Corrosion Resistant Primers

NCP270 Red
NCP271 Gray

NCP270 & 271 are premium-quality, corrosion–resistant primers developed for today’s advanced technology finishes such as the DELTRON® and CONCEPT® topcoat systems. Featuring a 3.5 VOC, these primers are free of chrome, lead and isocyanates.

NCP270 & 271 offer superior sanding characteristics and excellent gloss holdout. They can be used over sanded original finishes and properly prepared, clean bare metal.

NCP270/271 must be mixed with NCX275 catalyst. NCP270/271 may be used as a non-sanding primer. To obtain optimum application characteristics the addition of a DT reducer is required.

Compatible Surfaces

NCP270 and 271 may be applied over:
- Properly cleaned and sanded fiberglass
- Properly cleaned and sanded E-Coat
- Cured and sanded OEM finishes
- Properly prepared and treated bare steel and aluminum
- Properly cleaned, sanded and treated galvanized steel
- DELTRON® plastic adhesion promoter or etch primer*
- DELTRON® 2K primer surfacer*
- DP Epoxy Primer LF*

* Prime complete panels or extend NCT Primer Surfacer application well beyond the first primer (or exposed substrate) and maintain a minimum dry film of 2.0 mils after sanding. Insufficient NCT Primer Surfacer films may result in lifting on color applications.

Features
- User friendly
- Hi solids/Low VOC
- Can be used as primer or primer sealer

Advantages
- Quick dry time
- Easy mixing & sanding
- Complies with VOC regulations

Benefits
- Increase productivity
- Labor savings
- Meets future VOC requirements
- Reduced inventory
- Direct to topcoat
- Excellent gloss holdout

Required Products

<table>
<thead>
<tr>
<th>Hardeners</th>
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<tbody>
<tr>
<td>NCX275</td>
</tr>
</tbody>
</table>
**Directions for Use**

**Surface Preparation:**

NCP270/271 Corrosion Resistant Primers

- Wash the area to be painted with soap and water, then clean with appropriate PPG Cleaner.
- 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. Exposed bare metal should be spot primed with a suitable bare metal primer.
- Re-clean with the appropriate PPG cleaner.
- Two step metal treatments or the use of a wash primer coating will improve the adhesion and performance properties of the finished system.
- A two step metal treatment or wash primer is required over sanded clean galvanized steel substrate.
- Prime aluminum within 8 hours. **Prime carbon steel immediately after cleaning.**

**Mix Ratio:**

<table>
<thead>
<tr>
<th>NCP270 or NCP271</th>
<th>DT Reducer</th>
<th>NCX275</th>
</tr>
</thead>
<tbody>
<tr>
<td>3 : 0 – 1/2 : 1</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

A half part reducer may be added to modify application characteristics particularly for non-sanding primer uses.

**Note:** Shake or stir thoroughly before mixing to ensure proper performance.

Pot Life is 1 hour at 70°F (21°C).

**Spraygun Set-up:**

- Apply: 1 wet coat as non-sanding primer
  
  2 – 4 wet coats as surferc

- Fluid Tip: 1.4 – 1.6 mm or equivalent

- Air Pressure: 10 PSI at the cap for HVLP
  
  45 – 50 PSI at the gun for conventional gun

**Dry Times:**

<table>
<thead>
<tr>
<th>Between Coats:</th>
<th>Allow 5 – 10 minutes dry between coats</th>
</tr>
</thead>
</table>

**Recommended Dry Film Build:**

<table>
<thead>
<tr>
<th>Surfacer (After sanding)</th>
<th>2.0 – 6.0 mils</th>
</tr>
</thead>
<tbody>
<tr>
<td>Non-sanding Primer</td>
<td>1.5 – 1.8 mils</td>
</tr>
</tbody>
</table>

**Dry to Topcoat:**

| 30 minutes at 70°F (21°C) for 1 coat non-sanding primer application |

**Dry to Sand:**

- 1 – 2 hours at 70°F (21°C)

**Purge Time:**

- 10 minutes at 70°F (21°C)

**Force Dry:**

- 20 – 30 minutes at 140°F (60°C)

**IR (Infrared):**

- 20 minutes for Medium Wave
  
  10 minutes for Short Wave

**Dust Free Time:**

- 20 minutes

**Note:** NCP270/271 must be sanded prior to topcoat application if allowed to dry more than 8 hours.
Directions for Use

Compatible Topcoats:

- CONCEPT® (DCC) Acrylic Urethane
- CONCEPT® LV (CLV) Acrylic Urethane Color
- DAS302x V-Seal™ Acrylic Urethane Sealer
- DPLF Epoxy Primer
- DELSTAR® / DELTHANE® (DAR/DXR80) Polyurethane
- DELTRON® 2000 (DBC) Basecoat*
- DELTRON® (DBU) Universal Basecoat
- DPS305x V-Prime™ Acrylic Urethane Surfacer*
- DX54 ROADGUARD® Chip Resistant Coating
- K36 PRIMA™ Acrylic Urethane Wet-on-Wet Sealer†
- K93 Tintable Primer (as a sealer)†
- NCS2000 Series Sealers†
- NCS1990 Compliant Wet-On-Wet Sealer†
- SX1056 Flexible 2K Sealer (Specialty Performance Products)

*Must be sealed before applying black DBC
†NCP270/271 must be sanded before topcoat

Equipment Cleaning:

Spray guns, gun cups, storage pots, etc. should be cleaned thoroughly after each use with DX590 All Purpose Clean-up Solvent, or DTL DURACRYL® Lacquer Thinners.

*Technical Data:

<table>
<thead>
<tr>
<th></th>
<th>3 : 1</th>
<th>3 : 1/2 : 1</th>
</tr>
</thead>
<tbody>
<tr>
<td>VOC (Ready to Spray)</td>
<td>3.5 lbs./U.S. Gallon</td>
<td>3.9 lbs./U.S. Gallon</td>
</tr>
<tr>
<td>Total Solids by Weight (RTS)</td>
<td>72.8 %</td>
<td>67.7 %</td>
</tr>
<tr>
<td>Total Solids by Volume (RTS)</td>
<td>54.2 %</td>
<td>48.1 %</td>
</tr>
<tr>
<td>Sq. Ft. Coverage/U.S. Gallon (1 mil 100% transfer efficiency)</td>
<td>868</td>
<td>772</td>
</tr>
<tr>
<td>Recommended wet film build per coat</td>
<td>3.5</td>
<td>3.0</td>
</tr>
<tr>
<td>Recommended dry film build per coat</td>
<td>2.0 – 2.5</td>
<td>1.5 – 1.8</td>
</tr>
</tbody>
</table>

* These are typical values. Depending on the tint chosen, the calculated values can vary.
Important:

The contents of this package may have to 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.

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

EMERGENCY MEDICAL OR SPILL CONTROL INFORMATION (412) 434-4515; IN CANADA (514) 645-1320

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