

**DTM High Build Primer**

**VP2050**

VP2050 is a two component gray direct to metal high build primer. VP2050 is fast drying and easy to sand and may be applied to over properly prepared steel, aluminum, fiberglass and existing coatings in good condition.

This bulletin for VP2050 is for use in low VOC compliant refinish markets. For use in National Rule refinish markets, see bulletin VB-18NR.



**Compatible Surfaces**

VP2050 DTM High Build Primer may be applied over the following.

- Fully cured, cleaned and sanded OEM and refinish paints, bare steel, aluminum and fiberglass substrates

**Compatible Topcoats**

- DELTRON® Low VOC surfacers
- ENVIROBASE® surfacers or sealers
- AQUABASE® Plus surfacers or sealers
- VIBRANCE® topcoat system
- *Vibrance Polyester Primer*
- *Envirobase Refinish Systems* - Follow EB-143 *Envirobase High Performance Waterborne Basecoat* recommendations for proper preparation
- *Aquabase Plus* - Follow *Aquabase Plus PDS N5.3.2* recommendations for proper preparation.

**Preparation**

- Wash the area to be painted with soap and water, then clean with SWX350 *H<sub>2</sub>O-So-Clean Wax and Grease Remover*, DX393 0.6 Low VOC Cleaner or DX394 1.4 Low VOC Cleaner, SXA330 Aerosol Wax and Grease Remover or SX1009 2.9 VOC Bug and Tar Remover.
- 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.
- Re-clean with SWX350 *H<sub>2</sub>O-So-Clean Wax and Grease Remover*, DX393 0.6 Low VOC Cleaner or DX394 1.4 Low VOC Cleaner, SXA330 Aerosol Wax and Grease Remover or SX1009 2.9 VOC Bug and Tar Remover.
- Prime aluminum substrate within 8 hours of sanding and cleaning.
- Prime carbon steel immediately after sanding and cleaning.

# DTM High Build Primer

## Directions For Use

### Mixing Ratio:



<b>VP2050</b>	:	<b>VH7050</b>	:	<b>D87xx/DT18xx/VR9200</b>
<b>2</b>	:	<b>1</b>	:	<b>1/2</b>

Pot life: Pot life is 2 hours at 70°F (21°C)

### Application:

Apply: Apply 1 - 4 medium wet coats allowing it to flash for 10 to 15 minutes between coats.

Film Build: 2 - 2.5 mils dry per coat

Note: Do not exceed 8 mils dry after sanding.

### Spraygun Set up:



Air Pressure: 8 - 10 PSI at the cap for HVLP guns  
29 - 40 PSI at the gun for compliant guns

Fluid Tip: 1.4 - 1.8 mm

### Drying Times:



Between Coats: 10 - 15 minutes  
70°F (21°C) Be sure the first coat has completely flashed before applying the second coats.



Dust Free: 1 hour  
70°F (21°C)



Tack Free: 4 - 6 hours  
70°F (21°C)



Tape Time: 8 - 12 hours  
70°F (21°C)



Air Dry: 16 - 24 hours / over night  
70°F (21°C)

Force Dry:\* 140° (60°C) Flash off for 15 minutes then 40 minutes @ 140°F (60°C)



IR (Infrared): N/A  
Medium Wave



Topcoat, Recoat and Repair **Topcoat:** 1 hour to 4 days @ 70°F (21°C)

**Recoat:**  
Air dry: 1 hour to 4 days @ 70°F (21°C)  
Force dry: After cool down

**Repair:** 16 - 24 hours / over night or after force dry @ 140°F (60°C)

Body Filler may be applied over VP2050 after an over night dry and a light sanding. If applying body filler, two coats of VP2050 must first be applied.

If preferred, VP2050 may be directly topcoated or sealed with a compatible PPG sealer.

VP2050 may be recoated without sanding up to 4 days. After 4 days, VP2050 must be lightly sanded and cleaned before top coating.

\* Force dry time is quoted for metal temperature. Additional time must be allowed during force drying to allow metal to reach recommended metal temperature.

**Technical Data:**

<b>RTS Combinations:</b>	VP2050 : VH7050 : D87xx/DT18xx/VR9200
Volume Ratio:	2 : 1 : 1/2
Applicable Use Category	Primer
VOC Actual (g/L)	175
VOC Actual (lbs./gal)	1.46
VOC Regulatory (less water less exempt) (g/L)	234
VOC Regulatory (less water less exempt) (lbs./gal)	1.95
Density (g/L)	1266 - 1305
Density (lbs./gal)	10.56 - 10.89
Volatiles wt. %	38.3
Water wt. %	0.5
Exempt wt. %	22.0 - 24.4
Water vol. %	0.7
Exempt vol. %	24.2
RTS Solids by Volume	53.39
RTS Solids by Weight	64.67 - 65.76
Sq. Ft. Coverage @.100% Transfer Efficiency. @ 1 mil	863

**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.

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**See Material Safety Data Sheet and Labels for additional safety information and handling instructions.**


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