance when applied over properly prepared steel, galvanized steel, fiberglass and aluminum substrates. DPU217 may be topcoated in as little as one hour, making it an excellent choice for production-oriented fleet refinishers. DPU217 combines outstanding performance, productivity and VOC compliance in one easy to use product. DPU217 is designed for use with Delta® High Solids Polyurethane topcoats.

Features	Advantages	Benefits
<ul style="list-style-type: none"> Adhesion to a wide variety of substrates Fast dry to topcoat Easy to apply Excellent corrosion resistance 	<ul style="list-style-type: none"> Versatility Faster turn around Better flow and leveling Protects substrate 	<ul style="list-style-type: none"> Less product inventory Productivity improvement Customer satisfaction Longer repaint cycle/unit life

Compatible Surfaces

DPU217 may be applied over:

- Properly cleaned and sanded: *steel, *aluminum, fiberglass, galvaneal and galvanized steel
- DPHS52 Low VOC Primer
- DX1793 Chrome Free Self Etching Primer
- DPU166 High Solids Chromate Primer 2.8 VOC Max
- OEM Enamels
- Cured Air Dry Finishes

If sanding bare metal areas prior to the application of DPU217, use 180-240 grit wet or dry. Sand old finishes with 280-400 grit wet or dry.

* Prime aluminum and carbon steel substrates immediately after cleaning.

	Hardener
High Solids Primer Hardener	DPU218
	Required Additive Options
Accelerator	DX39
Extender	DX53



APPLICATION GUIDE

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Mixing Ratio 2.1 VOC:



DPU217 : DPU218 + DX39
 5 parts : 1 part + 6 oz. per RTS gal.

Mixing Ratio 2.8 VOC:



DPU217 : DPU218 : DX39/DX53 : DRS Reducers*
 5 parts : 1 part : 6 oz. per RTS gal. : 1 part

* When adding DRS reducers in the 2.8 blend, for best results, the DRS Solvents must be added last, after the addition of the DX39/DX53.

Pot life:



1½ - 2 hours @ 70°F and 50% RH
 (High heat and humidity will shorten pot life)

Additives:



Accelerators: No Recommendation
 Extenders: No Recommendation
 Fisheye: No Recommendation
 Flex: No Recommendation
 Flattening: No Recommendation

Spraygun set-up:



Fluid Tip

1.2 - 1.4 mm for Pressure Feed/HVLP
 1.2 - 1.6 mm for Conventional Feed/HVLP

Air Pressure

HVLP at air cap 10 PSI
 Conventional at spray gun 55-65 PSI

Consult the Fleet Training Manual Spray Equipment section for gun set-up requirements.

Minimum number of coats:

1 - 2 coats

Total film build per coat:



	Wet	Dry
Minimum	1.8 mils	1.0 mils
Maximum	2.3 mils	1.3 mils

Flash Time at 70°F:



10 - 15 minutes between coats

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Drying times:



Air Dry @ 70°F	Force Dry**
Dust 45 minutes	Flash 10 minutes
Tack 2 hours	20 minutes @ 130°F
Tape 4 hours	10 minutes @ 160°F

** Force drying times are for quoted surface temperature. Additional time should be allowed in the force drying schedule to allow surface to reach recommended temperature.

Dry Time to Topcoat:

60 minutes @ 70°F*

* After 4 days, DPU217 must be sanded before additional primer or topcoat can be applied.

Test Properties:

Color	Gray
Volume Solids (RTS) (5:1+6 oz.)	64.5 - 66.5%
Volume Solids (RTS) (5:1:1+6 oz.) 2.8 VOC	51.8%
Square Foot Coverage (RTS U.S. Gallon 100% Transfer Efficiency)	922 - 954 sq. ft.

RTS Combinations:	DPU217 : DPU218 + DX39	DPU217 : DPU218 : DRS + DX39/DX53
Volume Ratio	5 : 1 + 6 oz	5 : 1 : 1 + 6 oz
Applicable Use Category	Primer	Primer
VOC Actual (g/L)	227	309
VOC Actual (lbs/gal)	1.9	2.59
VOC Regulatory (less water less exempt) (g/L)	248	333
VOC Regulatory (less water less exempt) (lbs/gal)	2.07	2.78
Density (g/L)	1460	1373
Density (lbs/gal)	12.18	11.46
Volatiles wt. %	20.0	26.6
Water wt. %	0.0	0.0
Exempt wt. %	4.4	4.1
Water vol. %	0.0	0.0
Exempt vol. %	8.2	7.1

Compatible Topcoats:

- DPHS52 Low VOC Primer
- DELTA® (DSS) Medium Solids Polyurethane
- DELTA® (DFHS) Fast Dry High Solids Polyurethane
- DELTA® (DUHS) High Solids Polyurethane
- DELTA® (DUHS) Basecoat
- DELTA® Basecoats
- DELTA® (DVHS) Fast Dry 2.8 VOC Polyurethane
- DELTA® (DGHS) Chemical Resistant Polyurethane 3.5 VOC
- DELTA® (DGHS) Chemical Resistant Polyurethane 4.4 VOC
- DELTA® (DHS) 2.8 VOC Polyurethane

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

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