



**AUTO REFINISH**

GLOBAL  
REFINISH  
SYSTEM



# Product Information

## DP40 D834

*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 sanded 2K primers and surfacers, when it fills sanding marks and promotes optimum gloss holdout in the topcoat.

DP40 is also an excellent sealer for use over TPA finishes.

### PREPARATION OF SUBSTRATE

#### **Substrate**

#### **Preparation**



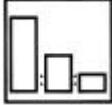
Bare steel  
Galvanised steel  
Zintect  
Aluminium and alloys  
Electropaint  
Aged painted surfaces  
GRP, Fiber Glass  
Polyester filler

P80 - 120  
P400 (dry)  
Fine sanding pad  
P280 - 320 (dry)  
P360 (dry)/P800 (wet)  
P280/P360 (dry)/P400 - P500 (wet)  
P320 (dry)  
P80 - P120 (dry)

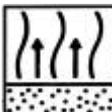


Before and after any sanding operation, the substrate must be thoroughly degreased.

## PRODUCT SET-UP

	<i>Non-sand Surfacer</i>	<i>Wet-on-wet Surfacer</i>	<i>Sealer</i>
	<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
* For exceptional conditions of temperature and humidity (>35°C / >70 %), the use of Very Slow Thinner D869 is recommended.			
	<i>Potlife at 20°C:</i> 16 hours	16 hours	16 hours
	<i>Spray viscosity at 20°C:</i> 15 seconds DIN4	15 seconds DIN4	12 seconds DIN4

## APPLICATION, FLASH-OFF AND DRYING

	<i>Non-sand Surfacer</i>	<i>Wet-on-wet Surfacer</i>	<i>Sealer</i>
	<i>Spraygun set-up:</i> 1.4 - 1.8 mm	1.4 - 1.8 mm	1.4 - 1.6 mm
	<i>Number of coats:</i> 2 - 4	2	1 full
	<i>Flash-off at 20°C:</i> - <i>Between coats</i> 10 minutes - <i>Before topcoat</i> 45 minutes	5 - 10 minutes 15 minutes	n/a 10 minutes
	<i>Drying times:**</i> - <i>Dust free at 20°C</i> 15 minutes	15 minutes	n/a
	- <i>Through dry at 20°C</i> 4 hours	n/a	n/a
	- <i>Through dry at 60°C</i> 30 minutes	n/a	n/a
	- <i>Through dry IR medium</i> 10 minutes	n/a	n/a
** Stoving times are for quoted metal temperature. Additional time should be allowed in the stoving schedule to allow metal to reach recommended temperature			
	<i>Total dry film build:</i> 30 - 50 µm	25 - 35 µm	15 - 20 µm
	<i>Theoretical coverage:</i> assuming 100% transfer efficiency and dry film thickness as indicated:		
	6 - 6.5 m <sup>2</sup> /l	6.5 - 7 m <sup>2</sup> /l	9 - 10 m <sup>2</sup> /l

## REPAIR AND RECOATING

*Non-sand Surfacers*

*Wet-on-wet  
Surfacers*

*Sealer*



*Sanding:*

Not necessary in normal use



*Overcoat / Re-coat  
time:*

- *Over TPA*
- *Other surfaces*

Within 8 hours

Degrease



Abrade lightly (sanding pad)



Degrease



Apply 1 coat of DP40



Overcoat within 45 minutes

*Overcoat with:*

PPG 2K primers

## PERFORMANCE AND LIMITATIONS



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

## EQUIPMENT CLEANING

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

## HEALTH AND SAFETY



For comprehensive Health, Safety and Environmental advice, please refer to relevant Material Safety Data Sheets and product can labels.  
Use the recommended safety equipment.

**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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