DEP351 is a 3.5 Epoxy Primer designed for use in fleet applications requiring excellent adhesion and corrosion protection. The chrome and lead-free primer also has exceptional topcoat characteristics and re-coat times.

**Features**
- Direct to metal
- User Friendly
- High Solids

**Advantages**
- Corrosion Protection
- VOC Compliant

**Benefits**
- Excellent Adhesion
- Increased Productivity
- Reduced Inventory

**Compatible Surfaces**
Delta® DEP351 may be applied over:
- Cured and sanded OEM finishes
- Properly cleaned and sanded fiberglass
- Properly cleaned and sanded: steel, aluminum and stainless
- Properly cleaned and sanded Galvanized and Galvaneal steel
- DPS306 2K Primer Sufacer
- DPHS52 Low VOC Primer
- DPU166 High Solids Chromate Primer 2.8 VOC Max.
- DPU174 High Solids Polyurethane Primer (Chrome-Free)
- DPU217 2.1 VOC Polyurethane

**Catalyst**
Epoxy Primer Catalyst DEP352
**Application Guide**

**Preparation:**
- Wash the area to be painted with soap and water, and then clean with DX436 or DX437 wax and grease remover. DX438 Low VOC Cleaner should be used in VOC restricted areas.
- All metal substrates need to be sanded with 80-180 grit wet or dry. Re-clean with DX436, DX437 or DX438.
- Prime aluminum, stainless and carbon steel immediately after cleaning.
- Sand old finishes with 240-280 grit wet or dry.

**Mixing Ratio:**

<table>
<thead>
<tr>
<th>DEP351</th>
<th>DEP352</th>
</tr>
</thead>
<tbody>
<tr>
<td>2 parts</td>
<td>1 part</td>
</tr>
</tbody>
</table>

The addition of 10 - 20% Acetone or DES1570 Exempt Solvent Blend should be used for sealer applications.

**Pot life:**

4 hours @ 70°F and 50% RH (High heat and humidity will shorten pot life)

**Additives:**

Not Recommended

**Spraygun set-up:**

**Fluid Tip:**
- 1.2 - 1.4 mm Pressure Feed/HVLP
- 1.4 - 1.6 mm Conventional Feed/HVLP

**Air Pressure:**
- HVLP at air cap 10 PSI
- Conventional at spray gun 55 - 65 PSI

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

**Number of coats:**

1 - 2 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>2 mils</td>
<td>1 mils</td>
</tr>
<tr>
<td>Maximum</td>
<td>4 mils</td>
<td>2 mils</td>
</tr>
</tbody>
</table>
Flash Time at 70°F (21°C):

Between coats

5 minutes

Drying times:

<table>
<thead>
<tr>
<th></th>
<th>Air Dry @ 70°F</th>
<th>Force Dry**</th>
</tr>
</thead>
<tbody>
<tr>
<td>Dust:</td>
<td>20 minutes</td>
<td>Flash 10 minutes</td>
</tr>
<tr>
<td>Tack:</td>
<td>3 hours</td>
<td>20 minutes @ 130°F</td>
</tr>
<tr>
<td>Tape:</td>
<td>4 hours</td>
<td>10 minutes @ 160°F</td>
</tr>
<tr>
<td>Dry to Topcoat:</td>
<td>60 minutes</td>
<td></td>
</tr>
</tbody>
</table>

Note: After 2 weeks, DEP351 must be sanded before additional primer or topcoat can be applied.

**Force drying times are for quoted surface temperature. Additional time should be allowed in the force-drying schedule to allow surface to reach recommended temperature.

Test Properties:

<table>
<thead>
<tr>
<th></th>
<th>Color</th>
<th>Gray</th>
</tr>
</thead>
<tbody>
<tr>
<td>VOC DEP351 Packaged</td>
<td>3.3 lbs. per U.S. gal.</td>
<td></td>
</tr>
<tr>
<td>VOC DEP352 Packaged</td>
<td>4.0 lbs. per U.S. gal.</td>
<td></td>
</tr>
<tr>
<td>VOC RTS Applied</td>
<td>3.5 lbs. per U.S. gal.</td>
<td></td>
</tr>
<tr>
<td>Volume Solids (RTS)</td>
<td>49.5%</td>
<td></td>
</tr>
<tr>
<td>Square Foot Coverage</td>
<td>990 sq. ft.</td>
<td></td>
</tr>
</tbody>
</table>

(RTS US Gallon 100% Transfer Efficiency)

Compatible Topcoats:

- DPHS52 Low VOC Primer
- DPU166 High Solids Chromate Primer (2.8 VOC)
- DPU174 High Solids Polyurethane Primer
- DPU217 DELTA® 2.1 VOC Polyurethane Primer
- DPS306 DELTA® 2K Primer Surfacer
- DELTA® (DFHS) Fast Dry High Solids Polyurethane
- DELTA® (DUHS) High Solids Polyurethane
- DELTA® (DVHS) Fast Dry 2.8 VOC Polyurethane
- DELTA® (DGHS) Chemical Resistant 3.5 VOC
- DELTA® (DGHS) Chemical Resistant 4.4 VOC
- DELTA® (DSS) Medium Solids Polyurethane
- DELTA® (DHS) 2.8 VOC Polyurethane

Health and Safety

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
Delta® DEP351

3.5 Epoxy Primer

Instant Reference

How to Mix:

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Blend should be used for sealer applications.

Pot life:

Pot life @ 70°F and 50% RH: 4 hours
(High heat and humidity will shorten pot life)

Gun set-up:

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<th>HVLP:</th>
<th>10 PSI at the air cap</th>
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<tr>
<td>Conventional:</td>
<td>55 - 65 PSI at the gun</td>
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Fluid Tip: 1.2 - 1.4 mm for Pressure Feed/HVLP
1.4 - 1.6 mm for Conventional Feed/HVLP

Application:

<table>
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<tr>
<th>Apply:</th>
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<td>Between Coats:</td>
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Film build per coat:

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Additional time should be allowed in the force-drying schedule to allow surface to reach recommended temperature.

For additional information, refer back to the complete FL305 bulletin.

EMERGENCY MEDICAL OR SPILL CONTROL INFORMATION (304) 843-1300. IN CANADA (514) 645-1320.
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