

NCT® Primer Surfacer

NCP250 Reddish Gray
NCP260 Gray

NCT® Primer Surfacer are isocyanate-free, two component surfacers designed for today's advanced technology finishes. High build, fast drying and easy sanding qualities make *NCT*® Primer Surfacer a useful tool in refinish applications.

The *NCT*® Primer Surfacer must be mixed with NCX255 *NCT*® Primer Surfacers Activator before application.



Features

- High Solids
- Isocyanate-free
- User Friendly

Advantages

- Fills Quickly
- VOC Compliant
- Easy Mix and Sand

Benefits

- Increased Productivity
- Meets National Law
- Labor Savings

Compatible Surfaces

NCP250 and NCP260 Primer Surfacer 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
- Properly cleaned, sanded and treated galvanized steel
- *DELTRON*® plastic adhesion promoter or etch primer*
- *DELTRON*® 2K primer surfacer*
- DP Epoxy Primer LF*

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

Required Products

Hardener

NCT Primer Surfacers Activator

NCX255

NCP250/260

Directions for Use

Surface Preparation:



NCT® Primer Surfacer

- 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.
- Two step metal treatments or the use of a wash primer coating will improve the adhesion and performance properties of the finished system.
- A two step metal treatment or wash primer is required over sanded clean galvanized steel substrate.
- Prime aluminum within 8 hours. Prime carbon steel immediately after cleaning.

Mix Ratio:



$$\frac{\text{NCP250 or NCP260}}{4} : \frac{\text{NCX255}}{1}$$



Pot Life is 1 hour at 70°F (21°C).

Pot life is shortened as temperatures increase.

Additives:



DX814 Universal Flexibilizer may be added to NCT Surfacer using the ratio below:



$$\frac{\text{NCP250 or NCP260}}{4} : \frac{\text{NCX255}}{1} : \frac{\text{DT Reducer}}{2} : \frac{\text{DX814}}{1}$$

OR



$$\frac{\text{RTS NCP250 or NCP260}}{5} : \frac{\text{DT Reducer}}{2} : \frac{\text{DX814}}{1}$$

Apply a maximum of 3 coats of flexibilized NCT Surfacer. Keep dry films below 5.0 mils before sanding.



Pot Life of **Flexibilized** NCT Surfacer is 2 hours at 70°F (21°C)

Pot life is shortened as temperatures increase.

Spraygun Set-up:



Apply: 2 – 4 coats

Fluid Tip: 1.4 – 1.8 mm or equivalent

Air Pressure: 10 PSI at the cap for HVLP guns
35 – 45 PSI at the gun for conventional guns

Directions for Use

Drying Times:



Between Coats: 10 minutes

Dry to Sand*:

2 – 3 coats	1 – 2 hours at 70°F (21°C)
4 coats	4 hours at 70°F (21°C)



Purge Time: 10 minutes at 70°F (21°C)

Force Dry: 30 minutes at 140°F (60°C)



IR (Infrared): 20 minutes for Medium wave
10 minutes for Short wave

**Film should not exceed 8.0 mils before sanding*

Compatible Topcoats:

CONCEPT[®] (DCC) Acrylic Urethane
CONCEPT[®] LV (CLV) Acrylic Urethane Color
 DAS302x V-Seal[™] Acrylic Urethane Sealer
 DPLF Epoxy Primer
DELSTAR[®] / *DELTHANE*[®] (DAR/DXR80) Polyurethane
DELTRON[®] 2000 (DBC) Basecoat*
DELTRON[®] (DBU) Universal Basecoat
 DPS305x V-Prime[™] Acrylic Urethane Surfacer*
 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
 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 DX590 All Purpose Clean-up Solvent, or DTL *DURACRYL*[®] Lacquer Thinners.

NCP250/260

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***Technical Data:**

Package VOC Actual:	4.50 lbs/gal (539 g/L)
Package VOC Regulatory:	4.60 lbs/gal (551 g/L)
Total Solids by Weight (RTS)	53.2%
Total Solids by Volume (RTS)	33.6%
Sq. Ft. Coverage / U.S. Gallon (RTS)	540
Recommended wet film build per coat	3.0 – 4.0
Recommended dry film build per coat	1.4 – 1.8

** These are typical values. Depending on the tint chosen, the calculated values can vary.*

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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