Chrome Free Self Etching Primer

DX1793 Chrome Free Self Etching Primer is specifically designed for commercial fleet refinishing. The product provides excellent adhesion and corrosion resistance when applied to properly prepared aluminum, galvanized steel and steel substrates. DX1793 offers a choice of three catalyst/reducers which optimize dry speed for shop conditions. DX1793 is easy to apply and quickly dries to a smooth, easy-to-see film.

<table>
<thead>
<tr>
<th>Features</th>
<th>Advantages</th>
<th>Benefits</th>
</tr>
</thead>
<tbody>
<tr>
<td>• Quick Dry Formula</td>
<td>• Faster Dry To Topcoat</td>
<td>• Better Productivity</td>
</tr>
<tr>
<td>• Adhesion To Most Substrates</td>
<td>• Fewer Products Needed</td>
<td>• Lower Inventory Costs</td>
</tr>
<tr>
<td>• Pigmented</td>
<td>• Easy To See</td>
<td>• Better Quality Jobs</td>
</tr>
</tbody>
</table>

Compatible Surfaces

DX1793 may be applied over:
• Properly prepared steel and aluminum
• Properly prepared stainless steel*
• Properly prepared galvanized metal*
• Properly prepared galvaneal*

* Sand these substrates prior to the application of other primers or topcoats using 180-240 grit wet or dry.

<table>
<thead>
<tr>
<th>Catalysts</th>
</tr>
</thead>
<tbody>
<tr>
<td>Catalyst for DX1793 (Fast)</td>
</tr>
<tr>
<td>Catalyst for DX1793 (Medium)</td>
</tr>
<tr>
<td>Catalyst for DX1793 (Slow)</td>
</tr>
</tbody>
</table>
Preparation:

• Wash the area to be painted with soap and water, then clean with DX436 or DX437 wax and grease remover. DX438 Low VOC Cleaner should be used in VOC restricted areas.
• Aluminum and steel substrates do not need to be sanded.
• Sand harder metal substrates, such as stainless steel or galvanized steel with 180-240 grit wet or dry.
• Re-clean with DX436, DX437, DX438.
PRIME ALUMINUM, STAINLESS AND CARBON STEEL IMMEDIATELY AFTER CLEANING.

Mixing Ratio:

DX1793 : DX1794, DX1795 or DX1796
1 part : 1 part
Use appropriate catalyst for shop temperature.

Pot life:

24 hours @ 70°F
(High heat and humidity will shorten pot life.)

Additives:

Accelerator: No Recommendation
Extender: No Recommendation
Fisheye: No Recommendation
Flex: No Recommendation

Spraygun set-up:

Fluid Tip
1.0 - 1.3 mm for Pressure Feed/HVLP
1.3 - 1.5 mm for Conventional Feed/HVLP

Air Pressure
HVLP at air cap 10 PSI
Conventional at spray gun 40-50 PSI

Consult the Fleet Training Manual Spray Equipment Section for gun set-up requirements.

Minimum number of coats:

1-2 medium coats

Total film build per coat:

<table>
<thead>
<tr>
<th></th>
<th>Wet</th>
<th>Dry</th>
</tr>
</thead>
<tbody>
<tr>
<td>Minimum</td>
<td>5.0 mils</td>
<td>.6 mils</td>
</tr>
<tr>
<td>Maximum</td>
<td>6.5 mils</td>
<td>.8 mils</td>
</tr>
</tbody>
</table>

Flash Time at 70°F:

Between coats 10-15 minutes
Drying times:

20 minutes minimum at 70°F for one coat
30 minutes minimum at 70°F for two coats
24 hours maximum

Note: After 24 hours, sand DX1793 with 400 grit (wet or dry) and reapply 1 coat of DX1793 before proceeding to the next undercoat or topcoat.

TEST PROPERTIES

<table>
<thead>
<tr>
<th>Property</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>VOC Packaged</td>
<td>5.2 lbs. per U.S. gal.</td>
</tr>
<tr>
<td>VOC RTS Applied</td>
<td>6.1 lbs. per U.S. gal.</td>
</tr>
<tr>
<td>Weight Solids (RTS)</td>
<td>22.4%</td>
</tr>
<tr>
<td>Volume Solids (RTS)</td>
<td>12.0%</td>
</tr>
<tr>
<td>Square Foot Coverage</td>
<td>241 sq. ft.</td>
</tr>
</tbody>
</table>

Compatible Topcoats:

- DPHSS2 Low VOC Primer
- DPU166 High Solids Chromate Primer (2.8 VOC)
- DPU174 High Solids Polyurethane Primer
- DELTA® (DSS) Medium Solids Polyurethane#
- DELTA® (DFHS) Fast Dry High Solids Polyurethane#
- DELTA® (DUHS) High Solids Polyurethane #
- DELTA® (DVHS) Fast Dry 2.8 VOC Polyurethane #
- DELTA® (DGHS) Chemical Resistant Polyurethane 3.5 VOC #
- DELTA® (DGHS) Chemical Resistant Polyurethane 4.4 VOC #
- DELTA® (DHS) 2.8 VOC Polyurethane#

# For optimum properties, DX1793 must be sealed with one of the listed undercoats before topcoating.
INSTRUCTIONS FOR USE

How to Mix: Mix DX1793

<table>
<thead>
<tr>
<th>DX1793</th>
<th>DX1794, 1795 or 1796</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>1</td>
</tr>
</tbody>
</table>

Pot life: 24 hours at 70°F

Air Pressure:

HVLP: 10 PSI at the air cap

Conventional: 40-50 PSI at the gun

Fluid tip: 1.0 - 1.3 mm for Pressure Feed/HVLP
           1.3 - 1.5 mm for Conventional Feed/HVLP

Application: Apply: 1-2 medium coats

Dry Time:

Between coats: 10-15 minutes

Air Dry @ 70°F
20 minutes for 1 coat
30 minutes for 2 coats
24 hours maximum

PRODUCTS NEEDED FOR JOB

For additional information, refer back to the complete FL300
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.

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

Emergency Medical or Spill Control Information (304) 843-1300; In Canada (514) 645-1320