



**DELTRON®**



# Product Information

## DP618

*DP618 PrimaBUILD*

### PRODUCTS

|                    |                            |
|--------------------|----------------------------|
| Deltron PrimaBUILD | DP618                      |
| Deltron Hardeners  | DH710, DH720, DH730        |
| Deltron Thinners   | DT810, DT820, DT830, DT840 |
| For Flexibilising  | DA210 Flexibiliser         |

### Product Description

Deltron DP618 PrimaBUILD is a versatile, G3 shade high build 2K primer, suitable for use under any Deltron 2K topcoat or Deltron Basecoat.

It offers exceptional film build when used as a spray filler or primer surfacer.

PrimaBUILD may be applied over suitably prepared polyester putties, or over sound, fully cured, original paintwork, or adhesion primers. PrimaBUILD may also be flexibilised for use over plastic parts.

Options are available for air drying, conventional baking and Infra Red drying.

### PREPARATION OF SUBSTRATE

#### Substrate

Bare steel  
 Galvanised steel  
 Zintec  
 Aluminium and alloys  
 Electropaint  
 Aged painted surfaces  
 GRP , Fibre-Glass  
 Polyester filler  
 Featheredge of repair

#### Preparation

Must be pre-primed (eg DP612, DP614)  
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 Must be pre-primed (eg DP612)  
 P320-P400 (dry)/P400 -600(wet)  
 P320-P400 (dry)/P400-600 (wet)  
 P320 (dry)  
 P120-180 (high-build version)  
 P240 - 320 (dry)

#### Cleaning

Before and after any sanding operation, the substrate must be thoroughly degreased with D845 or D837.

# Application Guide

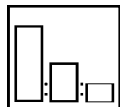
For use as a:

## Spray Filler mode

## Primer Surfacer mode

### Mixing Ratio

- RFU mixing available on Paint Manager



|          | By Volume |          | By Volume |  |
|----------|-----------|----------|-----------|--|
| DP618    | 4 vol     | DP618    | 4 vol     |  |
| Hardener | 1 vol     | Hardener | 1 vol     |  |
| Thinner  | 0.5 vol   | Thinner  | 1-1.5 vol |  |

- PrimaBUILD may be tinted by addition of up to 5% by volume of Deltron DG tinter or mixed DG colour prior to addition of hardener and thinner.
- PrimaBUILD may be flexibilised by adding 10-20% DA210 Flexibliser prior to addition of hardener and thinner.

### Hardener and Thinner Selection

#### Temperature

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

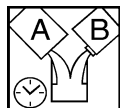
#### Hardener

DH710  
DH720  
DH730  
DH730

#### Thinner

DT810  
DT820  
DT830  
DT840

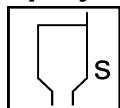
### Potlife at 20°C



1.5 - 2 hours

4 - 5 hours

### Spray Viscosity



30 - 40 secs DIN at 20°C

18 - 22 secs DIN at 20°C

### Spraygun Setup



Gravity  
Suction

1.8 - 2.2 mm  
1.8 - 2.2 mm

1.6 - 1.8 mm  
1.8 - 2.0 mm

### Spray Pressure

2-2.5 bar / 30-35 PSI

2-3 bar / 30-45 PSI

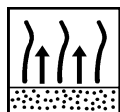
### Number of Coats



2 coats  
Up to a maximum of 3

2 coats  
Up to a maximum of 3

### Flash Off at 20°C



Between coats  
Before stoving

5–10 mins  
Bake immediately

5–10 mins  
Bake immediately

|  | <b>Spray Filler mode</b> | <b>Primer Surfacer mode</b> |
|--|--------------------------|-----------------------------|
|--|--------------------------|-----------------------------|

**Drying Times**



*Dust-free at 20°C*      15 mins  
*Through-dry at 20°C*      12 hours

15 mins  
5 hours



*Through-dry at 60°C*      30 mins

30 mins



*Through-dry with IR medium*      15-20 mins depending on IR unit

15-20 mins depending on IR unit

- *Note: Spray filler mode will require DT840 Slow thinner if IR Curing*
- *Baking time required once metal reaches the quoted temperature. Baking schedule should allow additional time for metal to reach this temperature*

**Technical Data**

**Total Dry Film Build**

|                |        |        |
|----------------|--------|--------|
| <i>Minimum</i> | 140 µm | 80 µm  |
| <i>Maximum</i> | 200 µm | 120 µm |

**Theoretical Coverage**

approx. 1.6-2.2 m<sup>2</sup> /L      approx. 2.5-4.0 m<sup>2</sup> /L

\* *Theoretical coverage in m<sup>2</sup>/L ready-to-spray, with a dry film thickness between indicated minimum and maximum values.*

**Flash Points**

|   |              |
|---|--------------|
| DH Hardeners, DT Thinners, DG tinter and mixed colour, D845, D837 | See PPG MSDS |
|   | See PPG MSDS |

**Sanding**



|                  |                             |
|------------------|-----------------------------|
| <i>Grade dry</i> | P240 followed by P400 - 500 |
| <i>Grade wet</i> | P400 followed by P600 - 800 |

|                             |
|-----------------------------|
| P240 followed by P400 - 500 |
| P400 followed by P600 - 800 |

**Overcoat with**

Any PPG Deltron topcoat.

## PAINTING OF FLEXIBLE SUBSTRATES - FLEXIBLE substrates are all plastic types except GRP

**Please note:** The positioning of plastic components on motor vehicles, i.e. bumpers, means they are more likely to be subjected to, bumps and knocks from outside sources, such as other motor vehicles, gutters, curbs, brick walls etc. PPG recommends flexibilising all plastics, particularly bumper bars, to improve impact resistance.

Additives are also required when applying over a flexible substrate (typically plastics). The additives required and the appropriate volume and weight mix ratios are indicated in the tables below and are also available on paint manager. In a repair situation PPG recommends that flexibilised 2K primers and polyester filler, be applied over the appropriate PPG plastic primer. (See substrate preparation section in PPG product manual)

**Note:** Keep primer film build to a minimum on plastic substrates. Apply Maximum 2 coats over D820 Plastic Adhesion Promoter

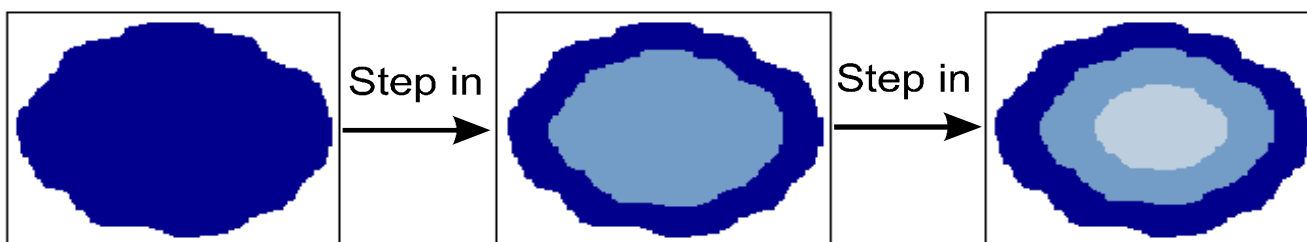
| Substrate | DP618 PrimaBUILD | DH7XX Hardener | DA210 Flexibilser |
|-----------|------------------|----------------|-------------------|
| Flexible  | 3 Parts          | 1 Part         | 1 Part            |

RFU Mix ratio available on Paint manager

### Performance Guidelines

When **spot priming** with DP618 PrimaBUILD as a Spray Filler / Primer Surfacer, adopt the following procedure:

1. Ensure that the surface is thoroughly sanded to the panel edge, breakline or to a distance 15 centimetres beyond the feathered edge area, whichever is the smaller.
2. Apply the first coat to the entire area to be primed then apply subsequent coats inside the previous coat allowing the correct flash-off times between coats. (This avoids building up an edge and trapping dry spray.)



3. Allow to dry as normal, and then be careful to thoroughly level the repair edge when sanding. Do not attempt spot repair on original or refinish TPA, lacquer or 1K finishes.
4. DT860 should not be used with this product.
5. DP618 PrimaBUILD and its ancillaries are sensitive to moisture, so all equipment must be perfectly dry. Where humidity is in the range 70–80%, use of DT840 Extra Slow Thinner is recommended. Do not attempt to use DP618 PrimaBUILD at humidity levels exceeding 80%.
6. To ensure maximum adhesion and impact resistance, DP618 PrimaBUILD must be coated within 72 hours of application. After this time it should be sanded and recoated with itself.

## EQUIPMENT CLEANING

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



### Health and Safety

**Please refer to Safety Data Sheets for full Health and Safety details before use.**



- Goggles must be worn when mixing and using to prevent accidental splashing into the eye. If contact occurs with eyes give prolonged irrigation with water and get medical attention immediately.
- Good ventilation and extraction must be provided in the working environment.
- Wear suitable protective equipment to prevent skin contact with this material.
- Do not smoke whilst using this material.
- Do not breathe vapours or overspray. In cases of insufficient ventilation, wear appropriate respiratory 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 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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