



**DELTRON**<sup>®</sup>



# Product information

DP616-EpoxyTHANE

## DP616

### PRODUCTS

Deltron EpoxyTHANE	DP616
Deltron Hardener	DH720,DH730 – Large areas, high temperature
Deltron Hardener	DH710 - Spot repairs / single panels/ brushed on
Deltron Thinners	DT810, DT820, DT830, DT840
<b>NOTE: DO NOT USE</b> DT850 or DT860 Accelerator Thinners in DP616 EpoxyTHANE	

### Product Description

DP616 EpoxyTHANE is a two component adhesion promoting epoxy urethane primer designed to be used over bare metal surfaces under polyester spray or hand applied body fillers and Deltron primers, to protect against corrosion. It also has excellent adhesion to steel, aluminum and galvanized steel. It should be used whenever optimum corrosion protection is required.

### Preparation of Substrate



EpoxyTHANE Primer can be applied over suitably prepared:

- Steel after degreasing with D837, conditioning with D840 Galvaprep or Deoxidine 624.
- Aluminum after cleaning with D837 and treating with SWX250 using a scotchbrite pad. Final degrease with D837.
- Fibreglass (GRP) after removing mould release agent using BodyKleen, degreasing with D837 and sanding with 240-320 dry.
- Sound existing paint finish after degreasing with D837 and sanding with P240-320 dry.

**Please note:** Substrates other than those stated should be tested before use to ensure that the performance of the product is suitable for the intended use.

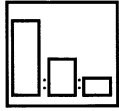
**Cleaning:** Before and after any sanding operation, the substrate must be thoroughly degreased with D845 before sanding and D837 after sanding.

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## Application Guide:

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### Mixing ratio:



By volume:

DP616	6 Parts
Hardener	1 Part
Thinner	2 – Spray applied 1 – Brush applied

### Hardener and Thinner Selection

#### Temperature

Up to 18°C  
18 – 25°C  
25 – 35°C  
Over 35°C

#### Hardener

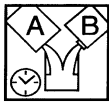
DH710  
DH720  
DH730  
DH730

#### Thinner

DT810  
DT820  
DT830  
DT840

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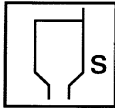
### Pot Life:



DH710	1 hour at 25 °C
DH720	2 hours at 25 °C
DH730	3 hours at 25 °C

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### Spray Viscosity:



DIN 4 at 25 °C 16-18 seconds.

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### Spraygun Setup:



Gravity

#### Conventional

1.3 – 1.9 mm

#### HVLP

1.3 – 1.9 mm

Suction

1.8 – 2.2 mm

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### Spray Pressure:

350 - 450 kPa

2.0 - 2.5 bar

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### Application:



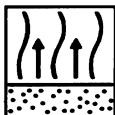
2 full, wet, even coats allowing flash-off between coats.

20-35 microns dry film build.

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### Flash Off Time:

5 minutes between coats @ 25 °C.



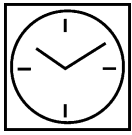
25 minutes @ 25°C before over coating with Polyester filler or Deltron primer

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## Application Guide:

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### Drying Times:



#### ***Air Dry Only:***

25 minutes at 25 °C

Do Not Bake.

Can be left for up to 8 hours before recoating.

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### Technical

**Data:** Total Dry Film Build: 20-35 microns.

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### Sanding:

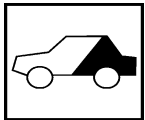


Sanding not required if being overcoated after 25 minutes and less than 8 hours @ 25°C.

If EpoxyTHANE is left to dry longer than 8 hours, it should be sanded with P180-P240 and re-coated with itself.

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### Overcoat with:



#### **Flash off for 25 minutes then overcoat with:**

PPG Polyester Spray Filler A712 WOW after 25 minutes @ 25°C. (sanding not required)

PPG Polyester Body Filler after 25 minutes @ 25°C. (sanding not required)

DP602 or DP618 after 25 minutes @ 25°C. (sanding not required)

Topcoat must not be applied directly over DP616 EpoxyTHANE.

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## Performance Guidelines

1. This product can be used as an adhesion promoter prior to using Polyester Spray Filler, Body Filler or PPG acrylic urethane 2K Primer such as DP602 or DP618.  
**Note:** Check polyester manufacturer's recommendations on whether an adhesion promoting primer is required.
2. Topcoats **must not** be applied directly over DP616 EpoxyTHANE. A PPG 2K primer filler must be applied before top coating.
3. If EpoxyTHANE is left to dry longer than 8 hours, it should be sanded with P180-P240 and re-coated with itself. EpoxyTHANE can be left for up to 6 weeks uncoated before the commencement of work in a clean dry environment.
4. Choice of thinner will depend on air temperature and size of the job.
5. Use only recommended PPG products. PPG cannot provide Paint warranty to a system where non-PPG products have been applied.
6. Please note the PPG PAINT PERFORMANCE GUARANTEE does not cover any film builds in excess of 300 microns total.
7. Where aluminum substrates are present, choose a body filler suitable for aluminum or use an acid etch primer such as DP612 EtchPRIME followed by Epoxy Urethane Primer.
8. Under no circumstances should polyester fillers be used directly over acid etch primers such as DP612 EtchPRIME (or F3963 Anti Corrosion Etch Primer) otherwise blistering and system failure will occur.

## Health and Safety

Please refer to Material Health and Safety Datasheets for full health and safety details.

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 inquiries 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/68°F. Film thickness, humidity and shop temperature can all affect drying times.



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