3.5 Epoxy Primer

Delta® DEP351

DEP351 is a 3.5 Epoxy Primer designed for use in fleet applications requiring excellent adhesion and corrosion protection. The chrome and lead-free primer also has exceptional topcoat characteristics and re-coat times.

Features

- Direct to metal
- User Friendly
- High Solids

Advantages

- Corrosion Protection
- VOC Compliant

Benefits

- Excellent Adhesion
- Increased Productivity
- Reduced Inventory

Compatible Surfaces

Delta® DEP351 may be applied over:

- Cured and sanded OEM finishes
- Properly cleaned and sanded fiberglass
- Properly cleaned and sanded: steel, aluminum and stainless
- Properly cleaned and sanded Galvanized and Galvaneal steel
- DPS306 2K Primer Sufacer
- DPHS52 Low VOC Primer
- DPU166 High Solids Chromate Primer 2.8 VOC Max.
- DPU174 High Solids Polyurethane Primer (Chrome-Free)
- DPU217 2.1 VOC Polyurethane

Catalyst

Epoxy Primer Catalyst	DEP352

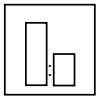
DEP351

Application Guide

Preparation:

- Wash the area to be painted with soap and water, and then clean with DX436 or DX437 wax and grease remover. DX438 Low VOC Cleaner should be used in VOC restricted areas.
- All metal substrates need to be sanded with 80-180 grit wet or dry. Re-clean with DX436, DX437 or DX438.
- Prime aluminum, stainless and carbon steel immediately after cleaning.
- Sand old finishes with 240-280 grit wet or dry.

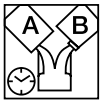
Mixing Ratio:



DEP351	DEP352
2 parts	1 part

The addition of 10 - 20% Acetone or DES1570 Exempt Solvent Blend should be used for sealer applications.

Pot life:



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

Additives:

Not Recommended

Spraygun set-up:

Fluid Tip:	1.2 - 1.4 mm Pressure Feed/HVLP 1.4 - 1.6 mm 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.

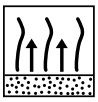
Number of coats:

1 - 2 coats

Total film build per coat:

	Wet	Dry
Minimum	2 mils	1 mils
Maximum	4 mils	2 mils

Flash Time at 70°F (21°C):



Between coats	5 minutes

Drying times:

	Air Dry @ 70°F	Force Dry**
Dust:	20 minutes	Flash 10 minutes
Tack:	3 hours	20 minutes @ 130°F
Tape:	4 hours	10 minutes @ 160°F
Dry to Topcoat:	60 minutes	

Note: After 2 weeks, DEP351 must be sanded before additional primer or topcoat can be applied.

**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.

Test Properties:

Color	Gray
VOC DEP351 Packaged	3.3 lbs. per U.S. gal.
VOC DEP352 Packaged	4.0 lbs. per U.S. gal.
VOC RTS Applied	3.5 lbs. per U.S. gal.
Volume Solids (RTS)	49.5%
Square Foot Coverage	990 sq. ft.

(RTS US Gallon 100% Transfer Efficiency)

Compatible Topcoats:

DPHS52 Low VOC Primer
DPU166 High Solids Chromate Primer (2.8 VOC)
DPU174 High Solids Polyurethane Primer
DPU217 DELTA® 2.1 VOC Polyurethane Primer
DPS306 DELTA® 2K Primer Surfacer
DELTA® (DFHS) Fast Dry High Solids Polyurethane
DELTA® (DUHS) High Solids Polyurethane
DELTA® (DVHS) Fast Dry 2.8 VOC Polyurethane
DELTA® (DGHS) Chemical Resistant 3.5 VOC
DELTA® (DGHS) Chemical Resistant 4.4 VOC
DELTA® (DSS) Medium Solids Polyurethane
DELTA® (DHS) 2.8 VOC Polyurethane

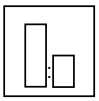
Health and Safety

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

Delta® DEP351 3.5 Epoxy Primer

Instant Reference

How to Mix:



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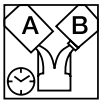


Pot life @ 70°F and 50% RH: 4 hours
(High heat and humidity will shorten pot life)

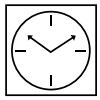
Gun set-up:

HVLP:	10 PSI at the air cap
Conventional:	55 - 65 PSI at the gun
Fluid Tip:	1.2 - 1.4 mm for Pressure Feed/HVLP 1.4 - 1.6 mm for Conventional Feed/HVLP

Application:

Apply:	1 - 2 coats	
Between Coats:	5 minutes	
Film build per coat:	*Wet*	*Dry*
Minimum	2 mils	1 mils
Maximum	4 mils	2 mils

Drying times:



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For additional information, refer back to the complete FL305 bulletin.

PPG Automotive Refinish

World Leaders in Automotive Finishes

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